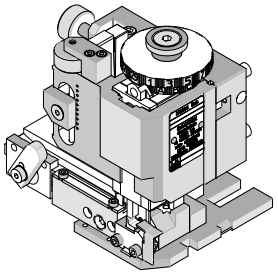
Order Number
203702-4200

molex®

Application Tooling Specification



FEATURES

- Directly adapts to most automatic wire processing machines
- 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 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 .015mm (.0006") for conductor crimp height and .063mm (.0025") for insulation height
- Independent adjustment rings allow users to quickly adjust the conductor or insulation crimp height without affecting each other

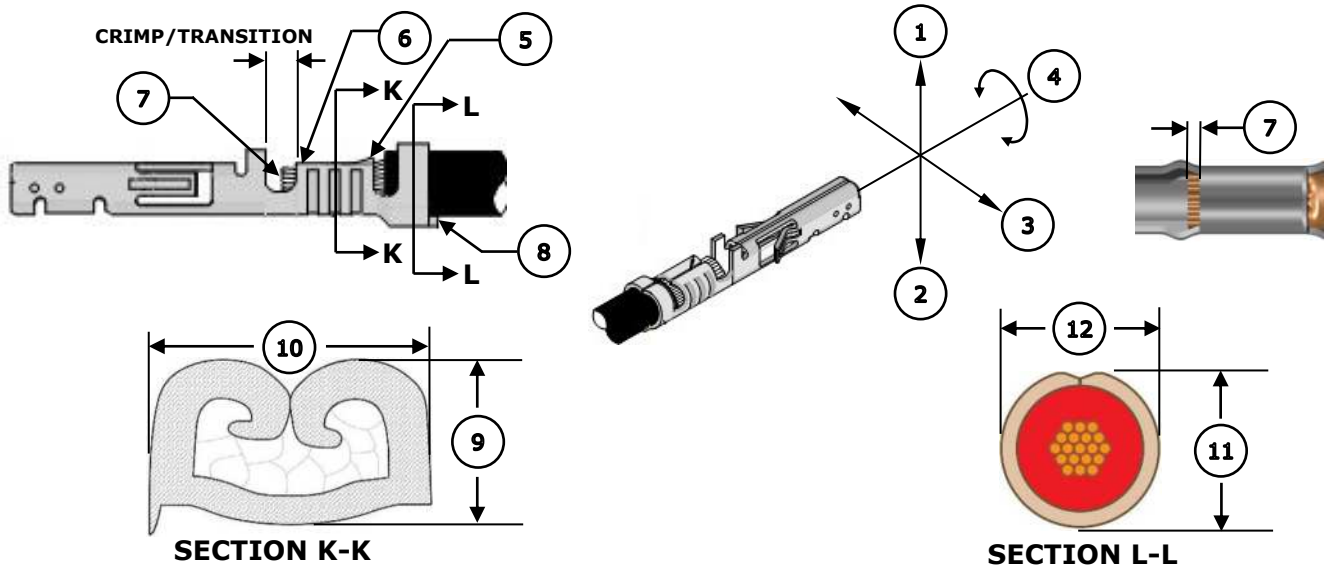
SCOPE

Products: Mega-Fit Wire-to-Wire Male and Female Crimp Terminals, 10 AWG.

Terminal Series No.	Terminal Order No.	Wire Size and Type		Insulation Diameter IPC/WHMA-A-620 (1)		Strip Length	
		AWG	Type	mm	In.	mm	In.
76823	76823-0345	10	UL11028	3.40-3.60	.134-.142	5.0-6.0	.20-.24
105417	105417-0332						
105418	105418-0312						
	105418-1312						
172063	172063-0335						
	172063-1335						

(1) To achieve optimum IPC/WHMA-A-620 Class 2 insulation crimps, use this insulation OD range.

DEFINITION OF TERMS



Note: Image above is a generic terminal representation. The actual terminals of the scope may look different.

