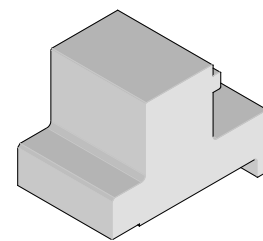


**Impel
Daughtercard
Module Installation
Press-In Tool**



**Application Tooling
Specification Sheet**



Order No. 62201-8960

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: Impel 1.9mm Pitch DaughterCard and Right Angle Male (RAM) Assembly (6-Pair by 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.

Series No.	Guide Style	Columns	Assembly Order Number					
171400	Unguided	8	171400-1038					
	Left	8	171400-3038	171400-3138	171400-3238	171400-3338	171400-3438	171400-3538
			171400-3638	171400-3738	171400-3838			
	Right	8	171400-5038	171400-5138	171400-5238	171400-5338	171400-5438	171400-5538
			171400-5638	171400-5738	171400-5838			
	172130	Unguided	8	172130-1807	172130-1808			
Left		172130-5807		172130-5808	172130-5817	172130-5818	172130-5827	172130-5828
		172130-5837		172130-5838	172130-5847	172130-5848	172130-5857	172130-5858
		172130-5867		172130-5868	172130-5877	172130-5878	172130-5887	172130-5888
Right		172130-5807		172130-5808	172130-5817	172130-5818	172130-5827	172130-5828
		172130-5837		172130-5838	172130-5847	172130-5848	172130-5857	172130-5858
		172130-5867		172130-5868	172130-5877	172130-5878	172130-5887	172130-5888

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.

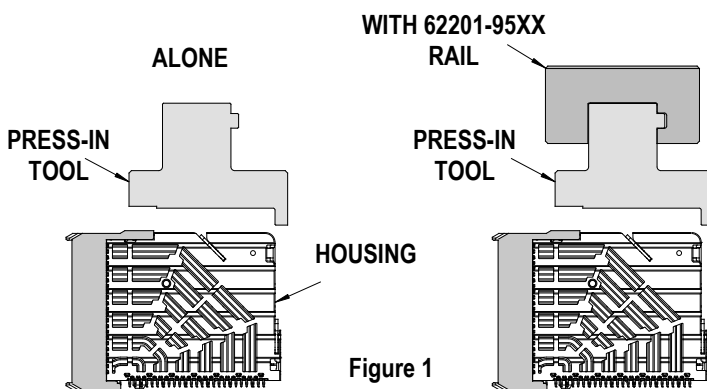


Figure 1

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: This Press-In Tool is 15mm (0.59 in.) long.

Printed Circuit Board (PCB) Support

The Impel connectors require up to 3.6kg (8 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.

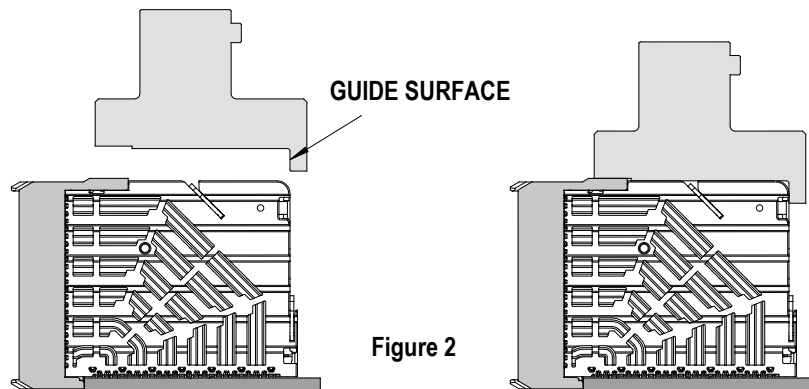
Press Equipment Recommendations

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

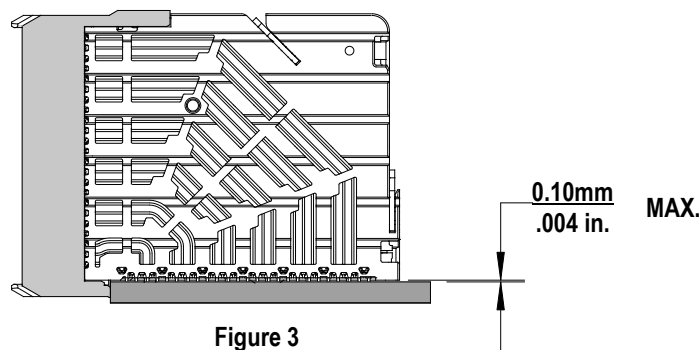
1. The capability to detect force variations as low as 4.5kg (10 lb) during the press-in cycle; excessive force measurements should stop the press-in cycle.
2. The rate of pressing can be regulated as low as 0.13mm (0.005 in) per second.
3. Press stroke control to within 0.25mm (0.010 in).
4. Total press 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.

Visit our Web site at <http://www.molex.com>