

<b>Power Module Insertion Tool</b>		
	<b>Application Tooling Specification Sheet</b>	

**FEATURES**

- This tool is used for the installation of the HDM® Power Module into a printed circuit board.
- Standalone tool; does NOT use the standard Molex tooling rail.
- For standard HDM® Power Modules, use tool 62200-5711

**SCOPE**

Products: \*HDM® Backplane Power Module (Custom Loaded). See Product List below for specific part numbers. \*HDM® is a registered trademark of Teradyne, Inc.

**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).

Connector Series Number	Style	Assembly Order Number		
73656	Custom Loaded	73656-0190	73656-5000	73656-5001

**DESCRIPTION**

The Power Module Insertion Tool is used with a suitable press to install the Backplane Power Module into a printed circuit board.

The tool measures 38mm (1.5 in.) long by 25mm (0.98 in.) wide by 49mm (1.93 in.) high and weighs about 110g (4 oz.). See Figure 1.

**Printed Circuit Board (PCB) Support**

The HDM® Power Module requires up to 13kg (30 lbs) of force per pin to press into the PCB. To prevent flexing or damage to the PCB, a support plate is strongly recommended directly beneath the connector terminal hole pattern.

Due to the custom nature of every application, a board support is required for proper tool application. This can be supplied by the customer or by Molex. For more information contact Molex Application Tooling.

When creating a PCB support plate, allow clearance for connector terminal pins that pass through the PCB.

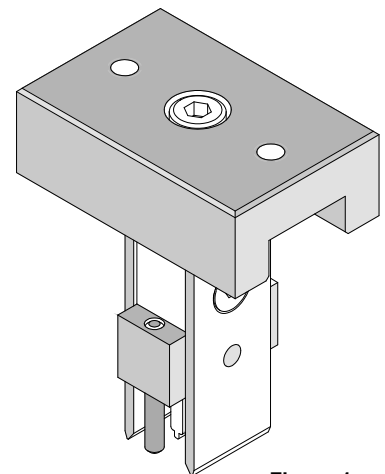


Figure 1

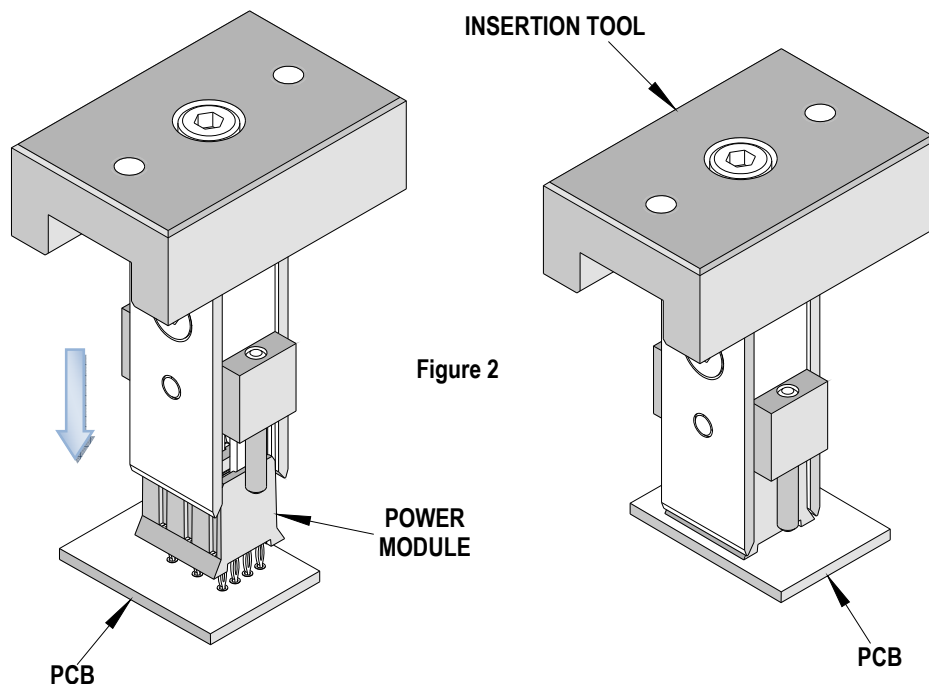
## Press Equipment Recommendations

Many types of presses can be used to install the HDM® Power Module, 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 Power Module into the PCB hole pattern. Make sure the connector is oriented properly to the PCB layout.
2. Line-up the insertion tool so the tool fits inside the power header. See Figure 2.
3. Using the application tool and an appropriate press, press in the Power Module until the stand-offs just touch the surface of the PCB. See Figure 2.



<http://www.molex.com>