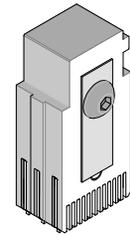


**Impact™
Backplane Module
Installation
Press-In Tool**



**Application Tooling
Specification Sheet**



Order No. 62201-8747

FEATURES

- 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™ Orthogonal Backplane Signal Module Assembly, 76845 Series, (4-Pair by 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.

76845 Series Numbers									
Guide Style	Columns	Assembly Order Number							
Unguided	6	76845-0604	76845-0605	76845-0607	76845-0608	76845-1604	76845-1605	76845-1607	76845-1608
		76845-0614	76845-0615	76845-0617	76845-0618	76845-1614	76845-1615	76845-1617	76845-1618
		76845-0634	76845-0635	76845-0637	76845-0638	76845-1634	76845-1635	76845-1637	76845-1638
Dual Wall	6	76845-0624	76845-0625	76845-0627	76845-0628	76845-1624	76845-1625	76845-1627	76845-1628
Guided Left	6	76845-2604	76845-2605	76845-2607	76845-2608	76845-3604	76845-3605	76845-3607	76845-3608
		76845-6604	76845-6605	76845-6607	76845-6608	76845-7604	76845-7605	76845-7607	76845-7608
Guided Right	6	76845-4604	76845-4605	76845-4607	76845-4608	76845-5604	76845-5605	76845-5607	76845-5608
		76845-8604	76845-8605	76845-8607	76845-8608	76845-9604	76845-9605	76845-9607	76845-9608

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.

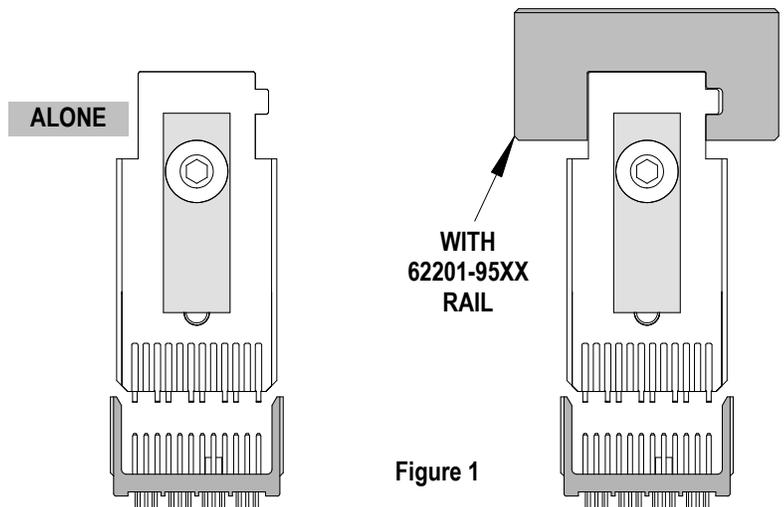


Figure 1

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 12.0mm (0.47in.) 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 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.

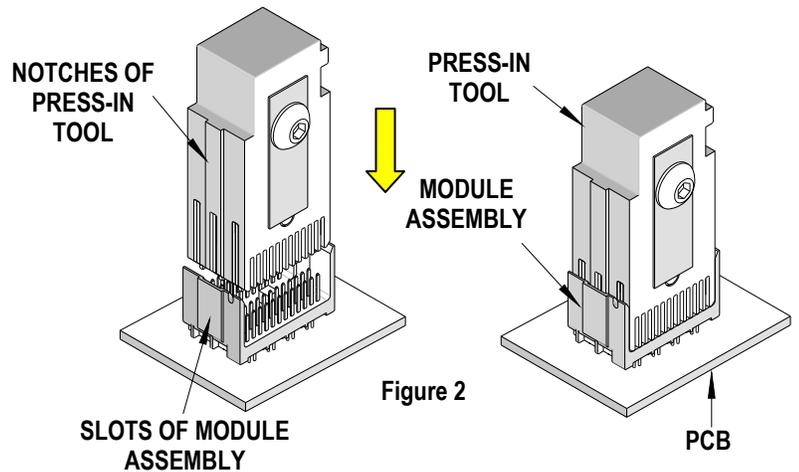
Press Equipment Recommendations

Many types of presses can be used to install Impact™ connectors, but to assure consistent connector installation Molex recommends the following press criteria:

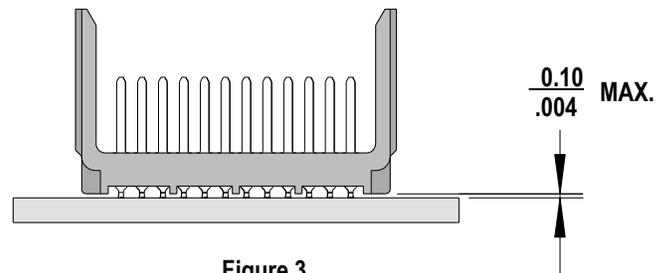
1. The capability to detect force variations as low as 4.5kg (10 lb) during the press-in cycle; excessive force measurements should stop the press-in cycle.
2. The rate of pressing can be regulated as low as 0.13mm (0.005 in) per second.
3. Press stroke control to within 0.25mm (0.010 in).
4. Total press stroke must be at least 19mm (0.75 in).
5. For statistical purposes, automatic collection of force and distance data.

Tool Operation

1. Insert by hand the backplane signal module assembly (s) carefully 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 Press-In Tool making sure that the notch in this tool is inserted into the slot on the connector housing. See 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.



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.

<http://www.molex.com>