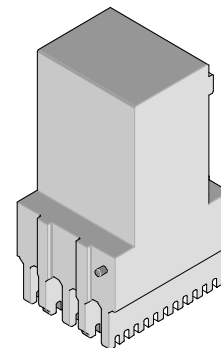




**I-Trac™ Backplane Module Installation  
Application Tooling Specification  
Press-In Tool  
Order No. 62201-8609**



## 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, 76015 Series 10 Column Assemblies. See Product List below for specific part numbers.

## Product List

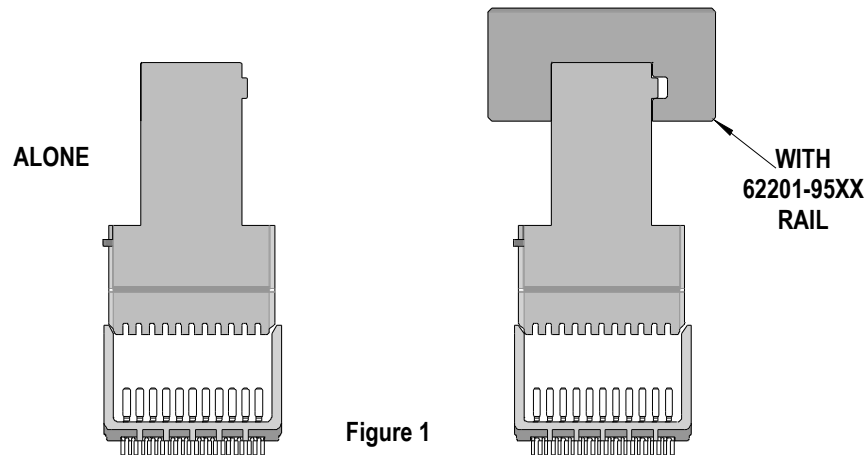
The following is a partial list of the product order numbers and their specifications this tool is designed to run. Updates to this list are available on [www.molex.com](http://www.molex.com).

76015 Series Numbers					
Guide Style	Columns	Assembly Order Number			
Open	10	76015-0102	76015-0103	76015-0104	76015-0105
Left End Wall		76015-0112	76015-0113	76015-0114	76015-0115
Dual End Wall		76015-0122	76015-0123	76015-0124	76015-0125
Right End Wall		76015-0132	76015-0133	76015-0134	76015-0135
Open		76015-1102	76015-1103	76015-1104	76015-1105
Left End Wall		76015-1112	76015-1113	76015-1114	76015-1115
Dual End Wall		76015-1122	76015-1123	76015-1124	76015-1125
Right End Wall		76015-1132	76015-1133	76015-1134	76015-1135
Guide Left	10	76015-2102	76015-2103	76015-2104	76015-2105
		76015-2112	76015-2113	76015-2114	76015-2115
		76015-2122	76015-2123	76015-2124	76015-2125
		76015-2132	76015-2133	76015-2134	76015-2135
		76015-2142	76015-2143	76015-2144	76015-2145
		76015-2152	76015-2153	76015-2154	76015-2155
		76015-2162	76015-2163	76015-2164	76015-2165
		76015-2172	76015-2173	76015-2174	76015-2175
		76015-2182	76015-2183	76015-2184	76015-2185
		76015-3102	76015-3103	76015-3104	76015-3105
		76015-3112	76015-3113	76015-3114	76015-3115
		76015-3122	76015-3123	76015-3124	76015-3125
		76015-3132	76015-3133	76015-3134	76015-3135
		76015-3142	76015-3143	76015-3144	76015-3145
		76015-3152	76015-3153	76015-3154	76015-3155
		76015-3162	76015-3163	76015-3164	76015-3165
76015-3172	76015-3173	76015-3174	76015-3175		
76015-3182	76015-3183	76015-3184	76015-3185		
Guide Right	10	76015-4102	76015-4103	76015-4104	76015-4105
		76015-4112	76015-4113	76015-4114	76015-4115
		76015-4122	76015-4123	76015-4124	76015-4125
		76015-4132	76015-4133	76015-4134	76015-4135