CRIMP SPECIFICATION

Feature	Requirement					
1. Bend Up	3° Max					
2. Bend Down	3° Max					
3. Twist	4° Max					
4. Roll	8° Max					
5. Bell Mouth Rear	0.60-1.20mm (.024-.048”)					
6. Bell Mouth Front	Not Applicable					
7. Conductor Brush	0.10-0.76mm (.004-.030”)					
8. Cut-Off Tab	0.20mm (.008”) Max					
Conductor Crimp	**Terminal Order No.**	**Wire Size**	**9. Crimp Height**		**10. Crimp Width (Ref)**	
	76823-0345 105417-0332 105418-0312 105418-1312 172063-0335 172063-1335	10 AWG	2.40-2.50mm	.094-.098 in	3.50mm	.138 in
Insulation Crimp	**Terminal Order No.**	**Wire Size**	**11. Crimp Height (Ref)**		**12. Crimp Width (Ref)**	
	76823-0345 105417-0332 105418-0312 105418-1312 172063-0335 172063-1335	10 AWG UL11028	4.15mm	.163 in	4.17mm	.164 in
Pull Force	**Terminal Order No.**	**Wire Size**	**Minimum Pull Force**			
	76823-0345 105417-0332 105418-0312 105418-1312 172063-0335 172063-1335	10 AWG	356 N	80 lbf	To be measured with no influence from the insulation crimp.	

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.

PARTS LIST

FineAdjust Applicator 203702-4200				
Item	**Order No.**	**Engineering No.**	**Description**	**Quantity**
Perishable Tooling				
	203702-4270	203702-4270	Tool Kit (All "Y" Items)	REF
1	200216-3401	200216-3401	Conductor Punch	1 Y
2	200217-3401	200217-3401	Conductor Anvil	1 Y
3	200220-4101	200220-4101	Insulation Punch	1 Y
4	200221-4101	200221-4101	Insulation Anvil	1 Y
5	63443-0002	63443-0002	Cut-Off Plunger	1 Y
6	63443-0012	63443-0012	Front Plunger Retainer	1 Y
Other Components				
7	11-17-0022	1739-21	Hold Down Spring	1
8	11-18-4083	60707-8	Feed Guide	1
9	11-24-1067	4996-4	Cut-Off Plunger Spring	1
10	63443-0009	63443-0009	Front Scrap Chute	1
11	63443-0024	63443-0024	Key	1
12	63443-0086	63443-0086	Wire Stop Base	1
13	63443-0093	63443-0093	Shank	1
14	200213-7525	200213-7525	Anvil Mount	1
15	63443-3160	63443-3160	Front Plunger Striker	1
16	63443-6125	63443-6125	Rear Cover	1
17	63443-7136	63443-7136	Terminal Hold Down	1
18	63443-0157	63443-0157	Target – Brush Control	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	—	—	M3 by 8 Long SHCS	1*
25	—	—	M4 by 6 Long SHCS	2*
26	—	—	M4 by 12 Long BHCS	2*
27	—	—	M4 by 50 Long SHCS	2*
28	—	—	M5 by 12 Long SHCS	1*
29	—	—	M5 by 10 Long Flat Point SSS	1*
30	—	—	M5 Hex Jam Nut	1*
* Available from an industrial supply company.				

