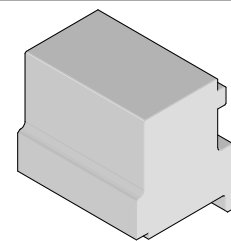


**Impact  
Daughtercard  
Module Installation  
Press-In Tool**



**Application Tooling  
Specification Sheet**



**Order No. 62201-8839**

**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: Impact Daughtercard 85 Ohm Assembly (4-Pair by 12 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](http://www.molex.com).

Series No.	Guide Style	Columns	Assembly Order Number					
76495	Unguided	12	76495-1203	76495-1204	76495-1205	76495-1206	76495-1207	76495-1208
			76495-1213	76495-1214	76495-1215	76495-1216	76495-1217	76495-1218
			76495-1223	76495-1224	76495-1225	76495-1226	76495-1227	76495-1228
			76495-1233	76495-1234	76495-1235	76495-1236	76495-1237	76495-1238
170340	Open	12	170340-1012	170340-1022				
	Left	12	170340-3012	170340-3022	170340-3052	170340-3062	170340-3112	170340-3122
			170340-3152	170340-3162	170340-3212	170340-3222	170340-3252	170340-3262
			170340-3312	170340-3322	170340-3352	170340-3362	170340-3412	170340-3422
			170340-3452	170340-3462	170340-3512	170340-3522	170340-3552	170340-3562
			170340-3612	170340-3622	170340-3652	170340-3662	170340-3712	170340-3722
			170340-3752	170340-3762	170340-3812	170340-3822	170340-3852	170340-3862
	Right	12	170340-5012	170340-5022	170340-5052	170340-5062	170340-5112	170340-5122
			170340-5152	170340-5162	170340-5212	170340-5222	170340-5252	170340-5262
			170340-5312	170340-5322	170340-5352	170340-5362	170340-5412	170340-5422
			170340-5452	170340-5462	170340-5512	170340-5522	170340-5552	170340-5562
			170340-5612	170340-5622	170340-5652	170340-5662	170340-5712	170340-5722
			170340-5752	170340-5762	170340-5812	170340-5822	170340-5852	170340-5862

## Tool Setup

Depending on the number of connectors to be installed 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.

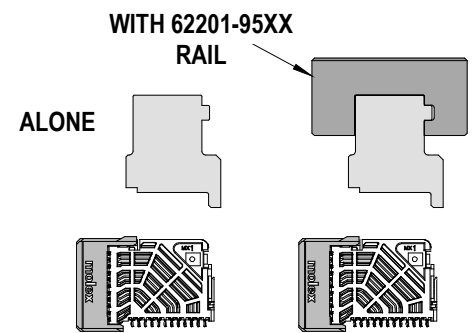


Figure 1

## 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 26.46mm (1.04 in.) long.

## Printed Circuit Board (PCB) Support

The Impact connectors require up to 3.6kg (8 lb) of force per pin to press into the PCB. To prevent excessive PCB flexure 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 plates. Customers must furnish their own support plates.

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 Impact connectors, but to assure consistent connector installation, Molex recommends the following press criteria:

1. Presses should have 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 should be within 0.25mm (0.010 in).
4. The total press stroke must be at least 19mm (0.75 in).
5. For statistical purposes, presses should automatically collect force and distance data.

## Tool Operation

1. By hand, carefully insert 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.

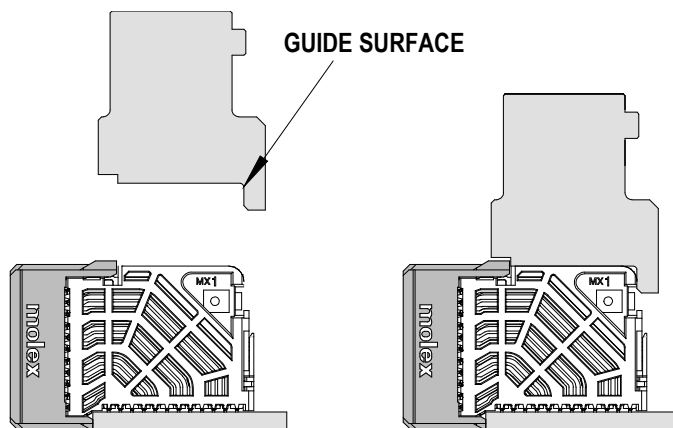


Figure 2

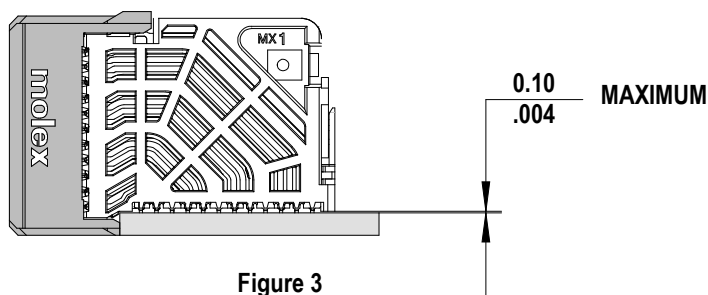


Figure 3

There should be no broken standoffs 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.

### Application Tooling Support

**Phone:** (402) 458-TOOL (8665)  
**E-Mail:** [applicationtooling@molex.com](mailto:applicationtooling@molex.com)  
**Website:** [www.molex.com/applicationtooling](http://www.molex.com/applicationtooling)

Molex is a registered trademark of Molex, LLC in the United States of America and may be registered in other countries; all other trademarks listed herein belong to their respective owners.