76015 Series Numbers					
Guide Style	Columns	Assembly Order Number			
Guide Right	10	76015-4142	76015-4143	76015-4144	76015-4145
		76015-4152	76015-4153	76015-4154	76015-4155
		76015-4162	76015-4163	76015-4164	76015-4165
		76015-4172	76015-4173	76015-4174	76015-4175
		76015-4182	76015-4183	76015-4184	76015-4185
		76015-5102	76015-5103	76015-5104	76015-5105
		76015-5112	76015-5113	76015-5114	76015-5115
		76015-5122	76015-5123	76015-5124	76015-5125
		76015-5132	76015-5133	76015-5134	76015-5135
		76015-5142	76015-5143	76015-5144	76015-5145
		76015-5152	76015-5153	76015-5154	76015-5155
		76015-5162	76015-5163	76015-5164	76015-5165
		76015-5172	76015-5173	76015-5174	76015-5175
		76015-5182	76015-5183	76015-5184	76015-5185
		Guide Left With End Wall	10	76015-6102	76015-6103
76015-6112	76015-6113			76015-6114	76015-6115
76015-6122	76015-6123			76015-6124	76015-6125
76015-6132	76015-6133			76015-6134	76015-6135
76015-6142	76015-6143			76015-6144	76015-6145
76015-6152	76015-6153			76015-6154	76015-6155
76015-6162	76015-6163			76015-6164	76015-6165
76015-6172	76015-6173			76015-6174	76015-6175
76015-6182	76015-6183			76015-6184	76015-6185
76015-7102	76015-7103			76015-7104	76015-7105
76015-7112	76015-7113			76015-7114	76015-7115
76015-7122	76015-7123			76015-7124	76015-7125
76015-7132	76015-7133			76015-7134	76015-7135
76015-7142	76015-7143			76015-7144	76015-7145
76015-7152	76015-7153			76015-7154	76015-7155
76015-7162	76015-7163	76015-7164	76015-7165		
76015-7172	76015-7173	76015-7174	76015-7175		
76015-7182	76015-7183	76015-7184	76015-7185		
Guide Right With End Wall	10	76015-8102	76015-8103	76015-8104	76015-8105
		76015-8112	76015-8113	76015-8114	76015-8115
		76015-8122	76015-8123	76015-8124	76015-8125
		76015-8132	76015-8133	76015-8134	76015-8135
		76015-8142	76015-8143	76015-8144	76015-8145
		76015-8152	76015-8153	76015-8154	76015-8155
		76015-8162	76015-8163	76015-8164	76015-8165
		76015-8172	76015-8173	76015-8174	76015-8175
		76015-8182	76015-8183	76015-8184	76015-8185
		76015-9102	76015-9103	76015-9104	76015-9105
		76015-9112	76015-9113	76015-9114	76015-9115
		76015-9122	76015-9123	76015-9124	76015-9125
		76015-9132	76015-9133	76015-9134	76015-9135
		76015-9142	76015-9143	76015-9144	76015-9145
		76015-9152	76015-9153	76015-9154	76015-9155
76015-9162	76015-9163	76015-9164	76015-9165		
76015-9172	76015-9173	76015-9174	76015-9175		
76015-9182	76015-9183	76015-9184	76015-9185		

## 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.

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 37.0mm (14.57 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.

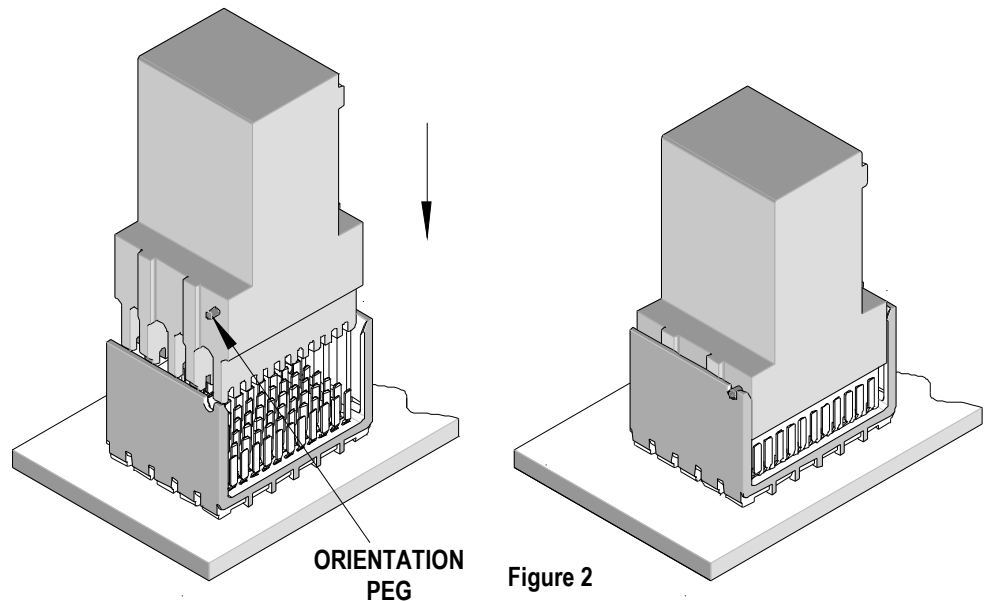


Figure 2

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.

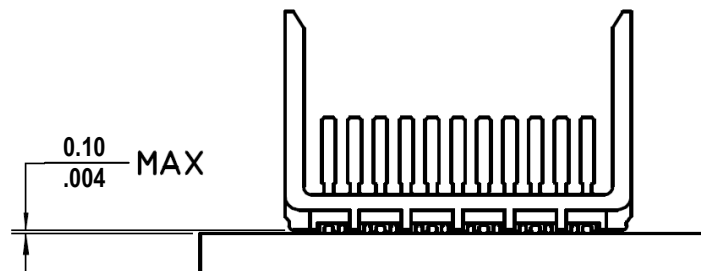


Figure 3

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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