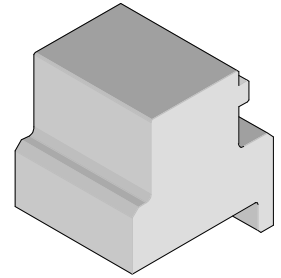




**I-Trac™ Daughtercard Module and RAM Installation
Application Tooling Specification
Press-In Tool
Order No. 62201-8606**



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 10 Column Assemblies, and I-Trac™ RAM, 75910 Series 10 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.

| 75710 Series Numbers | | | | | | | |
|----------------------|---------|-----------------------|------------|------------|------------|------------|------------|
| Guide Style | Columns | Assembly Order Number | | | | | |
| Open | 10 | 75710-0010 | 75710-1010 | | | | |
| Guide Left | 10 | 75710-2010 | 75710-2110 | 75710-2210 | 75710-2310 | 75710-2410 | 75710-2510 |
| | | 75710-2610 | 75710-2710 | 75710-2810 | 75710-3010 | 75710-3110 | 75710-3210 |
| | | 75710-3310 | 75710-3410 | 75710-3510 | 75710-3610 | 75710-3710 | 75710-3810 |
| Guide Right | 10 | 75710-4010 | 75710-4110 | 75710-4210 | 75710-4310 | 75710-4410 | 75710-4510 |
| | | 75710-4610 | 75710-4710 | 75710-4810 | 75710-5010 | 75710-5110 | 75710-5210 |
| | | 75710-5310 | 75710-5410 | 75710-5510 | 75710-5610 | 75710-5710 | 75710-5810 |

| 75910 Series Numbers | | | | | | | |
|----------------------|---------|-----------------------|------------|------------|------------|------------|------------|
| Guide Style | Columns | Assembly Order Number | | | | | |
| Open | 10 | 75910-0103 | 75910-0105 | 75910-0106 | 75910-1103 | 75910-1105 | 75910-1106 |
| Left End Wall | 10 | 75910-0113 | 75910-0115 | 75910-0116 | 75910-1113 | 75910-1115 | 75910-1116 |
| Right End Wall | 10 | 75910-0123 | 75910-0125 | 75910-0126 | 75910-1123 | 75910-1125 | 75910-1126 |
| Dual End Wall | 10 | 75910-0133 | 75910-0135 | 75910-0136 | 75910-1133 | 75910-1135 | 75910-1136 |
| Guide Left | 10 | 75910-2123 | 75910-2125 | 75910-2126 | 75910-2133 | 75910-2135 | 75910-2136 |
| | | 75910-3123 | 75910-3125 | 75910-3126 | 75910-3133 | 75910-3135 | 75910-3136 |
| | | 75910-6123 | 75910-6125 | 75910-6126 | 75910-6133 | 75910-6135 | 75910-6136 |
| | | 75910-7123 | 75910-7125 | 75910-7126 | 75910-7133 | 75910-7135 | 75910-7136 |
| Guide Right | 10 | 75910-4123 | 75910-4125 | 75910-4126 | 75910-4133 | 75910-4135 | 75910-4136 |
| | | 75910-5123 | 75910-5125 | 75910-5126 | 75910-5133 | 75910-5135 | 75910-5136 |
| | | 75910-8123 | 75910-8125 | 75910-8126 | 75910-8133 | 75910-8135 | 75910-8136 |
| | | 75910-9123 | 75910-9125 | 75910-9126 | 75910-9133 | 75910-9135 | 75910-9136 |

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.

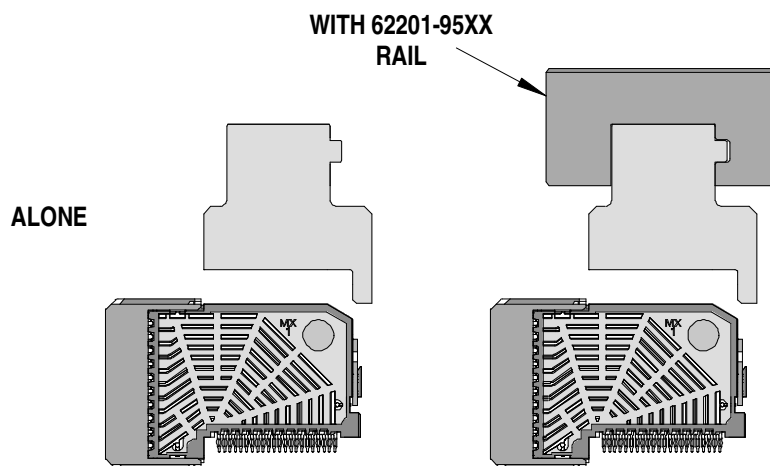


Figure 1

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 62201-8606 Press-In Tool is 36.9mm (1.45 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.

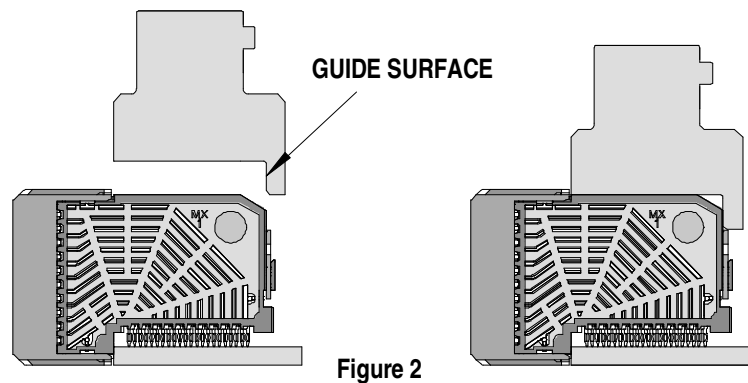


Figure 2

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.

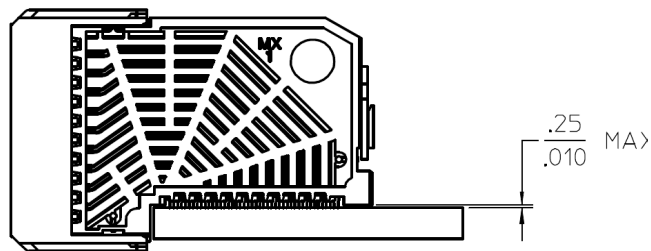


Figure 3
(Daughtercard shown; same dimensions for RAM)

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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