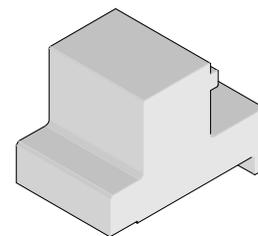




**Impel
Daughtercard
Module Installation
Press-In Tool**

**Application Tooling
Specification Sheet**



Order No. 62201-8919

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 Assembly and RAM Assembly (6-Pair by 10 Column). See Product List below for specific part numbers.

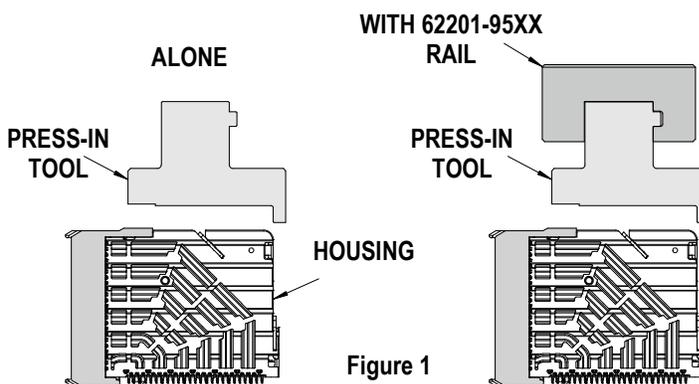
Product List

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	10	171400-1020					
	Left	10	171400-3020	171400-3120	171400-3220	171400-3320	171400-3420	171400-3520
			171400-3620	171400-3720	171400-3820			
	Right	10	171400-5020	171400-5120	171400-5220	171400-5320	171400-5420	171400-5520
			171400-5620	171400-5720	171400-5820			
	172130	Unguided	10	172130-1107	172130-1108			
Left		10	172130-3107	172130-3108	172130-3117	172130-3118	172130-3127	172130-3128
			172130-3137	172130-3138	172130-3147	172130-3148	172130-3157	172130-3158
			172130-3167	172130-3168	172130-3177	172130-3178	172130-3187	172130-3188
Right		10	172130-5107	172130-5108	172130-5117	172130-5118	172130-5127	172130-5128
			172130-5137	172130-5138	172130-5147	172130-5148	172130-5157	172130-5158
			172130-5167	172130-5168	172130-5177	172130-5178	172130-5187	172130-5188

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)

Reference: This Press-In Tool is 19.6mm (.771 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.

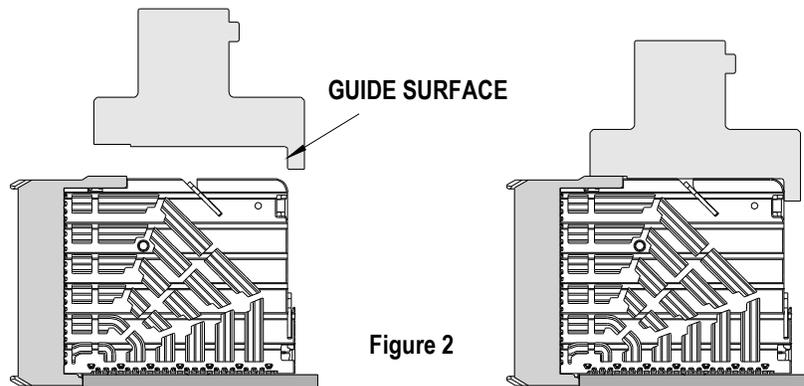
Press Equipment Recommendations

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

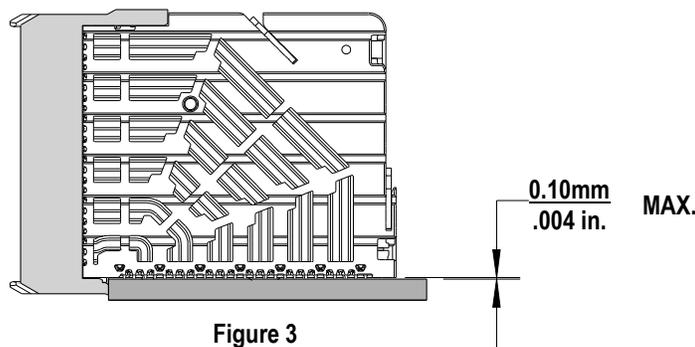
1. The capability to detect force variations as low as 4.5kg (10 lb) during the press-in cycle; excessive force measurements should stop the press-in cycle.
2. The rate of pressing can be regulated as low as 0.13mm (0.005 in) per second.
3. Press stroke control to within 0.25mm (0.010 in).
4. Total press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