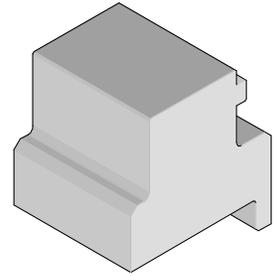




**I-Trac™ Daughtercard Module Installation
Application Tooling Specification
Press-In Tool
Order No. 62201-8610**



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 4 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	4	76020-0004	76020-1004	76020-0904	76020-1904		
Guide Left	4	76020-2004	76020-2104	76020-2204	76020-2304	76020-2404	76020-2504
		76020-2604	76020-2704	76020-2804	76020-3004	76020-3104	76020-3204
		76020-3304	76020-3404	76020-3504	76020-3604	76020-3704	76020-3804
Guide Right	4	76020-4004	76020-4104	76020-4204	76020-4304	76020-4404	76020-4504
		76020-4604	76020-4704	76020-4804	76020-5004	76020-5104	76020-5204
		76020-5304	76020-5404	76020-5504	76020-5604	76020-5704	76020-5804
Guide Left (ESD)	4	76020-2054	76020-2154	76020-2254	76020-2354	76020-2454	76020-2554
		76020-2654	76020-2754	76020-2854	76020-3054	76020-3154	76020-3254
		76020-3354	76020-3454	76020-3554	76020-3654	76020-3754	76020-3854
Guide Right (ESD)	4	76020-4054	76020-4154	76020-4254	76020-4354	76020-4454	76020-4554
		76020-4654	76020-4754	76020-4854	76020-5054	76020-5154	76020-5254
		76020-5354	76020-5454	76020-5554	76020-5654	76020-5754	76020-5854

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.

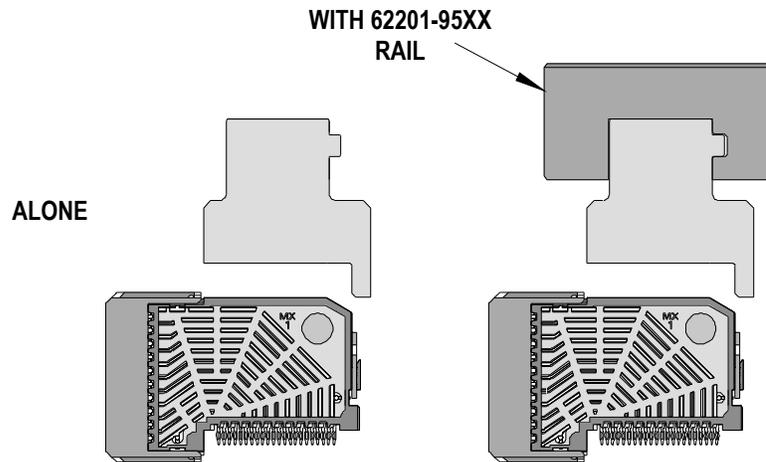


Figure 1

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 14.9mm (0.59 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.

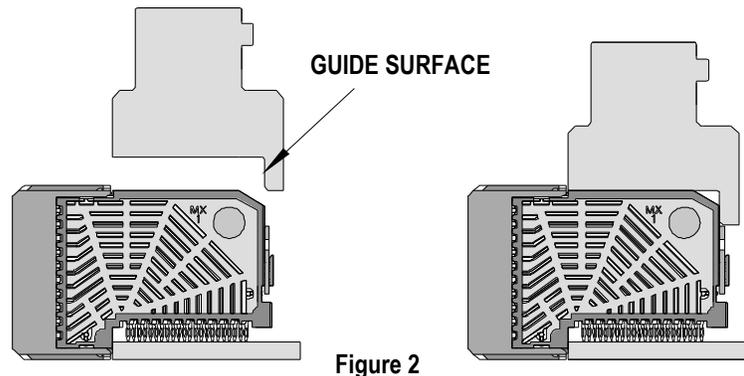


Figure 2

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.

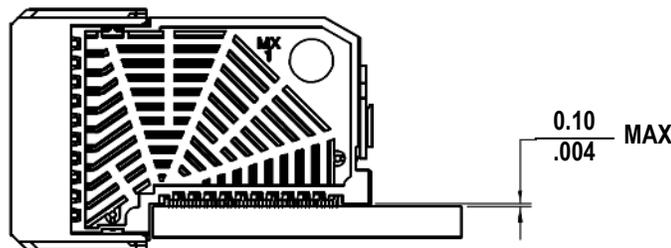


Figure 3

(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

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