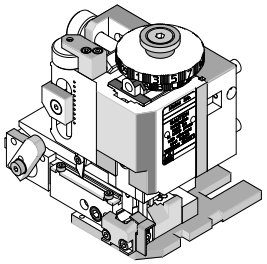
Order Number
203702-0300

molex®

Application Tooling Specification



FEATURES

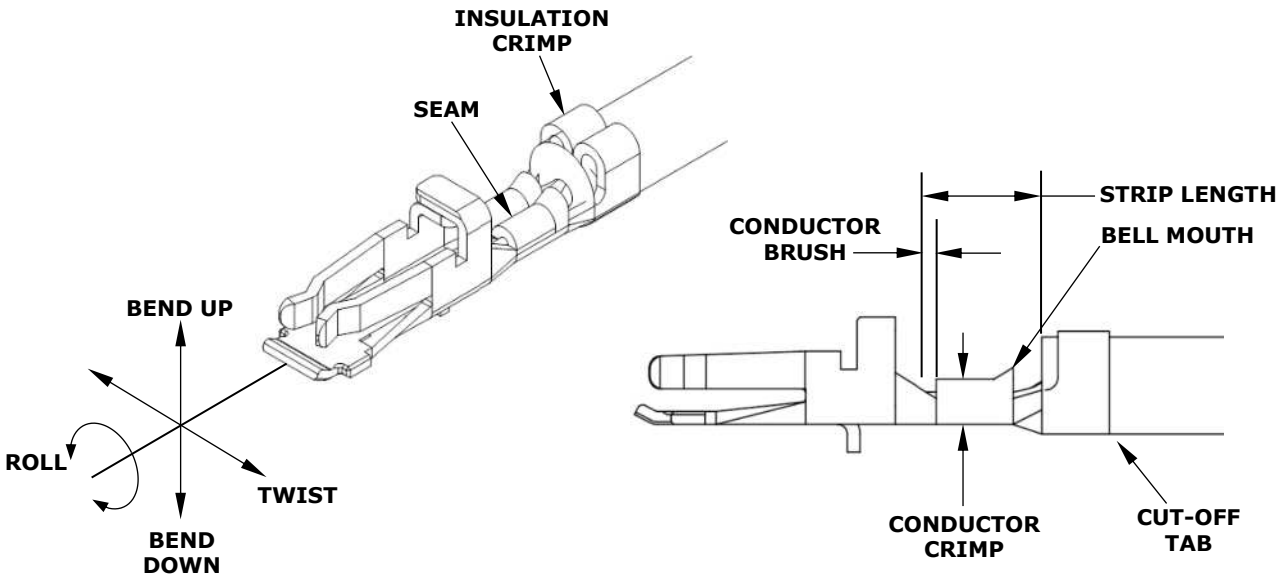
- Quick punch removal with the push of a button for fast and easy tooling change
- Applicator designed to industry-standard mounting and 135.80mm (5.346”) shut height
- Quick setup time; plus, the crimp height, track and feed adjustments can be set without removing the applicator from the press
- Fine adjustment allows users to achieve target with little effort by adjusting in increments of 0.015mm (.0006”) for conductor crimp height and 0.063mm (.0025”) for insulation height
- Independent adjustment rings allow users to quickly adjust the conductor or insulation crimp height without affecting each other
- Directly adapts to most automatic wire processing machines
- This tool is IPC/WHMA-A-620 Class 2 compliant, as indicated below

SCOPE

Products: Spot-On 2.0 Female Crimp Terminal, 22-26 AWG Wire.

Terminal Series No.	Terminal Order No.	Wire		Insulation Diameter				Strip Length	
				IPC/WHMA-A-620 (1)		Terminal (2)			
		Wire Type	Size	mm	In.	mm	In.	mm	In.
201195	201195-6000	UL1007	22-26 AWG	1.60 (Max)	.063 (Max)	1.25-1.60	.049-.063	1.90-2.10	.075-.083
(1) To achieve optimum IPC/WHMA-A-620 insulation crimps, use this insulation OD range. **(2)** Overall insulation OD specification for terminal.									

