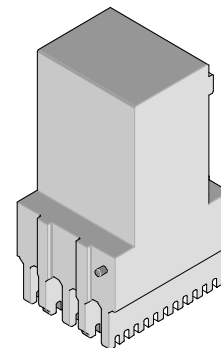




**I-Trac™ Backplane Module Installation  
Application Tooling Specification  
Press-In Tool  
Order No. 62201-8602**



## FEATURES

- Polarized tool prevents product damage.
- 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™ Backplane Signal Module Assembly, 75705 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](http://www.molex.com).

75705 Series Numbers					
Guide Style	Columns	Assembly Order Number			
Open	6	75705-0602	75705-0603	75705-0604	75705-0605
Left End Wall		75705-0612	75705-0613	75705-0614	75705-0615
Dual End Wall		75705-0622	75705-0623	75705-0624	75705-0625
Right End Wall		75705-0632	75705-0633	75705-0634	75705-0635
Open		75705-1602	75705-1603	75705-1604	75705-1605
Left End Wall		75705-1612	75705-1613	75705-1614	75705-1615
Dual End Wall		75705-1622	75705-1623	75705-1624	75705-1625
Right End Wall		75705-1632	75705-1633	75705-1634	75705-1635
Guide Left	6	75705-2602	75705-2603	75705-2604	75705-2605
		75705-2612	75705-2613	75705-2614	75705-2615
		75705-2622	75705-2623	75705-2624	75705-2625
		75705-2632	75705-2633	75705-2634	75705-2635
		75705-2642	75705-2643	75705-2644	75705-2645
		75705-2652	75705-2653	75705-2654	75705-2655
		75705-2662	75705-2663	75705-2664	75705-2665
		75705-2672	75705-2673	75705-2674	75705-2675
		75705-2682	75705-2683	75705-2684	75705-2685
		75705-3602	75705-3603	75705-3604	75705-3605
		75705-3612	75705-3613	75705-3614	75705-3615
		75705-3622	75705-3623	75705-3624	75705-3625
		75705-3632	75705-3633	75705-3634	75705-3635
		75705-3642	75705-3643	75705-3644	75705-3645
		75705-3652	75705-3653	75705-3654	75705-3655
		75705-3662	75705-3663	75705-3664	75705-3665
75705-3672	75705-3673	75705-3674	75705-3675		
75705-3682	75705-3683	75705-3684	75705-3685		
Guide Right	6	75705-4602	75705-4603	75705-4604	75705-4605
		75705-4612	75705-4613	75705-4614	75705-4615
		75705-4622	75705-4623	75705-4624	75705-4625

75705 Series Numbers					
Guide Style	Columns	Assembly Order Number			
Guide Right	6	75705-4632	75705-4633	75705-4634	75705-4635
		75705-4642	75705-4643	75705-4644	75705-4645
		75705-4652	75705-4653	75705-4654	75705-4655
		75705-4662	75705-4663	75705-4664	75705-4665
		75705-4672	75705-4673	75705-4674	75705-4675
		75705-4682	75705-4683	75705-4684	75705-4685
		75705-5602	75705-5603	75705-5604	75705-5605
		75705-5612	75705-5613	75705-5614	75705-5615
		75705-5622	75705-5623	75705-5624	75705-5625
		75705-5632	75705-5633	75705-5634	75705-5635
		75705-5642	75705-5643	75705-5644	75705-5645
		75705-5652	75705-5653	75705-5654	75705-5655
		75705-5662	75705-5663	75705-5664	75705-5665
		75705-5672	75705-5673	75705-5674	75705-5675
		75705-5682	75705-5683	75705-5684	75705-5685
		Guide Left With End Wall	6	75705-6602	75705-6603
75705-6612	75705-6613			75705-6614	75705-6615
75705-6622	75705-6623			75705-6624	75705-6625
75705-6632	75705-6633			75705-6634	75705-6635
75705-6642	75705-6643			75705-6644	75705-6645
75705-6652	75705-6653			75705-6654	75705-6655
75705-6662	75705-6663			75705-6664	75705-6665
75705-6672	75705-6673			75705-6674	75705-6675
75705-6682	75705-6683			75705-6684	75705-6685
75705-7602	75705-7603			75705-7604	75705-7605
75705-7612	75705-7613			75705-7614	75705-7615
75705-7622	75705-7623			75705-7624	75705-7625
75705-7632	75705-7633			75705-7634	75705-7635
75705-7642	75705-7643			75705-7644	75705-7645
75705-7652	75705-7653			75705-7654	75705-7655
75705-7662	75705-7663			75705-7664	75705-7665
75705-7672	75705-7673	75705-7674	75705-7675		
75705-7682	75705-7683	75705-7684	75705-7685		
Guide Right With End Wall	6	75705-8602	75705-8603	75705-8604	75705-8605
		75705-8612	75705-8613	75705-8614	75705-8615
		75705-8622	75705-8623	75705-8624	75705-8625
		75705-8632	75705-8633	75705-8634	75705-8635
		75705-8642	75705-8643	75705-8644	75705-8645
		75705-8652	75705-8653	75705-8654	75705-8655
		75705-8662	75705-8663	75705-8664	75705-8665
		75705-8672	75705-8673	75705-8674	75705-8675
		75705-8682	75705-8683	75705-8684	75705-8685
		75705-9602	75705-9603	75705-9604	75705-9605
		75705-9612	75705-9613	75705-9614	75705-9615
		75705-9622	75705-9623	75705-9624	75705-9625
		75705-9632	75705-9633	75705-9634	75705-9635
		75705-9642	75705-9643	75705-9644	75705-9645
		75705-9652	75705-9653	75705-9654	75705-9655
		75705-9662	75705-9663	75705-9664	75705-9665
75705-9672	75705-9673	75705-9674	75705-9675		
75705-9682	75705-9683	75705-9684	75705-9685		

