Impact™ ZX2 DC and RAM Press-In Tool	**molex®** **Application Tooling Specification Sheet**	
		Order No. 200214-0009
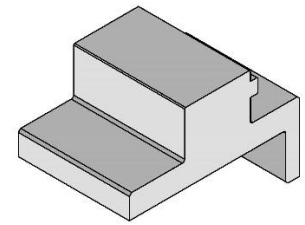
FEATURES

- Lip provided for positive alignment to connector assembly
- Tool provides uniform distribution of press force across entire pin array
- May be used as a standalone tool or mounted in an optional holder with other Molex press-in tools

SCOPE

Products: Impact™ ZX2 Daughtercard and Right Angle Male Assemblies (8-Pair by 12 Column). See Product List below for specific part numbers.

Product List
The following is a partial list of the product order numbers and their specifications that this tool is designed to run. Updates to this list are available on www.molex.com.

Series No.	Columns	Assembly Order Number	
173510		173510-0012	173510-0052
173520	12	173520-0205	
173630		173630-0205	173630-0206

Tool Setup

Depending on the number of connectors to be installed 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.

PRESS-IN TOOL

ALONE

CONNECTOR ASSEMBLY

PRESS-IN TOOL

WITH 62201-95XX RAIL

Figure 1
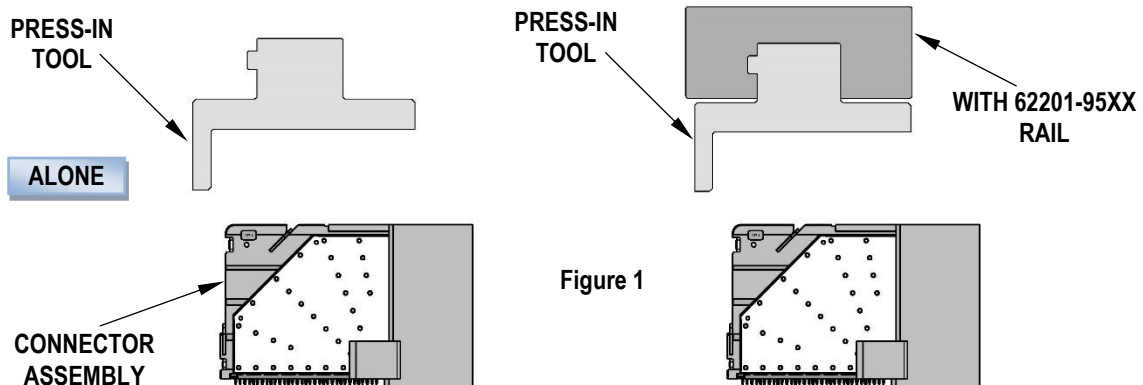
Tool Installation

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 24mm (0.94 in.) long.

Printed Circuit Board (PCB) Support

The Impact™ connectors require up to 3.6kg (8 lb) of force per pin to press into the PCB. To prevent excessive PCB flexure 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. Customers must furnish their own support plates.

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 Impact™ connectors, but to assure consistent connector installation, Molex recommends the following press criteria:

1. Presses should have 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 should be within 0.25mm (0.010 in).
4. The total press stroke must be at least 19mm (0.75 in).
5. For statistical purposes, presses should automatically collect force and distance data.

Tool Operation

1. Carefully insert, by hand, the Orthogonal Direct Ram module(s) into the PCB hole pattern.
2. Place the application tool on top of the Orthogonal Direct Ram module with the back guide surface of the tool against the back of the Orthogonal Direct Ram module. See Figure 2.

GUIDE SURFACE

PRESS-IN TOOL

CONNECTOR ASSEMBLY

PCB

PCB
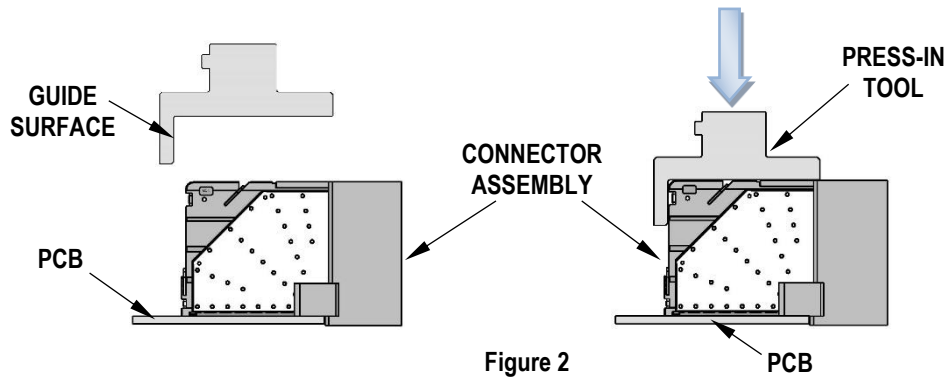
Figure 2

3. Using the application tool and an appropriate press, seat the Orthogonal Direct Ram module 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.

0.10mm **MAX.**
.004 in.

PCB   **Figure 3**
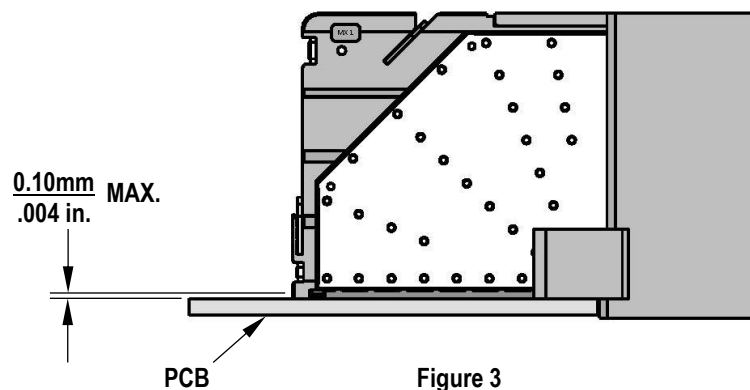
There should be no broken stand-offs along the perimeter of the part (an indication of over-pressing).

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.

Application Tooling Support

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