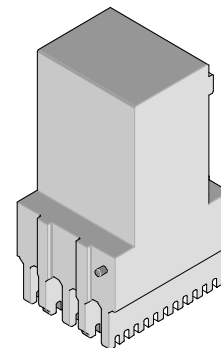




**I-Trac™ Backplane Module Installation  
Application Tooling Specification  
Press-In Tool  
Order No. 62201-8603**



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

## Product List

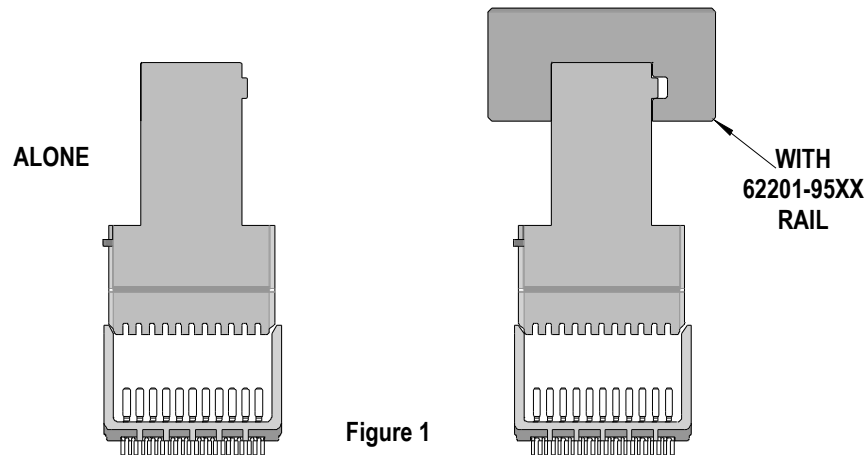
The following is a partial list of the product order numbers and their specifications this tool is designed to run. Updates to this list are available on [www.molex.com](http://www.molex.com).

75705 Series Numbers					
Guide Style	Columns	Assembly Order Number			
Open	10	75705-0102	75705-0103	75705-0104	75705-0105
Left End Wall		75705-0112	75705-0113	75705-0114	75705-0115
Dual End Wall		75705-0122	75705-0123	75705-0124	75705-0125
Right End Wall		75705-0132	75705-0133	75705-0134	75705-0135
Open		75705-1102	75705-1103	75705-1104	75705-1105
Left End Wall		75705-1112	75705-1113	75705-1114	75705-1115
Dual End Wall		75705-1122	75705-1123	75705-1124	75705-1125
Right End Wall		75705-1132	75705-1133	75705-1134	75705-1135
Guide Left		10	75705-2102	75705-2103	75705-2104
	75705-2112		75705-2113	75705-2114	75705-2115
	75705-2122		75705-2123	75705-2124	75705-2125
	75705-2132		75705-2133	75705-2134	75705-2135
	75705-2142		75705-2143	75705-2144	75705-2145
	75705-2152		75705-2153	75705-2154	75705-2155
	75705-2162		75705-2163	75705-2164	75705-2165
	75705-2172		75705-2173	75705-2174	75705-2175
	75705-2182		75705-2183	75705-2184	75705-2185
	75705-3102		75705-3103	75705-3104	75705-3105
	75705-3112		75705-3113	75705-3114	75705-3115
	75705-3122		75705-3123	75705-3124	75705-3125
	75705-3132		75705-3133	75705-3134	75705-3135
	75705-3142		75705-3143	75705-3144	75705-3145
	75705-3152		75705-3153	75705-3154	75705-3155
	75705-3162		75705-3163	75705-3164	75705-3165
	75705-3172		75705-3173	75705-3174	75705-3175
	75705-3182		75705-3183	75705-3184	75705-3185
Guide Right	10	75705-4102	75705-4103	75705-4104	75705-4105
		75705-4112	75705-4113	75705-4114	75705-4115
		75705-4122	75705-4123	75705-4124	75705-4125

