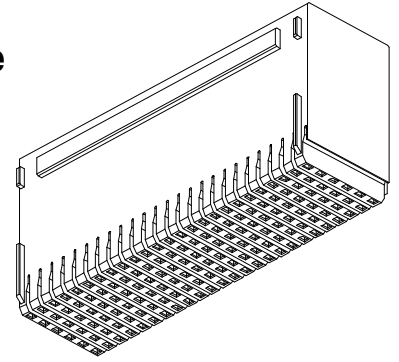




***VHDM® Backplane Signal Insertion Module
Application Tooling Specification
Press-In Tool
Order No. 62202-0208**



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 tooling holder with other Molex press-in tools.

SCOPE

Products: *VHDM® Standard Shield Signal Module Assembly, (150 Circuits), 74057, 74058, 74059, and 74074 Series 6 Rows by 25 Columns Assemblies.
2.00mm (.079") Pitch VHDM® Lite Signal Module Assembly, (150 Circuits), 75194, 75195, and 75196 Series 6 Rows by 25 Columns 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.

74057 Series Number							
Guide Style	Columns	Assembly Order Number					
Open End	6	74057-2501	74057-2502	74057-2503	74057-2504	74057-2506	74057-2507
		74057-2508	74057-2509				
		74057-2601	74057-2602	74057-2603	74057-2604	74057-2606	74057-2607
		74057-2608	74057-2609				
		74057-9001	74057-9002	74057-9003	74057-9004	74057-9006	74057-9007
		74057-9008	74057-9009				
		74057-8601	74057-8602	74057-8603	74057-8604	74057-8606	74057-8607
		74057-8608	74057-8609				

74058 Series Number							
Guide Style	Columns	Assembly Order Number					
Signal End	6	74058-2501	74058-2502	74058-2503	74058-2504	74058-2506	74058-2507
		74058-2508	74058-2509	74058-2511	74058-2512	74058-2513	74058-2514
		74058-2516	74058-2517	74058-2518	74058-2519	74058-2521	74058-2522
		74058-2523	74058-2524	74058-2526	74058-2527	74058-2528	74058-2529
		74058-2531	74058-2532	74058-2533	74058-2534	74058-2536	74058-2537
		74058-2538	74058-2539	74058-2541	74058-2542	74058-2543	74058-2544
		74058-2546	74058-2547	74058-2548	74058-2549	74058-2551	74058-2552
		74058-2553	74058-2554	74058-2556	74058-2557	74058-2558	74058-2559
		74058-2561	74058-2562	74058-2563	74058-2564	74058-2566	74058-2567
		74058-2568	74058-2569	74058-2571	74058-2572	74058-2573	74058-2574
		74058-2576	74058-2577	74058-2578	74058-2579	74058-2581	74058-2582
		74058-2583	74058-2584	74058-2586	74058-2587	74058-2588	74058-2589
		74058-2601	74058-2602	74058-2603	74058-2604	74058-2606	74058-2607
		74058-2608	74058-2609	74058-2611	74058-2612	74058-2613	74058-2614
		74058-2616	74058-2617	74058-2618	74058-2619	74058-2621	74058-2622