ASSEMBLY DRAWING

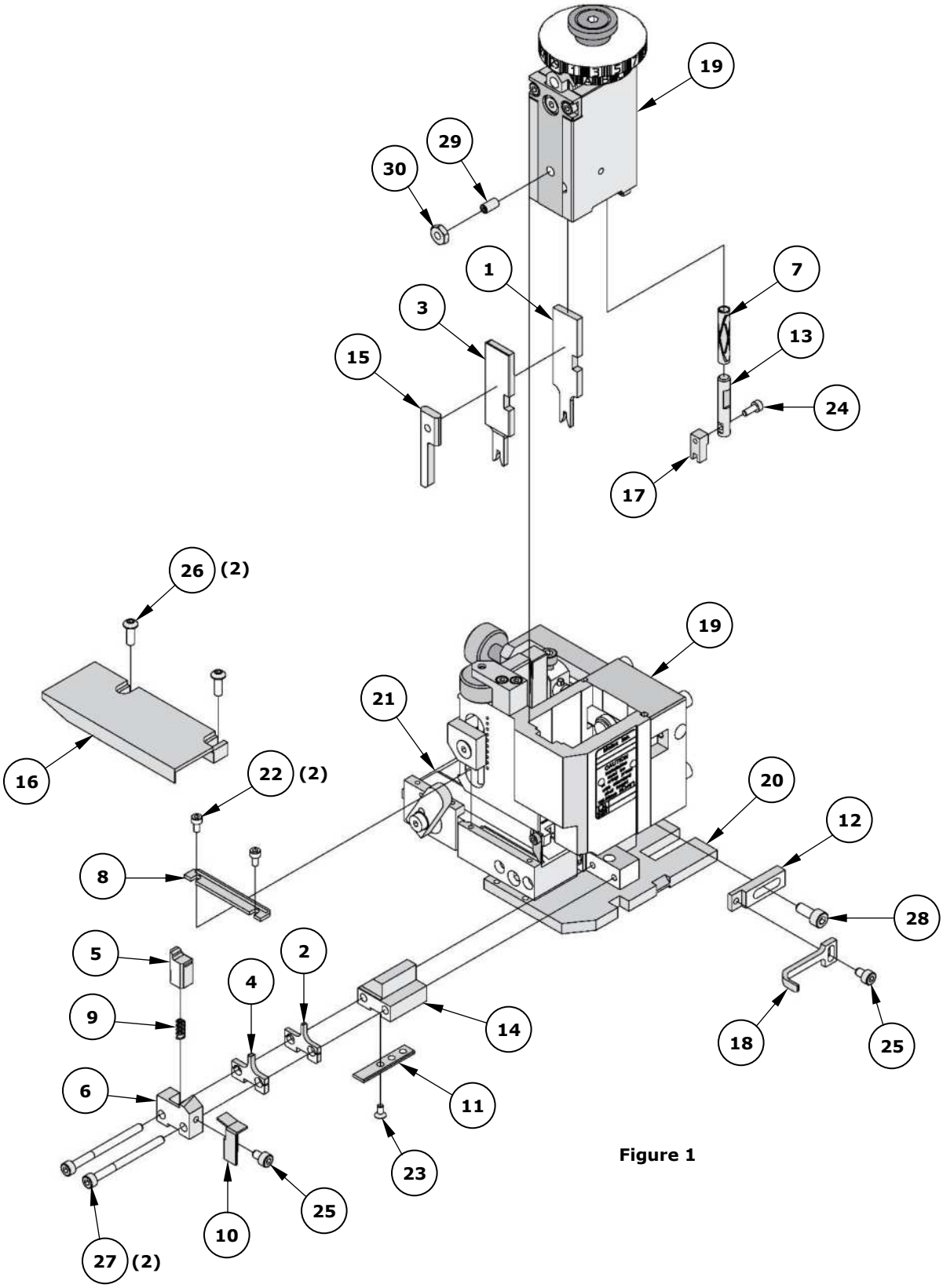


Figure 1

NOTES

1. Molex recommends that an extra perishable tooling kit be maintained at your facility.
2. Verify tooling alignment by hand 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.

WARNINGS

CAUTION: This applicator must be installed in a press with a standard shut height of 135.80mm (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 tooling crimp specifications are valid only when used with Molex terminals and tooling manufactured by Molex and sold by Molex or authorized distributors (“Molex Tooling”). When using tooling other than Molex Tooling with Molex-specific connector systems listed in our ATS documents, the Molex Tooling qualification does not apply, and the responsibility for full qualification of the connector system is that of the customer. Molex accepts no liability for connector performance or tooling support where tooling other than Molex Tooling is used or where Molex Tooling is modified.

Application Tooling Support

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