75705 Series Numbers					
Guide Style	Columns	Assembly Order Number			
Guide Right	10	75705-4132	75705-4133	75705-4134	75705-4135
		75705-4142	75705-4143	75705-4144	75705-4145
		75705-4152	75705-4153	75705-4154	75705-4155
		75705-4162	75705-4163	75705-4164	75705-4165
		75705-4172	75705-4173	75705-4174	75705-4175
		75705-4182	75705-4183	75705-4184	75705-4185
		75705-5102	75705-5103	75705-5104	75705-5105
		75705-5112	75705-5113	75705-5114	75705-5115
		75705-5122	75705-5123	75705-5124	75705-5125
		75705-5132	75705-5133	75705-5134	75705-5135
		75705-5142	75705-5143	75705-5144	75705-5145
		75705-5152	75705-5153	75705-5154	75705-5155
		75705-5162	75705-5163	75705-5164	75705-5165
		75705-5172	75705-5173	75705-5174	75705-5175
		75705-5182	75705-5183	75705-5184	75705-5185
		Guide Left With End Wall	10	75705-6102	75705-6103
75705-6112	75705-6113			75705-6114	75705-6115
75705-6122	75705-6123			75705-6124	75705-6125
75705-6132	75705-6133			75705-6134	75705-6135
75705-6142	75705-6143			75705-6144	75705-6145
75705-6152	75705-6153			75705-6154	75705-6155
75705-6162	75705-6163			75705-6164	75705-6165
75705-6172	75705-6173			75705-6174	75705-6175
75705-6182	75705-6183			75705-6184	75705-6185
75705-7102	75705-7103			75705-7104	75705-7105
75705-7112	75705-7113			75705-7114	75705-7115
75705-7122	75705-7123			75705-7124	75705-7125
75705-7132	75705-7133			75705-7134	75705-7135
75705-7142	75705-7143			75705-7144	75705-7145
75705-7152	75705-7153			75705-7154	75705-7155
75705-7162	75705-7163			75705-7164	75705-7165
75705-7172	75705-7173	75705-7174	75705-7175		
75705-7182	75705-7183	75705-7184	75705-7185		
Guide Right With End Wall	10	75705-8102	75705-8103	75705-8104	75705-8105
		75705-8112	75705-8113	75705-8114	75705-8115
		75705-8122	75705-8123	75705-8124	75705-8125
		75705-8132	75705-8133	75705-8134	75705-8135
		75705-8142	75705-8143	75705-8144	75705-8145
		75705-8152	75705-8153	75705-8154	75705-8155
		75705-8162	75705-8163	75705-8164	75705-8165
		75705-8172	75705-8173	75705-8174	75705-8175
		75705-8182	75705-8183	75705-8184	75705-8185
		75705-9102	75705-9103	75705-9104	75705-9105
		75705-9112	75705-9113	75705-9114	75705-9115
		75705-9122	75705-9123	75705-9124	75705-9125
		75705-9132	75705-9133	75705-9134	75705-9135
		75705-9142	75705-9143	75705-9144	75705-9145
		75705-9152	75705-9153	75705-9154	75705-9155
		75705-9162	75705-9163	75705-9164	75705-9165
75705-9172	75705-9173	75705-9174	75705-9175		
75705-9182	75705-9183	75705-9184	75705-9185		

## 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 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 37.0mm (1.46 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.

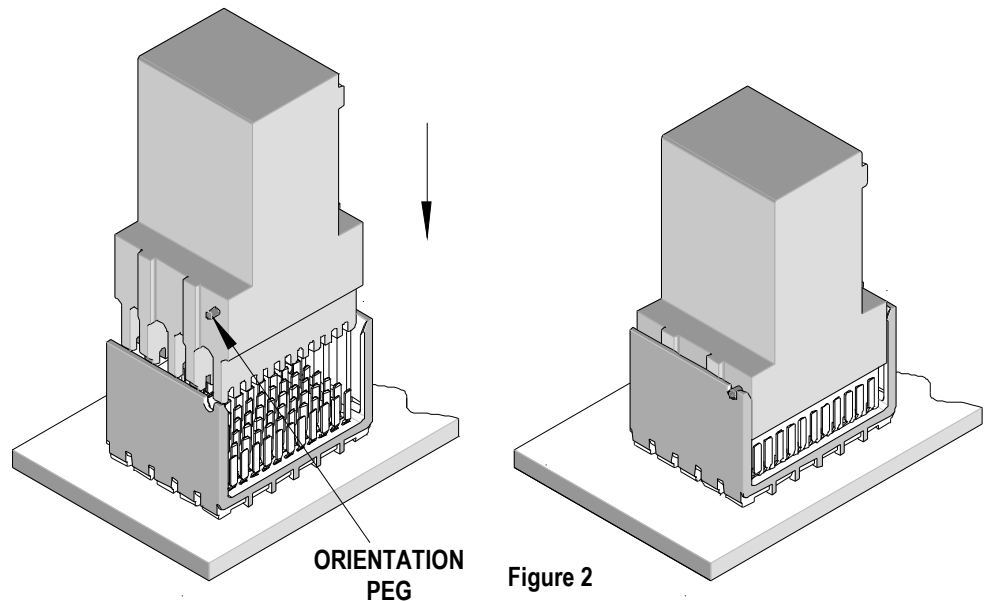


Figure 2

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.

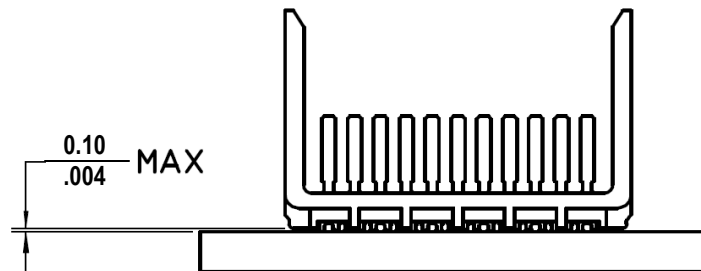


Figure 3

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.

**Americas Headquarters**  
Lisle, Illinois 60532 U.S.A.  
1-800-78MOLEX  
amerinfo@molex.com

**Far East North Headquarters**  
Yamato, Kanagawa, Japan  
81-462-65-2324  
feninfo@molex.com

**Far East South Headquarters**  
Jurong, Singapore  
65-6-268-6868  
fesinfo@molex.com

**European Headquarters**  
Munich, Germany  
49-89-413092-0  
eurinfo@molex.com

**Corporate Headquarters**  
2222 Wellington Ct.  
Lisle, IL 60532 U.S.A.  
630-969-4550  
Fax: 630-969-1352

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