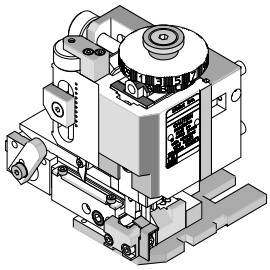
Order Number
63904-6600

molex®

Application Tooling Specification



FEATURES

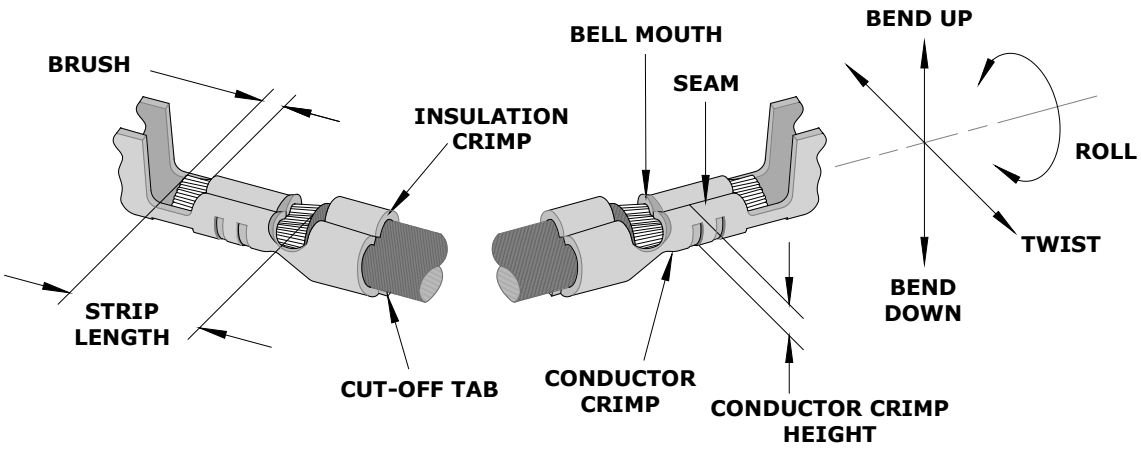
- Directly adapts to most automatic wire processing machines
- Quick punch removal with the push of a button for fast and easy tooling change
- Applicator designed to industry standard mounting and 135.80mm (5.346") shut height
- Quick setup time; plus, the crimp height, track and feed adjustments can 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

SCOPE

Products: Micro-Fit 3.0 Crimp Terminal, Male and Female, 26-30 AWG.

Terminal Series No.	Terminal Order No.			Wire Size		× Insulation Diameter		Strip Length	
				AWG	mm²	mm	In.	mm	In.
43030	43030-0004	43030-0005	43030-0006	26-30	0.12-0.05	0.63-1.10	.025-.043	2.54-2.92	.100-.115
43031	43031-0004	43031-0005	43031-0006	26-30	0.12-0.05	0.63-1.10	.025-.043	2.54-2.92	.100-.115
	43031-5007								
45773	45773-0004	45773-0005	45773-0006	26-30	0.12-0.05	0.63-1.10	.025-.043	2.54-2.92	.100-.115
× This applicator will crimp small wire insulation diameter shown above. Applicator 63900-4400 should be used for insulation OD 1.12-1.27mm (.044-.050”).									

DEFINITION OF TERMS



The above terminal drawing is a generic terminal representation. It is not an image of a terminal listed in the scope.

CRIMP SPECIFICATION

Terminal Series No.	Bell Mouth		Cut-Off Tab Maximum		Conductor Brush	
	mm	In.	mm	In.	mm	In.
43030	0.05-0.40	.002-.016	0.15	.006	0.20-0.80	.008-.031
43031	0.05-0.40	.002-.016	0.15	.006	0.20-0.80	.008-.031
45773	0.05-0.40	.002-.016	0.15	.006	0.20-0.80	.008-.031

Terminal Series No.	Bend Up	Bend Down	Twist	Roll	Punch Width mm (Ref)				Seam
	Degree		Degree		Conductor		Insulation		
					mm	In.	mm	In.	
43030	3	3	4	8	1.10	.043	1.40	.055	Seam shall not be open and no wire allowed out of the crimping area
43031	3	3	4	8	1.10	.043	1.40	.055	
45773	3	3	4	8	1.10	.043	1.40	.055	

After crimping, the conductor profile should measure the following:

Terminal Series No.	Wire Size		Crimp Height		Pull Force Minimum	
	AWG	mm^2	mm	In.	N	Lb.
43030	26	0.12	0.74-0.79	.029-.031	13.4	3.0
	28	0.08	0.71-0.76	.028-.030	8.9	2.0
	30	0.05	0.69-0.74	.027-.029	6.7	1.5
43031	26	0.12	0.74-0.79	.029-.031	13.4	3.0
	28	0.08	0.71-0.76	.028-.030	8.9	2.0
	30	0.05	0.69-0.74	.027-.029	6.7	1.5
45773	26	0.12	0.74-0.79	.029-.031	13.4	3.0
	28	0.08	0.71-0.76	.028-.030	8.9	2.0
	30	0.05	0.69-0.74	.027-.029	6.7	1.5