DEFINITION OF TERMS



CRIMP SPECIFICATION

Terminal Series No.	Bell Mouth		Cut-Off Tab Maximum		Conductor Brush	
	mm	In.	mm	In.	mm	In.
201195	0.10-0.45	.004-.018	0.10	.004	0.65	.026

Terminal Series No.	Bend Up	Bend Down	Twist	Roll	Punch Width (Ref)				Seam
					Conductor		Insulation		
	Degree (Max)		Degree (Max)		mm	In.	mm	In.	
201195	3	2	3	4	1.10-1.20	.043-.047	1.40-1.50	.055-.059	Seam shall not be open and no wire allowed out of the crimping area

After crimping, the conductor profile should measure the following:

Terminal Series No.	Wire Size	Conductor Crimp Height		Insulation Crimp Height (Ref)		Pull Force Minimum	
	AWG	mm	In.	mm	In.	N	Lb.
201195	22	0.78-0.83	.031-.033	1.85-1.95	.073-.077	39.2	8.8
	24	0.70-0.75	.028-.030	1.80-1.90	.071-.075	29.4	6.6
	26	0.65-0.70	.026-.028	1.70-1.85	.067-.073	19.6	4.4

Tool Qualification Notes

1. Pull force should be measured with no influence from the insulation crimp.
2. The above specifications are guidelines to an optimum crimp.
3. Terminal Oiler (63801-7240) will improve tooling life and minimize crimp extrusions. See 63800-4900 FineAdjust manual.

NOTES

1. Molex recommends that an extra perishable tooling kit be maintained at your facility.
2. Verify tooling alignment by manually cycling the press and applicator before crimping under power. Check that all screws are tight.
3. Slugs, terminals, dirt and oil should be kept clear of the work area.
4. Wear safety glasses at all times.
5. For recommended maintenance, refer to the FineAdjust manual.

CAUTION: This applicator should only be used in a press with a shut height of 135.8mm (5.346”). Tooling damage could result at a lower setting.

CAUTION: To prevent injury, never operate this applicator without the guards supplied with the press or wire-processing machine in place. Reference the press or wire processing manufacturer’s instruction manual.

CAUTION: Molex crimp specifications are valid only when used with Molex terminals, applicators and tooling.

PARTS LIST

FineAdjust Applicator 203702-0300				
Item	**Order No.**	**Engineering No.**	**Description**	**Quantity**
Perishable Tooling				
	203702-0370	203702-0370	Tool Kit (All "Y" Items)	REF
1	200219-1501	200219-1501	Insulation Punch	1 Y
2	200216-1201	200216-1201	Conductor Punch	1 Y
3	200221-1501	200221-1501	Insulation Anvil	1 Y
4	200217-1201	200217-1201	Conductor Anvil	1 Y
5	63443-0005	63443-0005	Cut-Off Plunger	1 Y
6	63443-0012	63443-0012	Front Plunger Retainer	1 Y
Other Components				
7	11-18-4083	60707-8	Feed Guide	1
8	11-24-1067	4996-4	Cut-Off Plunger Spring	1
9	63443-0117	63443-0117	Front Scrap Chute	1
10	63443-0024	63443-0024	Lower Tooling Key	1
11	63443-0090	63443-0090	Wire Stop Assembly	1
12	63443-7406	63443-7406	Terminal Hold Down Mount	1
13	63600-5776	63600-5776	Stopper Bolt	1
14	200213-7503	200213-7503	Anvil Mount	1
15	63443-2807	63443-2807	Front Plunger Striker	1
16	63443-2905	63443-2905	Wire Hold Down Plunger	1
17	63443-6110	63443-6110	Rear Cover	1
18	63600-0021	63600-0021	Wire Hold Down Spring	1
Frame				
19	63800-4901	63800-4901	Top	1
20	63801-3281	63801-3281	Base	1
21	63801-4650	63801-4650	Track	1
Hardware				
22	—	—	M3 by 6 Long SHCS	2*
23	—	—	M3 by 6 Long FHCS	1*
24	—	—	M4 by 6 Long SHCS	2*
25	—	—	M4 by 10 Long SHCS	1*
26	—	—	M4 by 12 Long BHCS	2*
27	—	—	M4 by 45 Long SHCS	2*
28	—	—	M5 by 12 Long SHCS	1*
29	—	—	#10-32 by 3/8" Long Flat Point SSS	1*
30	—	—	#10-32 Hex Jam Nut	1*
* Available from an industrial supply company.				

