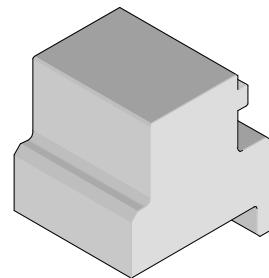




**I-Trac™ Daughtercard Module and RAM Installation  
Application Tooling Specification  
Press-In Tool  
Order No. 62201-8604**



## 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: I-Trac™ Daughtercard Signal Module Assembly, 75710 Series 5 Column Assemblies and I-Trac™ RAM, 75910 Series 5 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).

75710 Series Numbers							
Guide Style	Columns	Assembly Order Number					
Open	5	75710-0005	75710-1005				
Guide Left	5	75710-2005	75710-2105	75710-2205	75710-2305	75710-2405	75710-2505
		75710-2605	75710-2705	75710-2805	75710-3005	75710-3105	75710-3205
		75710-3305	75710-3405	75710-3505	75710-3605	75710-3705	75710-3805
Guide Right	5	75710-4005	75710-4105	75710-4205	75710-4305	75710-4405	75710-4505
		75710-4605	75710-4705	75710-4805	75710-5005	75710-5105	75710-5205
		75710-5305	75710-5405	75710-5505	75710-5605	75710-5705	75710-5805

75910 Series Numbers							
Guide Style	Columns	Assembly Order Number					
Open	5	75910-0503	75910-0505	75910-0506	75910-1503	75910-1505	75910-1506
Left End Wall	5	75910-0513	75910-0515	75910-0516	75910-1513	75910-1515	75910-1516
Right End Wall	5	75910-0523	75910-0525	75910-0526	75910-1523	75910-1525	75910-1526
Dual End Wall	5	75910-0533	75910-0535	75910-0536	75910-1533	75910-1535	75910-1536
Guide Left	5	75910-2523	75910-2525	75910-2526	75910-2533	75910-2535	75910-2536
		75910-3523	75910-3525	75910-3526	75910-3533	75910-3535	75910-3536
		75910-6523	75910-6525	75910-6526	75910-6533	75910-6535	75910-6536
		75910-7523	75910-7525	75910-7526	75910-7533	75910-7535	75910-7536
Guide Right	5	75910-4523	75910-4525	75910-4526	75910-4533	75910-4535	75910-4536
		75910-5523	75910-5525	75910-5526	75910-5533	75910-5535	75910-5536
		75910-8523	75910-8525	75910-8526	75910-8533	75910-8535	75910-8536
		75910-9523	75910-9525	75910-9526	75910-9533	75910-9535	75910-9536

## 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.

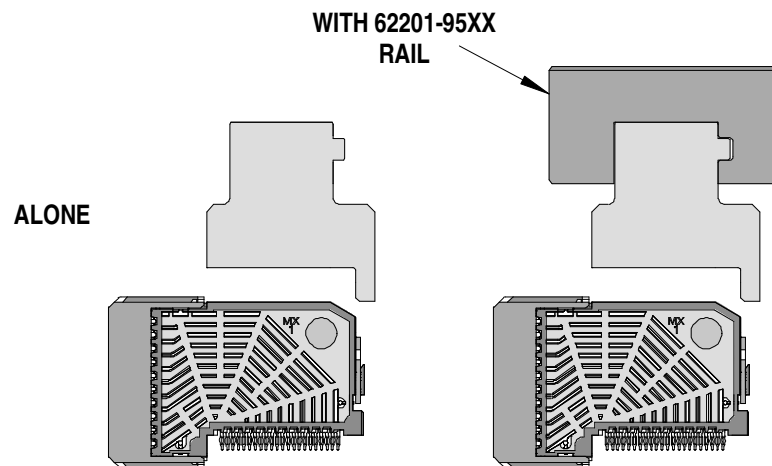


Figure 1

## Tool Installation continued

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: The 62201-8604 Press-In Tool is 19mm (0.75 in.) long.

## Printed Circuit Board (PCB) Support

The I-Trac™ 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 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 Daughtercard and / or RAM module(s) into the PCB hole pattern.
2. Place the application tool on top of the module with the back guide surface of the tool against the back of the module. See Figure 2.

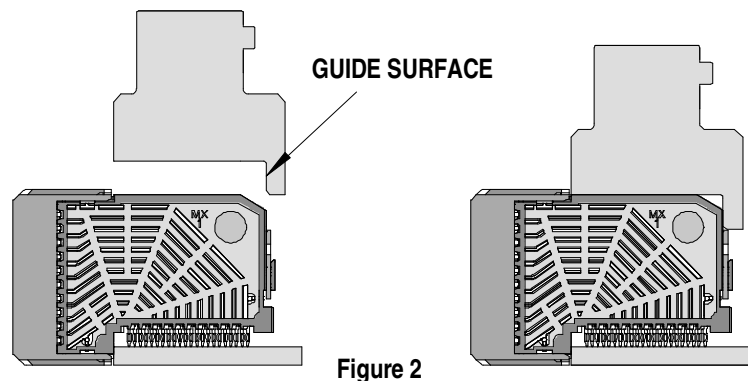


Figure 2

3. Using the application tool and an appropriate press, seat the module until there is less than 0.25mm (0.01 in) clearance between the bottom of the plastic housing and the surface of the PCB. See Figure 3.

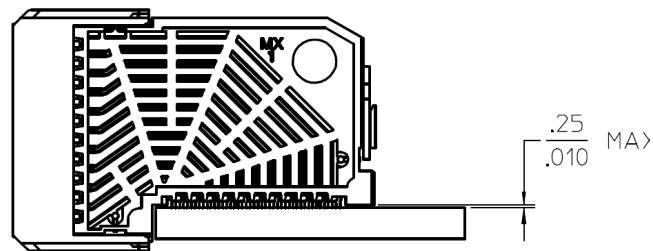


Figure 3  
(Daughtercard shown; same dimensions for RAM)

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.

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