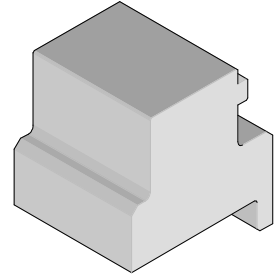




**I-Trac™ Daughtercard Module Installation  
Application Tooling Specification  
Press-In Tool  
Order No. 62201-8618**



## FEATURES

- Lip provided for positive alignment to connector assembly.
- 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: I-Trac™ Daughtercard Signal Module Assembly, 75710 Series 8 Column Assemblies. 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](http://www.molex.com).

75710 Series Numbers					
Guide Style	Columns	Assembly Order Number			
Open	8	75710-0008	75710-1008		
Guide Left	8	75710-2008	75710-2108	75710-2208	75710-2308
		75710-2408	75710-2508	75710-2608	75710-2708
		75710-2808			
		75710-3008	75710-3108	75710-3208	75710-3308
		75710-3408	75710-3508	75710-3608	75710-3708
		75710-3808			
Guide Right	8	75710-4008	75710-4108	75710-4208	75710-4308
		75710-4408	75710-4508	75710-4608	75710-4708
		75710-4808			
		75710-5008	75710-5108	75710-5208	75710-5308
		75710-5408	75710-5508	75710-5608	75710-5708
		75710-5808			

75910 Series Numbers							
Guide Style	Columns	Assembly Order Number					
Open	6	75910-0603	75910-0605	75910-0606	75910-1603	75910-1605	75910-1606
Left End Wall	6	75910-0613	75910-0615	75910-0616	75910-1613	75910-1615	75910-1616
Right End Wall	6	75910-0623	75910-0625	75910-0626	75910-1623	75910-1625	75910-1626
Dual End Wall	6	75910-0633	75910-0635	75910-0636	75910-1633	75910-1635	75910-1636
Guide Left	6	75910-2623	75910-2625	75910-2626	75910-2633	75910-2635	75910-2636
		75910-3623	75910-3625	75910-3626	75910-3633	75910-3635	75910-3636
		75910-6623	75910-6625	75910-6626	75910-6633	75910-6635	75910-6636
		75910-7623	75910-7625	75910-7626	75910-7633	75910-7635	75910-7636
Guide Right	6	75910-4623	75910-4625	75910-4626	75910-4633	75910-4635	75910-4636
		75910-5623	75910-5625	75910-5626	75910-5633	75910-5635	75910-5636
		75910-8623	75910-8625	75910-8626	75910-8633	75910-8635	75910-8636
		75910-9623	75910-9625	75910-9626	75910-9633	75910-9635	75910-9636

## Tool Setup

Depending on the number of connectors to be installed and/or the press used, this tool can be used alone or with a group of press-in tools, mounted in a 62201-95XX rail (ordered separately). See Figure 1.

## Tool Installation

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

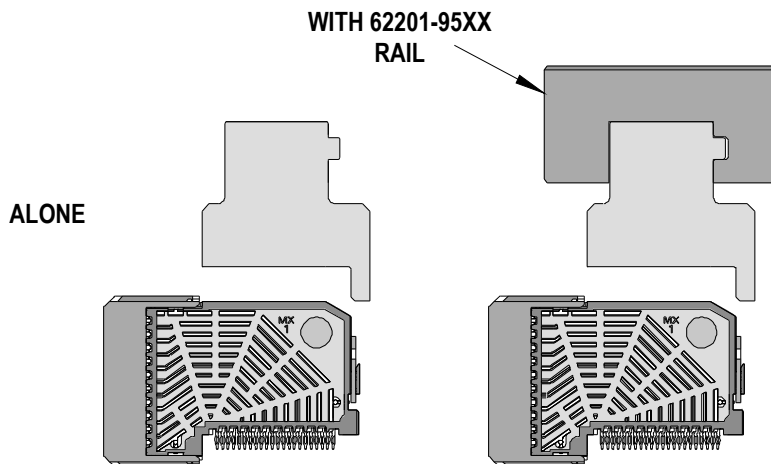


Figure 1

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: This Press-In Tool is 29.5mm (1.16 in.) long.

## Printed Circuit Board (PCB) Support

The I-Trac™ connectors require up to 1.81kg (4 lb) of 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.

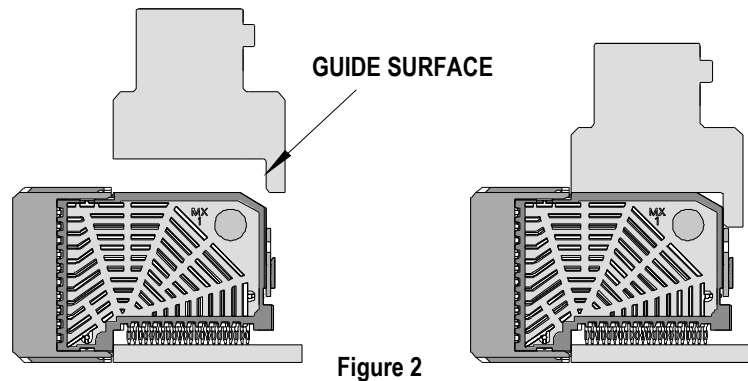
## Press Equipment Recommendations

Many types of presses can be used to install I-Trac™ connectors, but to assure consistent connector installation Molex recommends the following press criteria:

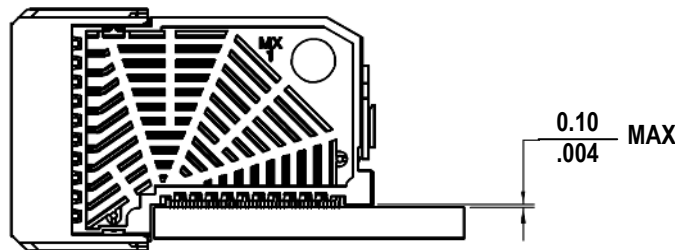
1. The capability to detect force variations as low as 4.5kg (10 lb) during the press-in cycle; excessive force measurements should stop the press-in cycle.
2. The rate of pressing can be regulated as low as 0.13mm (0.005 in) per second.
3. Press stroke control to within 0.25mm (0.010 in).
4. Total press 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 Daughtercard module(s) into the PCB hole pattern.
2. Place the application tool on top of the Daughtercard module with the back guide surface of the tool against the back of the Daughtercard module. See Figure 2.



3. Using the application tool and an appropriate press, seat the Daughtercard module until there is less than 0.10mm (.004 in) clearance between the bottom of the plastic housing and the surface of the PCB. See Figure 3.



There should be no broken stand-offs along the perimeter of the part (an indication of over-pressing).

**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

For more information on Molex application tooling please contact Molex at 1-800-786-6539.

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