## 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.

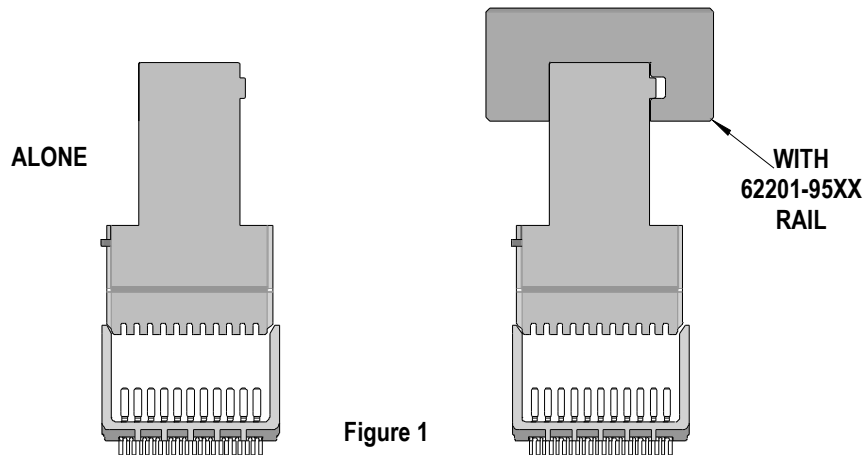


Figure 1

## 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: This Press-In Tool is 22.2mm (0.87 in.) long.

## Printed Circuit Board (PCB) Support

The I-Trac™ connectors require up to 1.81kg (4 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 backplane signal module(s) 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 application tool into the header assembly with the orientation peg on the tool entering the #1 circuit notch at the top of the connector housing. See Figure 2.

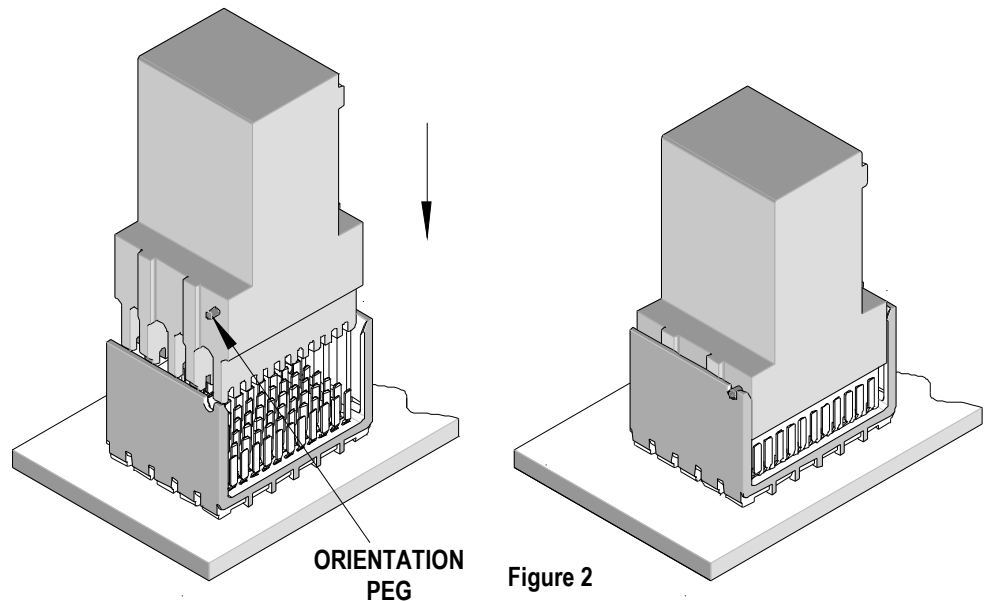


Figure 2

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.

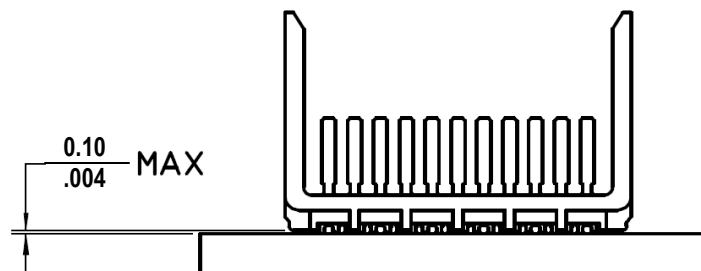


Figure 3

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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