74058 Series Number							
Guide Style	Columns	Assembly Order Number					
Signal End	6	74058-2623	74058-2624	74058-2626	74058-2627	74058-2628	74058-2629
		74058-2631	74058-2632	74058-2633	74058-2634	74058-2636	74058-2637
		74058-2638	74058-2639	74058-2641	74058-2642	74058-2643	74058-2644
		74058-2646	74058-2647	74058-2648	74058-2649	74058-2651	74058-2652
		74058-2653	74058-2654	74058-2656	74058-2657	74058-2658	74058-2659
		74058-2661	74058-2662	74058-2663	74058-2664	74058-2666	74058-2667
		74058-2668	74058-2669	74058-2671	74058-2672	74058-2673	74058-2674
		74058-2676	74058-2677	74058-2678	74058-2679	74058-2681	74058-2682
		74058-2683	74058-2684	74058-2686	74058-2687	74058-2688	74058-2689
		74058-8501	74058-8502	74058-8503	74058-8504	74058-8506	74058-8507
		74058-8508	74058-8509	74058-8511	74058-8512	74058-8513	74058-8514
		74058-8516	74058-8517	74058-8518	74058-8519	74058-8521	74058-8522
		74058-8523	74058-8524	74058-8526	74058-8527	74058-8528	74058-8529
		74058-8531	74058-8532	74058-8533	74058-8534	74058-8536	74058-8537
		74058-8538	74058-8539	74058-8541	74058-8542	74058-8543	74058-8544
		74058-8546	74058-8547	74058-8548	74058-8549	74058-8551	74058-8552
		74058-8553	74058-8554	74058-8556	74058-8557	74058-8558	74058-8559
		74058-8561	74058-8562	74058-8563	74058-8564	74058-8566	74058-8567
		74058-8568	74058-8569	74058-8571	74058-8572	74058-8573	74058-8574
		74058-8576	74058-8577	74058-8578	74058-8579	74058-8581	74058-8582
		74058-8583	74058-8584	74058-8586	74058-8587	74058-8588	74058-8589
		74058-8601	74058-8602	74058-8603	74058-8604	74058-8606	74058-8607
		74058-8608	74058-8609	74058-8611	74058-8612	74058-8613	74058-8614
		74058-8616	74058-8617	74058-8618	74058-8619	74058-8621	74058-8622
		74058-8623	74058-8624	74058-8626	74058-8627	74058-8628	74058-8629
		74058-8631	74058-8632	74058-8633	74058-8634	74058-8636	74058-8637
		74058-8638	74058-8639	74058-8641	74058-8642	74058-8643	74058-8644
		74058-8646	74058-8647	74058-8648	74058-8649	74058-8651	74058-8652
		74058-8653	74058-8654	74058-8656	74058-8657	74058-8658	74058-8659
		74058-8661	74058-8662	74058-8663	74058-8664	74058-8666	74058-8667
		74058-8668	74058-8669	74058-8671	74058-8672	74058-8673	74058-8674
		74058-8676	74058-8677	74058-8678	74058-8679	74058-8681	74058-8682
		74058-8683	74058-8684	74058-8686	74058-8687	74058-8688	74058-8689

74059 Series Number							
Guide Style	Columns	Assembly Order Number					
Shield End	6	74059-2501	74059-2502	74059-2503	74059-2504	74059-2506	74059-2507
		74059-2508	74059-2509	74059-2511	74059-2512	74059-2513	74059-2514
		74059-2516	74059-2517	74059-2518	74059-2519	74059-2521	74059-2522
		74059-2523	74059-2524	74059-2526	74059-2527	74059-2528	74059-2529
		74059-2531	74059-2532	74059-2533	74059-2534	74059-2536	74059-2537
		74059-2538	74059-2539	74059-2541	74059-2542	74059-2543	74059-2544
		74059-2546	74059-2547	74059-2548	74059-2549	74059-2551	74059-2552
		74059-2553	74059-2554	74059-2556	74059-2557	74059-2558	74059-2559
		74059-2561	74059-2562	74059-2563	74059-2564	74059-2566	74059-2567
		74059-2568	74059-2569	74059-2571	74059-2572	74059-2573	74059-2574
		74059-2576	74059-2577	74059-2578	74059-2579	74059-2581	74059-2582
		74059-2583	74059-2584	74059-2586	74059-2587	74059-2588	74059-2589
		74059-2601	74059-2602	74059-2603	74059-2604	74059-2606	74059-2607
		74059-2608	74059-2609	74059-2611	74059-2612	74059-2613	74059-2614
		74059-2616	74059-2617	74059-2618	74059-2619	74059-2621	74059-2622
		74059-2623	74059-2624	74059-2626	74059-2627	74059-2628	74059-2629
		74059-2631	74059-2632	74059-2633	74059-2634	74059-2636	74059-2637