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 63904-6600				
Item	**Order No.**	**Engineering No.**	**Description**	**Quantity**
Perishable Tooling				
	63904-6670	63904-6670	Tool Kit (All "Y" Items)	REF
1	63444-1116	63444-1116	Conductor Punch	1 Y
2	63445-1128	63445-1128	Conductor Anvil	1 Y
3	63454-0062	63454-0062	Insulation Punch	1 Y
4	63445-1409	63445-1409	Insulation Anvil	1 Y
5	63443-0003	63443-0003	Cut-Off Plunger	1 Y
6	63443-0012	63443-0012	Front Plunger Retainer	1 Y
Other Components				
7	11-17-0022	1739-21	Nose 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	Scrape Chute	1
11	63443-0024	63443-0024	Lower Tooling Key	1
12	63443-0090	63443-0090	Wire Stop Assembly	1
13	63443-0093	63443-0093	Nose Hold Down Shank	1
14	63443-2801	63443-2801	Front Plunger Striker	1
15	63443-2905	63443-2905	Wire Hold-Down Plunger	1
16	63443-6111	63443-6111	Rear Cover	1
17	63443-7123	63443-7123	Nose Hold Down	1
18	63443-7554	63443-7554	Anvil Mount	1
19	63600-0021	63600-0021	Compression Spring	1
Frame				
20	63800-4901	63800-4901	Top	1
21	63801-3281	63801-3281	Base	1
22	63801-4650	63801-4650	Track	1
Hardware				
23	—	—	M3 by 6 Long FHCS	1*
24	—	—	M3 by 6 Long SHCS	2*
25	—	—	M3 by 10 Long SHCS	1*
26	—	—	M4 by 6 Long SHCS	2*
27	—	—	M4 by 12 Long BHCS	2*
28	—	—	M4 by 50 Long SHCS	2*
29	—	—	M5 by 12 Long SHCS	1*
30	—	—	#10-32 by 3/8"Long SSS	1*
31	—	—	#10-32 Hex Nut	1*
* Available from an industrial supply company.				

ASSEMBLY DRAWING

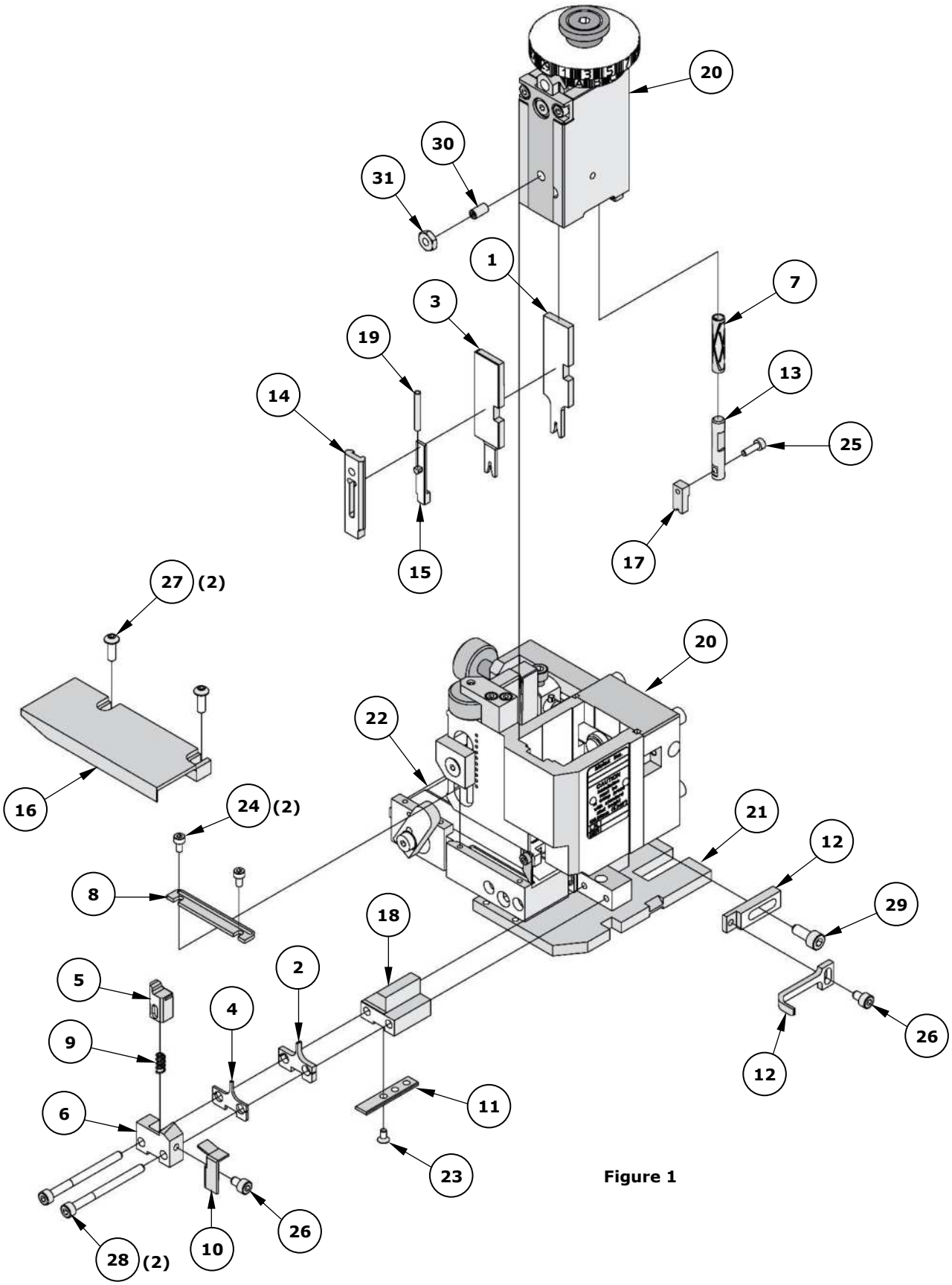


Figure 1

NOTES

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

Application Tooling Support

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