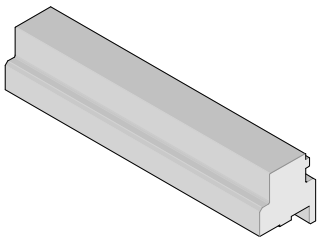
HS Dock™ Receptacle Press-In Tool

Application Tooling Specification Sheet



Order No. 62202-0222

FEATURES

- Designed to provide proper support to receptacle connectors during press-in operation
- This tool module may be used to press in (1) one connector or is stackable in a Molex tool holder system to press in multiple connectors at one time
- May be used as a stand-alone tool or mounted in an optional tooling holder with other Molex press-in tools.

SCOPE

Products: 1.20mm by 3.50mm Pitch HS Dock+ and Plateau HS Dock™ Receptacle, Right Angle, 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.	Circuit Size	Assembly Order Number					
75019	144	75019-0015	75019-0016	75019-0306	75019-7024	75019-7215	75019-7216
		75019-7315	75019-7316				
74149	144	74149-1001	74149-1101	74149-3001	74149-3101		

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.

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)

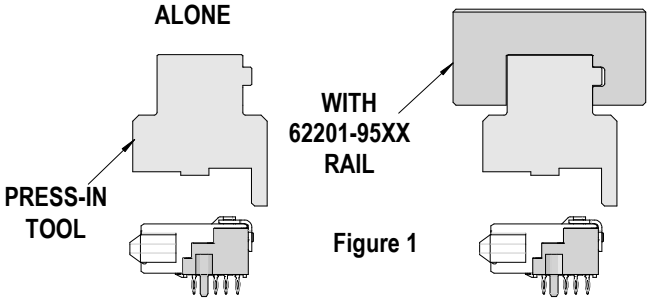


Figure 1

Reference: This Press-In Tool is 100.0mm (3.94 in.) long.

Printed Circuit Board (PCB) Support

The HS Dock™ connectors require a significant amount 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 HS Dock™ 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 lbs.) 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 connector assembly into the PCB hole pattern.
2. Place the press-in tool on top of the connector assembly with the back guide surface of the tool against the back of the connector assembly. See Figure 2.

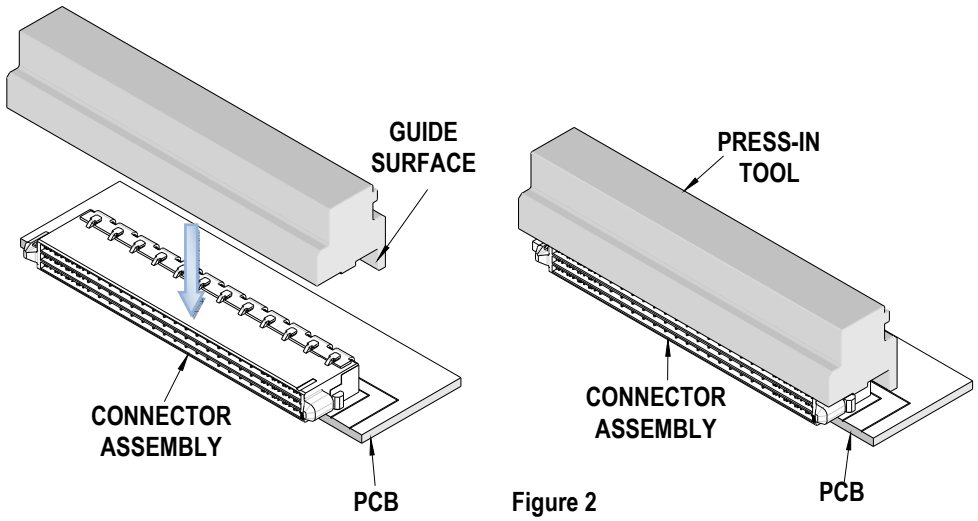


Figure 2

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

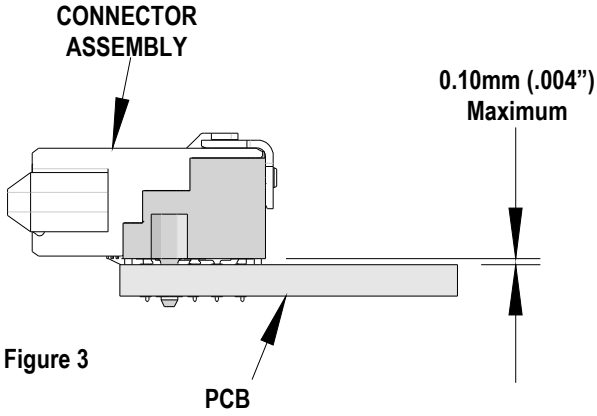


Figure 3

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