ASSEMBLY DRAWING

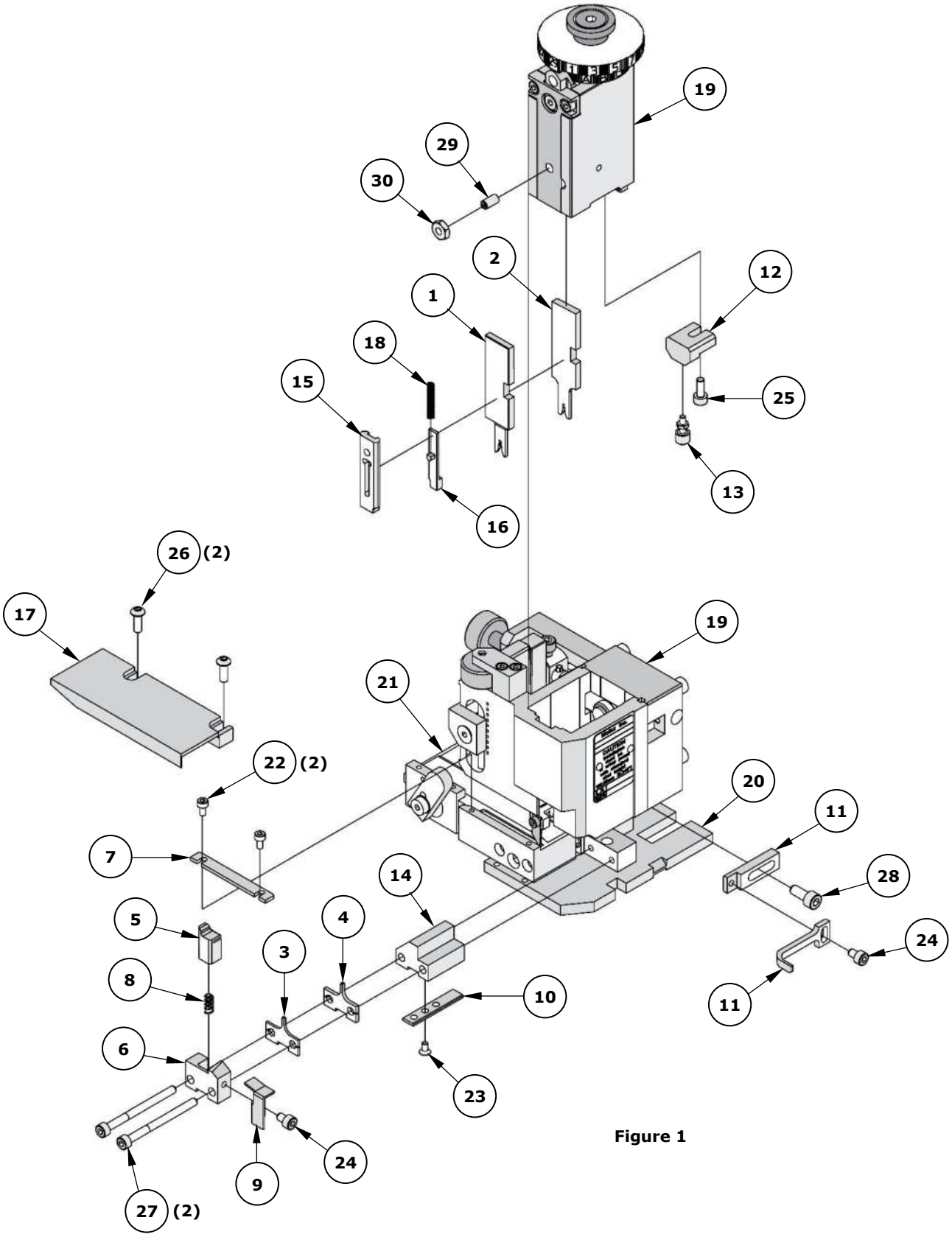


Figure 1

Application Tooling Support

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