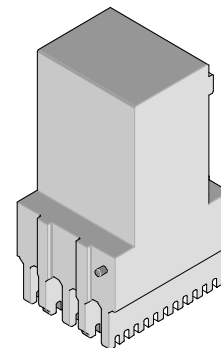




**I-Trac™ Backplane Module Installation
Application Tooling Specification
Press-In Tool
Order No. 62201-8607**



FEATURES

- Polarized tool prevents product damage.
- 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™ Backplane Signal Module Assembly, 76015 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.

76015 Series Numbers					
Guide Style	Columns	Assembly Order Number			
Open	4	76015-0402	76015-0403	76015-0404	76015-0405
Left End Wall		76015-0412	76015-0413	76015-0414	76015-0415
Dual End Wall		76015-0422	76015-0423	76015-0424	76015-0425
Right End Wall		76015-0432	76015-0433	76015-0434	76015-0435
Open		76015-1402	76015-1403	76015-1404	76015-1405
Left End Wall		76015-1412	76015-1413	76015-1414	76015-1415
Dual End Wall		76015-1422	76015-1423	76015-1424	76015-1425
Right End Wall		76015-1432	76015-1433	76015-1434	76015-1435
Guide Left	4	76015-2402	76015-2403	76015-2404	76015-2405
		76015-2412	76015-2413	76015-2414	76015-2415
		76015-2422	76015-2423	76015-2424	76015-2425
		76015-2432	76015-2433	76015-2434	76015-2435
		76015-2442	76015-2443	76015-2444	76015-2445
		76015-2452	76015-2453	76015-2454	76015-2455
		76015-2462	76015-2463	76015-2464	76015-2465
		76015-2472	76015-2473	76015-2474	76015-2475
		76015-2482	76015-2483	76015-2484	76015-2485
		76015-3402	76015-3403	76015-3404	76015-3405
		76015-3412	76015-3413	76015-3414	76015-3415
		76015-3422	76015-3423	76015-3424	76015-3425
		76015-3432	76015-3433	76015-3434	76015-3435
		76015-3442	76015-3443	76015-3444	76015-3445
		76015-3452	76015-3453	76015-3454	76015-3455
		76015-3462	76015-3463	76015-3464	76015-3465
76015-3472	76015-3473	76015-3474	76015-3475		
76015-3482	76015-3483	76015-3484	76015-3485		
Guide Right	4	76015-4402	76015-4403	76015-4404	76015-4405
		76015-4412	76015-4413	76015-4414	76015-4415
		76015-4422	76015-4423	76015-4424	76015-4425

76015 Series Numbers					
Guide Style	Columns	Assembly Order Number			
Guide Right	4	76015-4432	76015-4433	76015-4434	76015-4435
		76015-4442	76015-4443	76015-4444	76015-4445
		76015-4452	76015-4453	76015-4454	76015-4455
		76015-4462	76015-4463	76015-4464	76015-4465
		76015-4472	76015-4473	76015-4474	76015-4475
		76015-4482	76015-4483	76015-4484	76015-4485
		76015-5402	76015-5403	76015-5404	76015-5405
		76015-5412	76015-5413	76015-5414	76015-5415
		76015-5422	76015-5423	76015-5424	76015-5425
		76015-5432	76015-5433	76015-5434	76015-5435
		76015-5442	76015-5443	76015-5444	76015-5445
		76015-5452	76015-5453	76015-5454	76015-5455
		76015-5462	76015-5463	76015-5464	76015-5465
		76015-5472	76015-5473	76015-5474	76015-5475
		76015-5482	76015-5483	76015-5484	76015-5485
		Guide Left With End Wall	4	76015-6402	76015-6403
76015-6412	76015-6413			76015-6414	76015-6415
76015-6422	76015-6423			76015-6424	76015-6425
76015-6432	76015-6433			76015-6434	76015-6435
76015-6442	76015-6443			76015-6444	76015-6445
76015-6452	76015-6453			76015-6454	76015-6455
76015-6462	76015-6463			76015-6464	76015-6465
76015-6472	76015-6473			76015-6474	76015-6475
76015-6482	76015-6483			76015-6484	76015-6485
76015-7402	76015-7403			76015-7404	76015-7405
76015-7412	76015-7413			76015-7414	76015-7415
76015-7422	76015-7423			76015-7424	76015-7425
76015-7432	76015-7433			76015-7434	76015-7435
76015-7442	76015-7443			76015-7444	76015-7445
76015-7452	76015-7453			76015-7454	76015-7455
76015-7462	76015-7463			76015-7464	76015-7465
76015-7472	76015-7473	76015-7474	76015-7475		
76015-7482	76015-7483	76015-7484	76015-7485		
Guide Right With End Wall	4	76015-8402	76015-8403	76015-8404	76015-8405
		76015-8412	76015-8413	76015-8414	76015-8415
		76015-8422	76015-8423	76015-8424	76015-8425
		76015-8432	76015-8433	76015-8434	76015-8435
		76015-8442	76015-8443	76015-8444	76015-8445
		76015-8452	76015-8453	76015-8454	76015-8455
		76015-8462	76015-8463	76015-8464	76015-8465
		76015-8472	76015-8473	76015-8474	76015-8475
		76015-8482	76015-8483	76015-8484	76015-8485
		76015-9402	76015-9403	76015-9404	76015-9405
		76015-9412	76015-9413	76015-9414	76015-9415
		76015-9422	76015-9423	76015-9424	76015-9425
		76015-9432	76015-9433	76015-9434	76015-9435
		76015-9442	76015-9443	76015-9444	76015-9445
		76015-9452	76015-9453	76015-9454	76015-9455
		76015-9462	76015-9463	76015-9464	76015-9465
76015-9472	76015-9473	76015-9474	76015-9475		
76015-9482	76015-9483	76015-9484	76015-9485		

