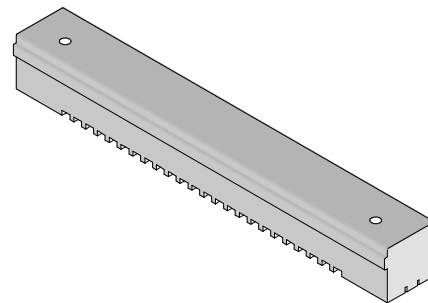




Plateau HS Dock™
Application Tooling Specification
Press-In Tool
Order No. 62202-0232



FEATURES

- Tool provides uniform distribution of press force across entire pin array.
- May be used as a stand-alone tool or mounted in an optional holder with other Molex press-in tools.

SCOPE

Products: Plateau HS Dock™ Interposer Assembly, 75126 series Assemblies (144 Circuits). See Product List below for specific part numbers.

Product List

The following is a partial list of the product order numbers and their specifications this tool is designed to run. Updates to this list are available on www.molex.com.

Series No.	Assembly Order Number	
75126	75126-1003	75126-2001

Tool Setup

This tool is designed to press a 144 circuit HS Dock™ Interposer Assembly onto a Printed Circuit Board. This tool can be used alone or with a 62201-95XX rail (ordered separately). See Figure 1.

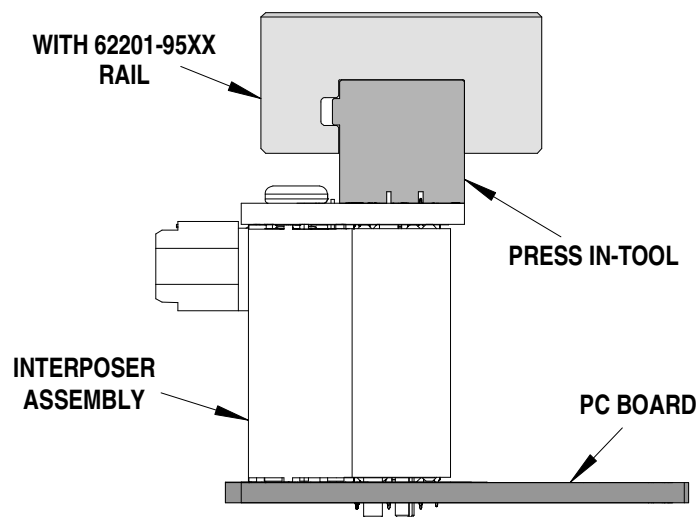


Figure 1

Tool Installation

The 62201-95XX rail is available in a variety of lengths to accommodate multiple press-in tools.

Rail Part Number	Rail Overall Length
62201-9501	24mm (0.94 in)
62201-9502	72mm (2.83 in)
62201-9503	156mm (6.14 in)
62201-9504	216mm (8.50 in)
62201-9509	254mm (10.0 in)
62201-9511	305mm (12.0 in)

Reference: The 62202-0232- Press-In Tool is 110.0mm (4.33 in.) long.

Printed Circuit Board (PCB) Support

The HS Dock™ Interposer Assembly connector requires a specific minimum force per pin to press into the PCB. To prevent excessive PCB flexure and/or damage to the PCB, a support plate is strongly recommended directly beneath the connector hole pattern.

Due to the custom nature of every application, Molex does not offer any PCB support plate. The customer must furnish their own support plate.

When creating the PCB support plate, remember to allow clearance for the connector pins as they pass through the PCB thickness.

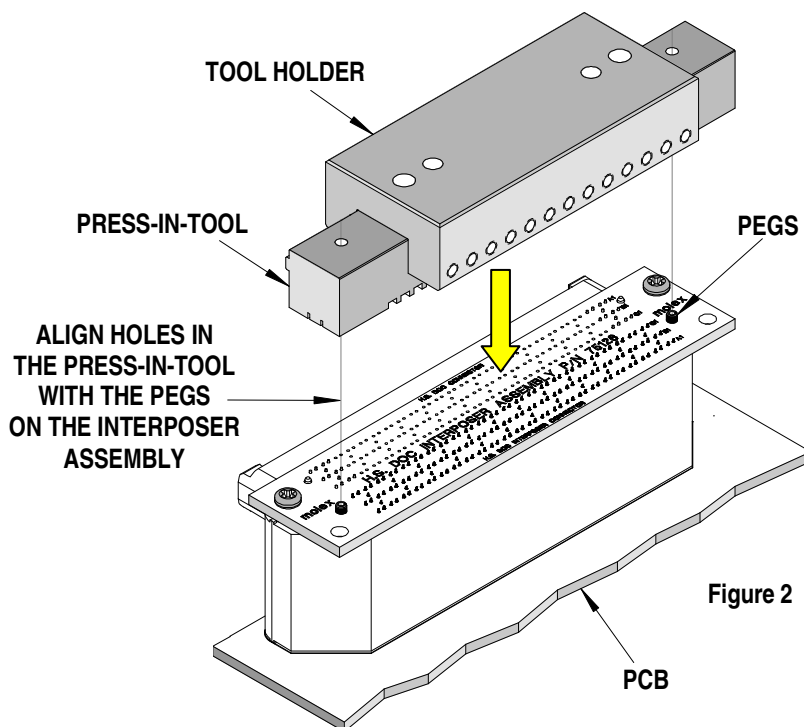
Press Equipment Recommendations

Many types of presses can be used to install the HS Dock™ Interposer Assembly, but to assure consistent connector installation Molex recommends the following press criteria:

1. The capability to detect force variations as low as 4.5kg (10 lb) during the press-in cycle; excessive force measurements should stop the press-in cycle.
2. The rate of pressing can be regulated as low as 0.13mm (0.005 in) per second.
3. Press stroke control to within 0.25mm (0.010 in).
4. Total press stroke must be at least 19mm (0.75 in).
5. For statistical purposes, automatic collection of force and distance data.

Tool Operation

1. Carefully insert, by hand, the Interposer Assembly into the printed circuit board hole pattern.
2. The Press-In-Tool is then located on the assembly by aligning the pilot holes in the press-in-tool with the pegs that protrude through the upper circuit board on the interposer assembly. See Figure 2.
3. Using the press-in-tool and an appropriate press, seat the Interposer Assembly until there is less than 0.25mm (0.01 in) clearance between the bottom of the plastic housing and the surface of the printed circuit board.
4. A support fixture, placed below the printed circuit board, is highly recommended due to the high forces required to press in the interposer assembly. This support would require clearance holes for protruding pins if the board thickness is less than the pin length. A press stop to control the insertion stroke is also recommended.



CAUTION: To prevent injury, never operate any press without the guards in place. Refer to the press manufacturer's instruction manual.

CAUTION: Molex application tooling specifications are valid only when used with Molex connectors and tooling.

Contact Information

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