Impact™ and Impel™ Daughtercard Module Installation Press-In Tool	**molex**® Application Tooling Specification Sheet	
		Order No. 62201-8975
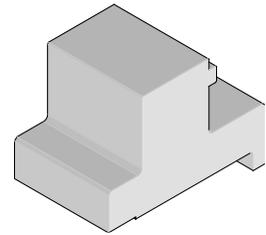
FEATURES

- 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: Impel™ 3mm Pitch daughtercard assembly (6-Pair by 8 Column), Impel™ 1.9mm Pitch daughtercard assembly (6-Pair by 12 Column), and Impact™ ZX2 daughtercard assembly (6-Pair by 12 Column). 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.

Series No.	Guide Style	Columns	Assembly Order Number					
171400 Impel™	Unguided	12	171400-1022					
171760 Impel™	Unguided	8	171760-1038					
	Left	8	171760-3038	171760-3138	171760-3238	171760-3338	171760-3438	171760-3538
			171760-3638	171760-3738	171760-3838			
	Right	8	171760-5038	171760-5138	171760-5238	171760-5338	171760-5438	171760-5538
			171760-5638	171760-5738		171760-5838		
172540 Impact™	Unguided	12	172540-1022					
	Left	12	172540-3022					
	Right	12	172540-5022					

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 to a 62201-95XX rail (ordered separately). See Figure 1.

ALONE

WITH 62201-95XX RAIL

PRESS-IN TOOL

PRESS-IN TOOL

HOUSING

Figure 1
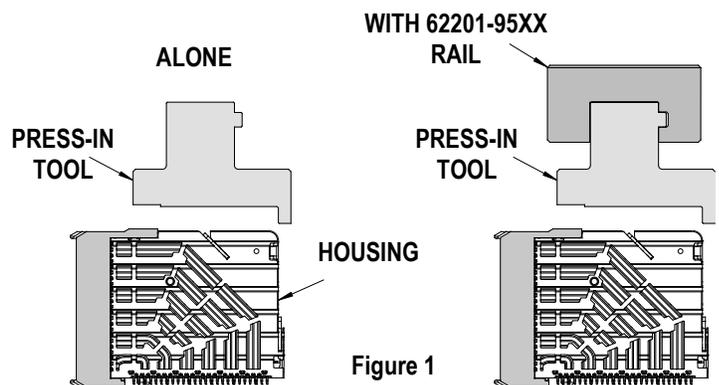
Tool Installation

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 23mm (.91 in.) long.

Printed Circuit Board (PCB) Support

The Impact™ and the Impel™ connectors require up to 2.7kg (6 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 Impel 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 module(s) into the PCB hole pattern.
2. Place the application tool on top of the Daughtercard module with the back guide surface of the tool against the back of the Daughtercard module. See Figure 2.

GUIDE SURFACE
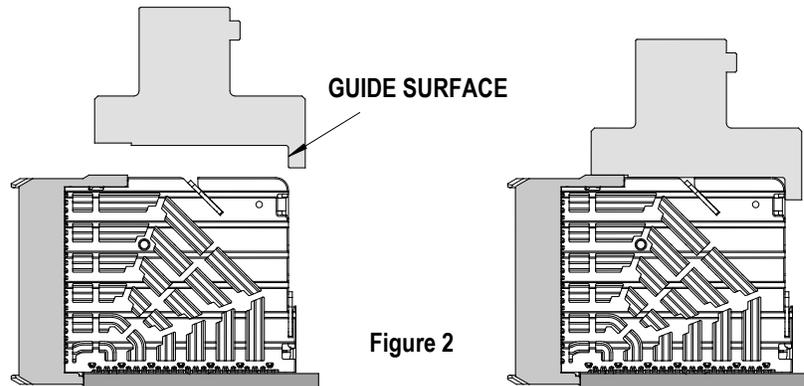
Figure 2

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

0.10mm
.004 in.   **MAX.**

Figure 3
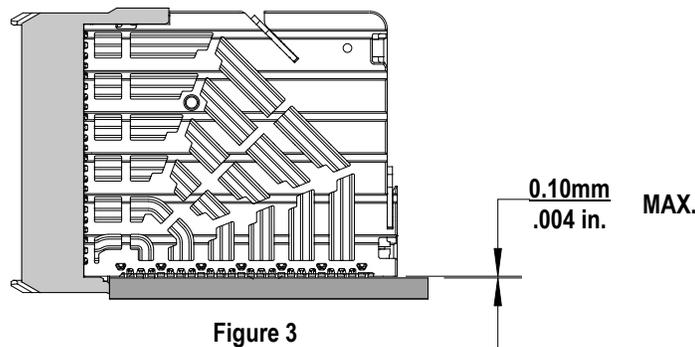
There should be no broken stand-offs along the perimeter of the part (an indication of over-pressing).

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.

Visit our Web site at http://www.molex.com