74059 Series Number							
Guide Style	Columns	Assembly Order Number					
Shield End	6	74059-2638	74059-2639	74059-2641	74059-2642	74059-2643	74059-2644
		74059-2646	74059-2647	74059-2648	74059-2649	74059-2651	74059-2652
		74059-2653	74059-2654	74059-2656	74059-2657	74059-2658	74059-2659
		74059-2661	74059-2662	74059-2663	74059-2664	74059-2666	74059-2667
		74059-2668	74059-2669	74059-2671	74059-2672	74059-2673	74059-2674
		74059-2676	74059-2677	74059-2678	74059-2679	74059-2681	74059-2682
		74059-2683	74059-2684	74059-2686	74059-2687	74059-2688	74059-2689
		74059-8501	74059-8502	74059-8503	74059-8504	74059-8506	74059-8507
		74059-8508	74059-8509	74059-8511	74059-8512	74059-8513	74059-8514
		74059-8516	74059-8517	74059-8518	74059-8519	74059-8521	74059-8522
		74059-8523	74059-8524	74059-8526	74059-8527	74059-8528	74059-8529
		74059-8531	74059-8532	74059-8533	74059-8534	74059-8536	74059-8537
		74059-8538	74059-8539	74059-8541	74059-8542	74059-8543	74059-8544
		74059-8546	74059-8547	74059-8548	74059-8549	74059-8551	74059-8552
		74059-8553	74059-8554	74059-8556	74059-8557	74059-8558	74059-8559
		74059-8561	74059-8562	74059-8563	74059-8564	74059-8566	74059-8567
		74059-8568	74059-8569	74059-8571	74059-8572	74059-8573	74059-8574
		74059-8576	74059-8577	74059-8578	74059-8579	74059-8581	74059-8582
		74059-8583	74059-8584	74059-8586	74059-8587	74059-8588	74059-8589
		74059-8601	74059-8602	74059-8603	74059-8604	74059-8606	74059-8607
		74059-8608	74059-8609	74059-8611	74059-8612	74059-8613	74059-8614
		74059-8616	74059-8617	74059-8618	74059-8619	74059-8621	74059-8622
		74059-8623	74059-8624	74059-8626	74059-8627	74059-8628	74059-8629
		74059-8631	74059-8632	74059-8633	74059-8634	74059-8636	74059-8637
		74059-8638	74059-8639	74059-8641	74059-8642	74059-8643	74059-8644
		74059-8646	74059-8647	74059-8648	74059-8649	74059-8651	74059-8652
		74059-8653	74059-8654	74059-8656	74059-8657	74059-8658	74059-8659
		74059-8661	74059-8662	74059-8663	74059-8664	74059-8666	74059-8667
		74059-8668	74059-8669	74059-8671	74059-8672	74059-8673	74059-8674
		74059-8676	74059-8677	74059-8678	74059-8679	74059-8681	74059-8682
		74059-8683	74059-8684	74059-8686	74059-8687	74059-8688	74059-8689

74074 Series Number							
Guide Style	Columns	Assembly Order Number					
Custom	6	74074-0003	74074-0004	74074-0005	74074-0006	74074-0011	74074-0012
		74074-0016	74074-0017	74074-0018	74074-0024	74074-0025	74074-0026
		74074-0027	74074-0028	74074-0029	74074-0030	74074-0031	74074-0032
		74074-0033	74074-0039	74074-0040	74074-0051	74074-0052	74074-0053
		74074-0054	74074-0067	74074-0071	74074-0072	74074-0073	74074-0074
		74074-0075	74074-0076	74074-0077	74074-0082	74074-0083	74074-0084
		74074-0085	74074-0091	74074-0093	74074-0098	74074-0099	74074-0101
		74074-0102	74074-0104	74074-0110	74074-0112	74074-0114	74074-0116
		74074-0126	74074-0130	74074-0133	74074-0140	74074-0142	74074-0146
		74074-0149	74074-0150	74074-0165	74074-0166	74074-0167	74074-0168
		74074-0170	74074-0176	74074-0177	74074-0178	74074-0180	74074-0185
		74074-0187	74074-0189	74074-0190	74074-0196	74074-0199	74074-0202
		74074-0203	74074-0204	74074-0205	74074-0206	74074-0210	74074-0214
		74074-0218	74074-0219	74074-0220	74074-0221	74074-0237	74074-0238
		74074-0240	74074-9860	74074-9870	74074-9871	74074-9884	74074-9890
		74074-9891	74074-9948	74074-9949	74074-9973	74074-9983	74074-9994

