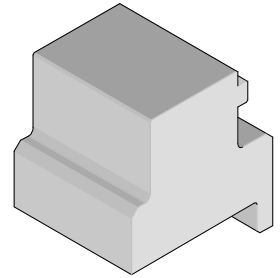




**I-Trac™ Daughtercard Module and RAM Installation
Application Tooling Specification
Press-In Tool
Order No. 62201-8611**



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, 76020 Series 6 Column Assemblies, and I-Trac™ RAM, 76011 Series 6 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.

76020 Series Numbers							
Guide Style	Columns	Assembly Order Number					
Open	6	76020-0006	76020-1006	76020-0906	76020-1906		
Guide Left	6	76020-2006	76020-2106	76020-2206	76020-2306	76020-2406	76020-2506
		76020-2606	76020-2706	76020-2806	76020-3006	76020-3106	76020-3206
		76020-3306	76020-3406	76020-3506	76020-3606	76020-3706	76020-3806
Guide Right	6	76020-4006	76020-4106	76020-4206	76020-4306	76020-4406	76020-4506
		76020-4606	76020-4706	76020-4806	76020-5006	76020-5106	76020-5206
		76020-5306	76020-5406	76020-5506	76020-5606	76020-5706	76020-5806

76011 Series Numbers							
Guide Style	Columns	Assembly Order Number					
Open	6	76011-0603	76011-0605	76011-0606	76011-1603	76011-1605	76011-1606
Left End Wall	6	76011-0613	76011-0615	76011-0616	76011-1613	76011-1615	76011-1616
Right End Wall	6	76011-0623	76011-0625	76011-0626	76011-1623	76011-1625	76011-1626
Dual End Wall	6	76011-0633	76011-0635	76011-0636	76011-1633	76011-1635	76011-1636
Guide Left	6	76011-2623	76011-2625	76011-2626	76011-2633	76011-2635	76011-2636
		76011-3623	76011-3625	76011-3626	76011-3633	76011-3635	76011-3636
		76011-6623	76011-6625	76011-6626	76011-6633	76011-6635	76011-6636
		76011-7623	76011-7625	76011-7626	76011-7633	76011-7635	76011-7636
Guide Right	6	76011-4623	76011-4625	76011-4626	76011-4633	76011-4635	76011-4636
		76011-5623	76011-5625	76011-5626	76011-5633	76011-5635	76011-5636
		76011-8623	76011-8625	76011-8626	76011-8633	76011-8635	76011-8636
		76011-9623	76011-9625	76011-9626	76011-9633	76011-9635	76011-9636

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.

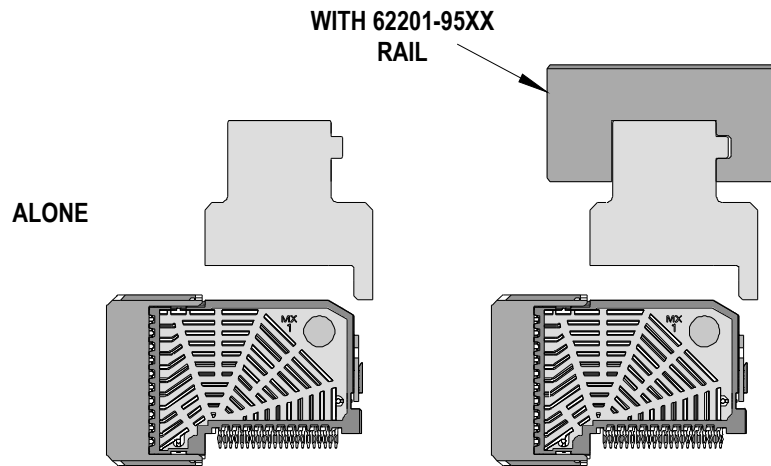


Figure 1

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: The 62201-8611- Press-In Tool is 22.3mm (0.88 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, 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 Daughtercard module. See Figure 2.

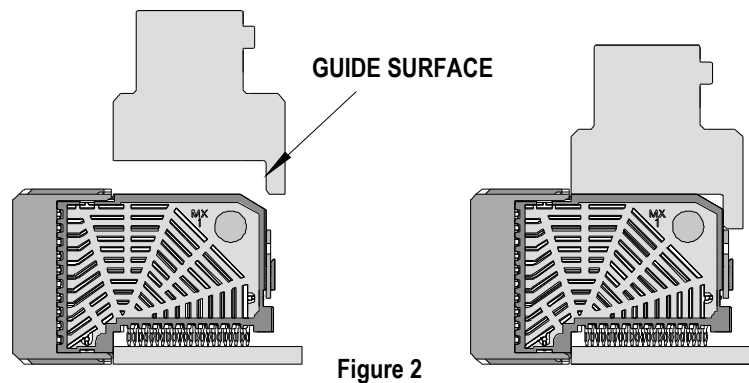


Figure 2

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.

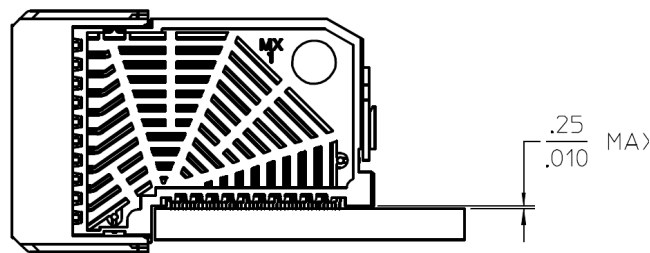


Figure 3

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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