Impel Daughtercard Module Installation Press-In Tool	**molex®** **Application Tooling Specification Sheet**	
		Order No. 62201-8903
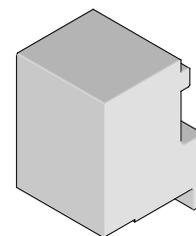
FEATURES
- Lip provided for positive alignment to connector assembly.
- Tool provides uniform distribution of press force across entire pin array.
- May be used as a stand-alone tool or mounted in an optional holder with other Molex press-in tools.
- For module removal, use tool 62100-9710

SCOPE
Products: Impel 1.9mm Pitch Daughtercard Assembly (3-Pair by 8 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.

| Series No.	Guide Style	Columns	Assembly Order Number					
171340	Custom	8	171340-1038	171340-9001				
171990	Unguided	8	171990-1038					
	Left	8	171990-3038	171990-3138	171990-3238	171990-3338	171990-3438	171990-3538
			171990-3638	171990-3738	171990-3838			
	Right	8	171990-5038	171990-5138	171990-5238	171990-5338	171990-5438	171990-5538
			171990-5638	171990-5738	171990-5838			

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.

Tool Installation
The 62201-95XX rail is available in a variety of lengths to accommodate multiple press-in tools.

WITH 62201-95XX RAIL

ALONE

PRESS-IN TOOL

Figure 1

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 15.8mm (0.622 in.) long.
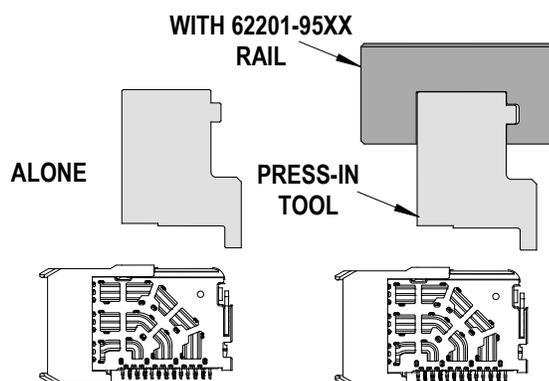
Printed Circuit Board (PCB) Support

The Impel 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 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
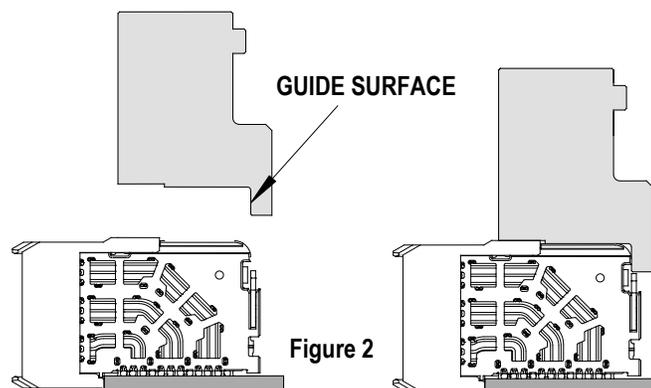
Figure 2

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.**
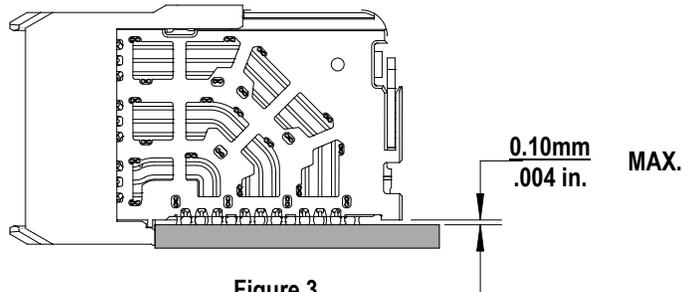
Figure 3

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.

http://www.molex.com