75194 Series Number							
Guide Style	Columns	Assembly Order Number					
Open End	6	75194-2501	75194-2502	75194-2503	75194-2504	75194-2506	75194-2507
		75194-2508	75194-2509				
		75194-8501	75194-8502	75194-8503	75194-8504	75194-8506	75194-8507
		75194-8508	75194-8509				

75195 Series Number							
Guide Style	Columns	Assembly Order Number					
Left	6	75195-2501	75195-2502	75195-2503	75195-2504	75195-2511	75195-2512
		75195-2513	75195-2514	75195-2521	75195-2522	75195-2523	75195-2524
		75195-2531	75195-2532	75195-2533	75195-2534	75195-2541	75195-2542
		75195-2543	75195-2544	75195-2551	75195-2552	75195-2553	75195-2554
		75195-2561	75195-2562	75195-2563	75195-2564	75195-2571	75195-2572
		75195-2573	75195-2574	75195-2581	75195-2582	75195-2583	75195-2584
		75195-8501	75195-8502	75195-8503	75195-8504	75195-8511	75195-8512
		75195-8513	75195-8514	75195-8521	75195-8522	75195-8523	75195-8524
		75195-8531	75195-8532	75195-8533	75195-8534	75195-8541	75195-8542
		75195-8543	75195-8544	75195-8551	75195-8552	75195-8553	75195-8554
		75195-8561	75195-8562	75195-8563	75195-8564	75195-8571	75195-8572
		75195-8573	75195-8574	75195-8581	75195-8582	75195-8583	75195-8584

75196 Series Number							
Guide Style	Columns	Assembly Order Number					
Left	6	75196-2501	75196-2502	75196-2503	75196-2504	75196-2511	75196-2512
		75196-2513	75196-2514	75196-2521	75196-2522	75196-2523	75196-2524
		75196-2531	75196-2532	75196-2533	75196-2534	75196-2541	75196-2542
		75196-2543	75196-2544	75196-2551	75196-2552	75196-2553	75196-2554
		75196-2561	75196-2562	75196-2563	75196-2564	75196-2571	75196-2572
		75196-2573	75196-2574	75196-2581	75196-2582	75196-2583	75196-2584
		75196-8501	75196-8502	75196-8503	75196-8504	75196-8511	75196-8512
		75196-8513	75196-8514	75196-8521	75196-8522	75196-8523	75196-8524
		75196-8531	75196-8532	75196-8533	75196-8534	75196-8541	75196-8542
		75196-8543	75196-8544	75196-8551	75196-8552	75196-8553	75196-8554
		75196-8561	75196-8562	75196-8563	75196-8564	75196-8571	75196-8572
		75196-8573	75196-8574	75196-8581	75196-8582	75196-8583	75196-8584

*VHDM® is a registered trademark of Teradyne, Inc.

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 tooling holder (ordered separately). See Figure 1.

