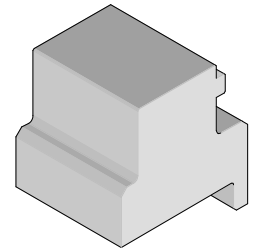




I-Trac™ Daughtercard Module and RAM Installation Application Tooling Specification Press-In Tool Order No. 62201-8612



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, 76020 Series 10 Column Assemblies, and I-Trac™ RAM, 76011 Series 10 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.

76020 Series Numbers							
Guide Style	Columns	Assembly Order Number					
Open	10	76020-0010	76020-1010	76020-0910	76020-1910		
Guide Left	10	76020-2010	76020-2110	76020-2210	76020-2310	76020-2410	76020-2510
		76020-2610	76020-2710	76020-2810	76020-3010	76020-3110	76020-3210
		76020-3310	76020-3410	76020-3510	76020-3610	76020-3710	76020-3810
Guide Right	10	76020-4010	76020-4110	76020-4210	76020-4310	76020-4410	76020-4510
		76020-4610	76020-4710	76020-4810	76020-5010	76020-5110	76020-5210
		76020-5310	76020-5410	76020-5510	76020-5610	76020-5710	76020-5810
Guide Left (ESD)	10	76020-2050	76020-2150	76020-2250	76020-2350	76020-2450	76020-2550
		76020-2650	76020-2750	76020-2850	76020-3050	76020-3150	76020-3250
		76020-3350	76020-3450	76020-3550	76020-3650	76020-3750	76020-3850
Guide Right (ESD)	10	76020-4050	76020-4150	76020-4250	76020-4350	76020-4450	76020-4550
		76020-4650	76020-4750	76020-4850	76020-5050	76020-5150	76020-5250
		76020-5350	76020-5450	76020-5550	76020-5650	76020-5750	76020-5850

76011 Series Numbers							
Guide Style	Columns	Assembly Order Number					
Open	10	76011-0103	76011-0105	76011-0106	76011-1103	76011-1105	76011-1106
Left End Wall	10	76011-0113	76011-0115	76011-0116	76011-1113	76011-1115	76011-1116
Right End Wall	10	76011-0123	76011-0125	76011-0126	76011-1123	76011-1125	76011-1126
Dual End Wall	10	76011-0133	76011-0135	76011-0136	76011-1133	76011-1135	76011-1136
Guide Left	10	76011-2123	76011-2125	76011-2126	76011-2133	76011-2135	76011-2136
		76011-3123	76011-3125	76011-3126	76011-3133	76011-3135	76011-3136
		76011-6123	76011-6125	76011-6126	76011-6133	76011-6135	76011-6136
		76011-7123	76011-7125	76011-7126	76011-7133	76011-7135	76011-7136
Guide Right	10	76011-4123	76011-4125	76011-4126	76011-4133	76011-4135	76011-4136
		76011-5123	76011-5125	76011-5126	76011-5133	76011-5135	76011-5136
		76011-8123	76011-8125	76011-8126	76011-8133	76011-8135	76011-8136
		76011-9123	76011-9125	76011-9126	76011-9133	76011-9135	76011-9136

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.

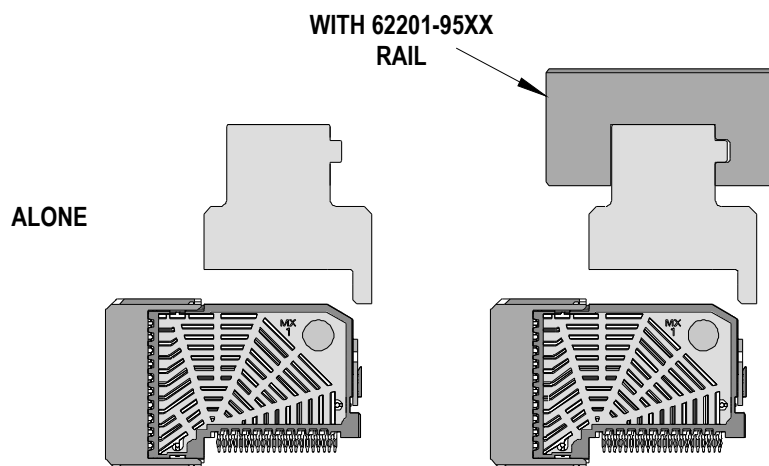


Figure 1

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 36.9mm (14.53 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 and / or RAM module(s) into the PCB hole pattern.
2. Place the application tool on top of the module with the back guide surface of the tool against the back of the module. See Figure 2.

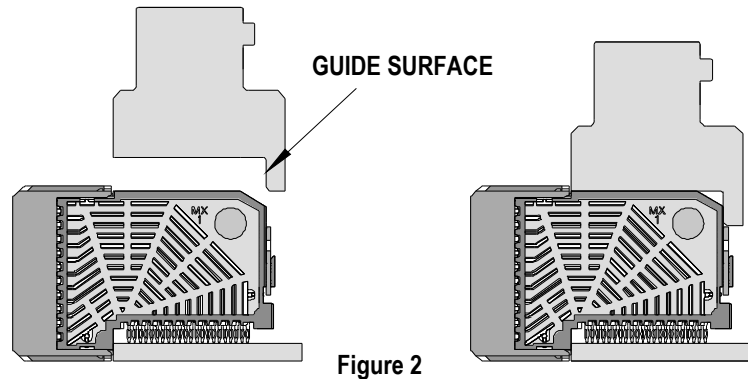


Figure 2

3. Using the application tool and an appropriate press, seat the 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.

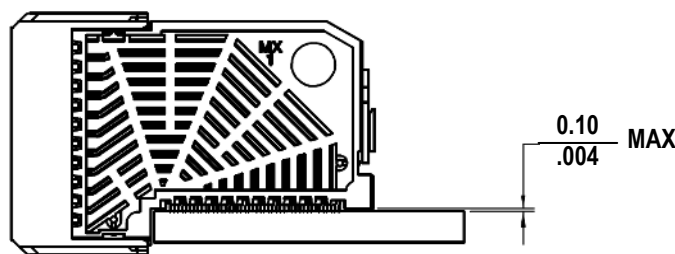


Figure 3
(Daughtercard shown; same dimensions for RAM)

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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