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.

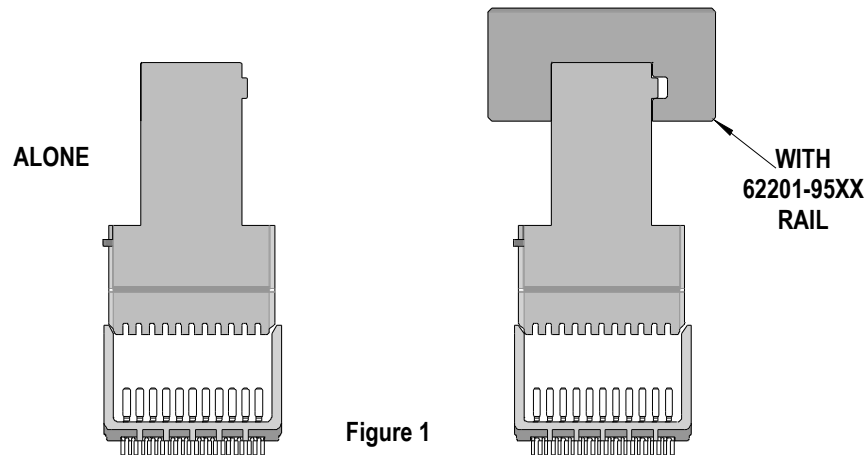


Figure 1

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 14.7mm (0.58 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 backplane signal module(s) into the PCB hole pattern. Make sure the connector(s) are oriented properly by confirming the location of the #1 circuit notch with respect to the PCB layout.
2. Insert the application tool into the header assembly with the orientation peg on the tool entering the #1 circuit notch at the top of the connector housing. See Figure 2.

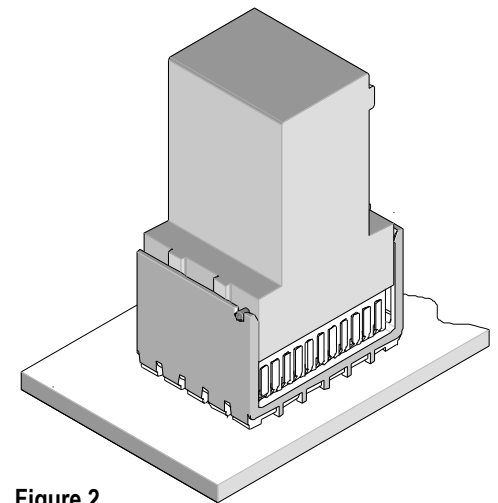
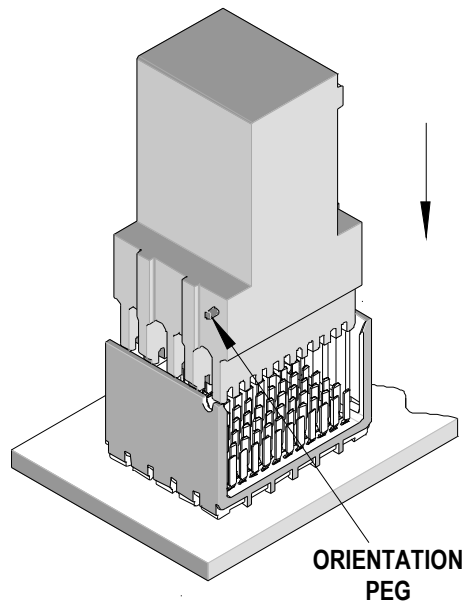


Figure 2

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

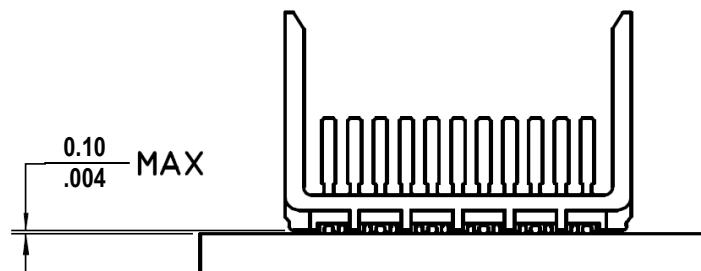


Figure 3

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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