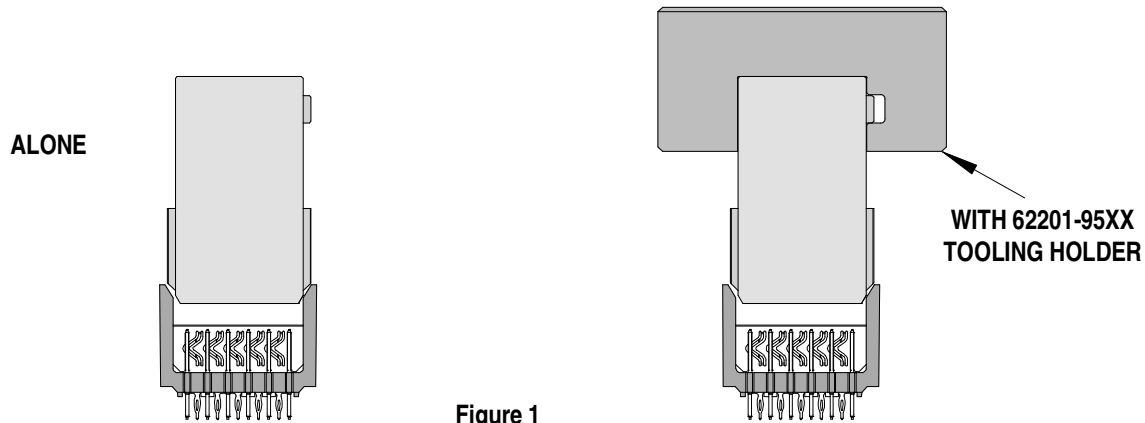


Figure 1

Tool Installation

The 62201-95XX tooling holder is available in a variety of lengths to accommodate multiple press-in tools.

Tooling Holder 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: The 62202-0208 Press-In Tool is 49.9mm (1.966 in.) long by 25.0mm (.984 in.) high.

Printed Circuit Board (PCB) Support

The *VHDM® connectors requires a large amount 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.

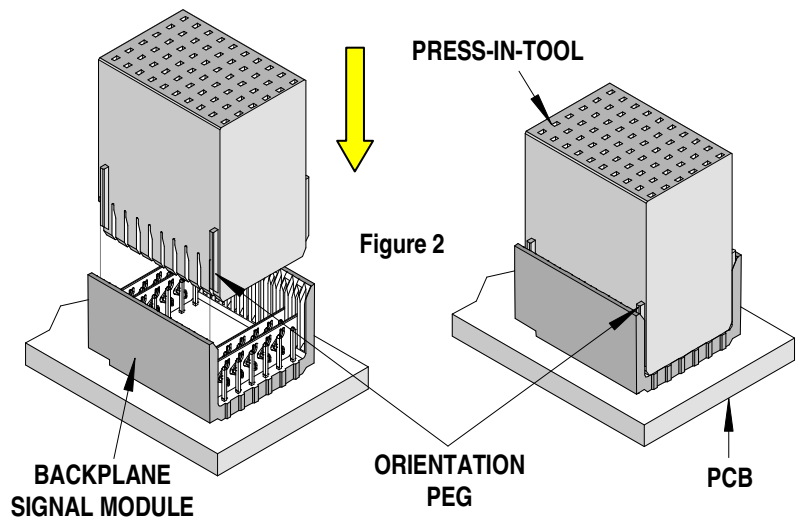
Press Equipment Recommendations

Many types of presses can be used to install *VHDM® connectors, but to assure consistent connector installation Molex recommends the following press criteria:

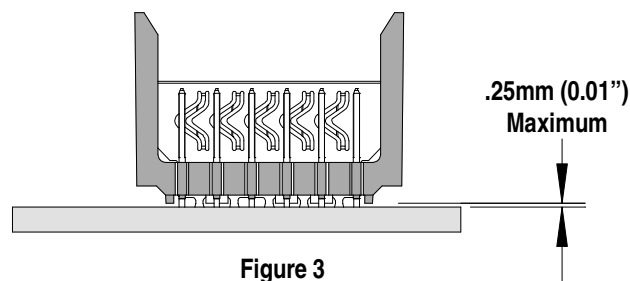
1. The capability to detect force variations as low as 4.5kg (10 lb) during the press-in cycle; excessive force measurements should stop the press-in cycle.
2. The rate of pressing can be regulated as low as 0.13mm (0.005 in) per second.
3. Press stroke control to within 0.25mm (0.010 in).
4. Total press 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.
2. Insert the press-in-tool into the backplane signal module assembly with the orientation peg on the tool entering the groove in the connector housing. Make sure all the pins and shields fit into the proper slots. See Figure 2.



3. Using the application tool and an appropriate press, seat the header assembly until there is less than 0.25mm (0.01 in) clearance between the bottom of the plastic housing and the surface of the PCB. See Figure 3.



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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