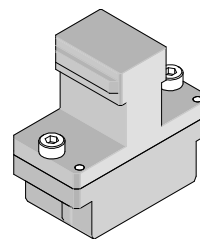


**IMPEL  
Backplane Module  
Installation  
Press-In Tool**



**Application Tooling  
Specification Sheet**



**Order No. 62201-8924**

**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
- Use tool 62201-8904 for removing connectors

**SCOPE**

Products: IMPEL Backplane Assembly, (6-Pair by 16 Column Assemblies).  
See Product List below for specific part numbers.

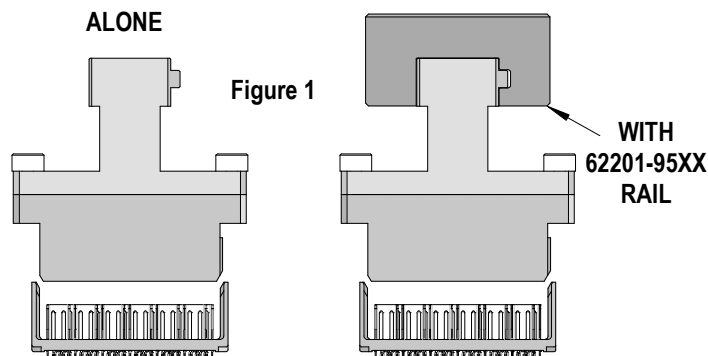
**Product List**

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).

Series	Column	Guide Style	Backplane Header Order No.					
			171395	16	Unguided	171395-1604	171395-1605	171395-1607
		Left	171395-3604	171395-3605	171395-3607	171395-3608	171395-3614	171395-3615
			171395-3617	171395-3618	171395-3624	171395-3625	171395-3627	171395-3628
			171395-3634	171395-3635	171395-3637	171395-3638	171395-3644	171395-3645
			171395-3647	171395-3648	171395-3654	171395-3655	171395-3657	171395-3658
			171395-3664	171395-3665	171395-3667	171395-3668	171395-3674	171395-3675
			171395-3677	171395-3678	171395-3684	171395-3685	171395-3687	171395-3688
		Right	171395-5604	171395-5605	171395-5607	171395-5608	171395-5614	171395-5615
			171395-5617	171395-5618	171395-5624	171395-5625	171395-5627	171395-5628
			171395-5634	171395-5635	171395-5637	171395-5638	171395-5644	171395-5645
			171395-5647	171395-5648	171395-5654	171395-5655	171395-5657	171395-5658
			171395-5664	171395-5665	171395-5667	171395-5668	171395-5674	171395-5675
			171395-5677	171395-5678	171395-5684	171395-5685	171395-5687	171395-5688

**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 31.10mm (1.22 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.

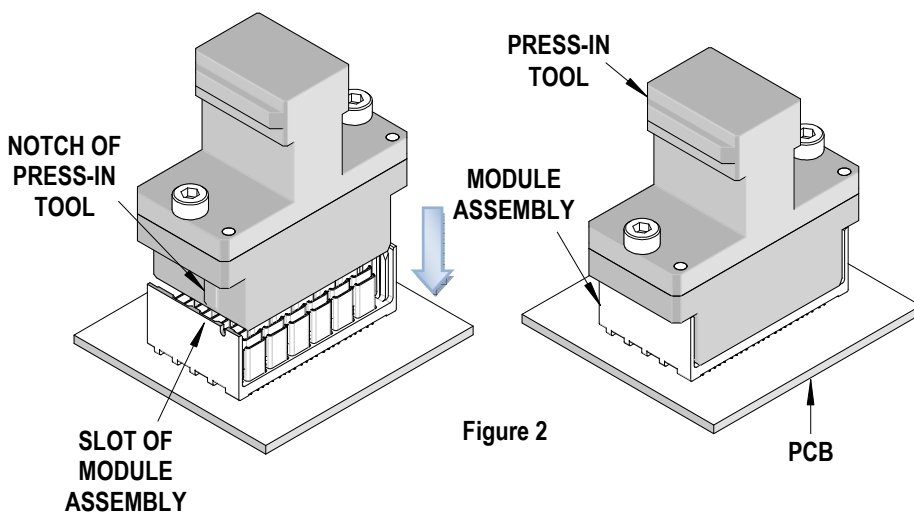
Due to the custom nature of every application, Molex does not offer any PCB support plate. The customer must furnish their own support plate.

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. Insert by hand the backplane signal module assembly (s) carefully 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 Press-In Tool making sure that the notch in this tool is inserted into the slot on top of the connector housing of the backplane signal module assembly. See 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.

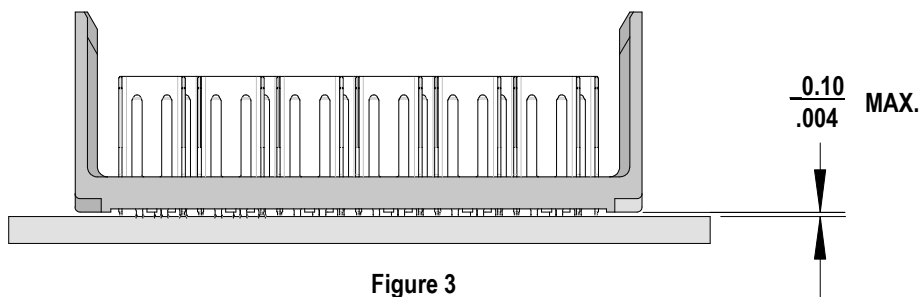


Figure 3

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.

<http://www.molex.com>