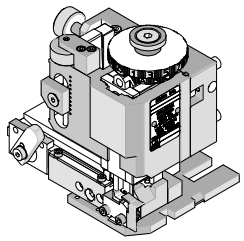
FineAdjust Applicator

molex

Application Tooling Specification Sheet



Order No. 63901-5700

FEATURES

- Quick punch removal with the push of a button for fast and easy tooling change
- Applicator designed to industry standard mounting and shut height 135.80mm (5.346")
- Quick set-up 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 .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
- Directly adapts to most automatic wire processing machines

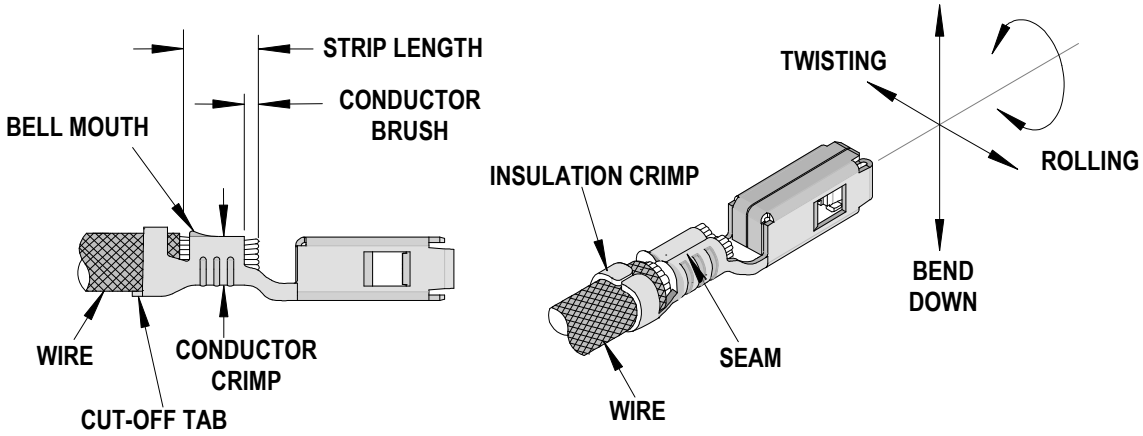
SCOPE

Products: 2.80mm (.110") Pitch UCC2 Receptacle Terminal, 0.35mm²; to 0.75mm² metric wire.

Terminal Series No.	Terminal Order No.	Wire Size and Type		Insulation Diameter				Strip Length	
				IPC/WHMA-A620 (1)		Terminal (2) Maximum			
		mm²	Type	mm	In.	mm	In.	mm	In.
98898	98898-1029	0.35	IR	1.25-1.90	.049-.075	1.25-1.90	.049-.075	4.50	.177
		0.50	IR					4.50	.177
		0.60	IR					4.50	.177
		0.75	IR					4.50	.177
		0.35 + 0.35	IR					4.50	.177

✦To achieve optimum IPC-A620 insulation crimps, use this insulation OD range.
(1) Overall insulation OD specification for terminal.
(2) See crimp specification for the individual Insulation Diameter.

DEFINITION OF TERMS



CRIMP SPECIFICATION

Terminal Series No.	Bell mouth		Cut-off Tab Maximum		▶ Conductor Brush	
	mm	In.	mm	In.	mm	In.
98898	0.05-1.00	.002-.039	0.20	.008	0.20-1.00	.008-.039
▶ Not to exceed above the conductor crimp height.						

Terminal Series No.	Bend up Bend down Degree		Twist Roll Degree		Punch Width (Ref)				Seam
					Conductor		Insulation		Seam shall not be open and no wire allowed out of the crimping area
					mm	In	mm	In	
98898	2	2	2	6	2.10	.083	2.50	.098	

After crimping, the crimp profiles should measure the following:

Terminal Series No.	Wire Size	Conductor				Pull Force Minimum	
		Crimp Height		Crimp Width (Ref.)			
	mm^2	mm	In.	mm	In.	N	Lb.
98898	0.35	1.01-1.09	.040-.043	2.20	.087	60.0	13.5
	0.50	1.06-1.14	.042-.045	2.20	.087	70.0	15.7
	0.60	1.06-1.14	.042-.045	2.20	.087	80.0	18.0
	0.75	1.11-1.19	.044-.047	2.20	.087	90.0	20.2
	0.35 + 0.35	1.06-1.14	.042-.045	2.20	.087	60.0	13.5

Terminal Series No.	Wire Size	Insulation Diameter		Insulation			
				Crimp Height (Ref)		Crimp Width (Ref.)	
	mm^2	mm	In.	mm	In.	mm	In.
98898	0.35	1.25-1.40	.049-.055	2.15-2.35	.085-.093	2.60	.102
	0.50	1.40-1.70	.055-.067	2.35-2.55	.093-.100	2.60	.102
	0.60	1.60-1.80	.063-.071	2.35-2.55	.093-.100	2.60	.102
	0.75	1.70-1.90	.067-.078	2.55-2.75	.100-.108	2.60	.102
	0.35 + 0.35	1.25-1.40	.049-.055	2.40-2.60	.095-.102	2.60	.102

▶ 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 63901-5700				
Item	**Order No**	**Engineering No.**	**Description**	**Quantity**
Perishable Tooling				
	63901-5770	63901-5770	Tool Kit (All "Y" Items)	REF
1	63444-2137	63444-2137	Conductor Punch	1 Y
2	63455-0091	63455-0091	Conductor Anvil	1 Y
3	63454-0084	63454-0084	Insulation Punch	1 Y
4	63456-0073	63456-0073	Insulation Anvil	1 Y
5	63443-0037	63443-0037	Cut-Off Plunger	1 Y
6	63443-0038	63443-0038	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	Scrap Chute	1
11	63443-0024	63443-0024	Key	1
12	63443-0090	63443-0090	Wire Stop	1
13	63443-0093	63443-0093	Shank	1
14	63443-1708	63443-1708	Height Spacer (17.80mm)	1
15	63443-2214	63443-2214	Spacer (14.00mm)	1
16	63443-2312	63443-2312	Spacer (3.60mm)	1
17	63443-2802	63443-2802	Front Plunger Striker	1
18	63443-2910	63443-2910	Wire Hold-Down Plunger	1
19	63443-6130	63443-6130	Rear Cover	1
20	63443-7113	63443-7113	Terminal Hold Down	1
21	63600-0021	63600-0021	Striker Plunger Spring	1
Frame				
22	63800-4901	63800-4901	Top	1
23	63801-3281	63801-3281	Base	1
24	63801-4650	63801-4650	Track	1
Hardware				
25	N/A	N/A	M3 by 6 Long SHCS	2**
26	N/A	N/A	M3 by 6 Long FHCS	1**
27	N/A	N/A	M3 by 8 Long SHCS	1**
28	N/A	N/A	M4 by 6 Long SHCS	2**
29	N/A	N/A	M4 by 12 Long BHCS	2**
30	N/A	N/A	M4 by 50 Long SHCS	2**
31	N/A	N/A	M5 by 12 Long SHCS	1**
32	N/A	N/A	#10-32 by 3/8"Long Flat Point SSS	1**
33	N/A	N/A	#10-32 Hex Jam Nut	1**
** Available from an industrial supply company such as MSC (1-800-645-7270).				

Assembly Drawing

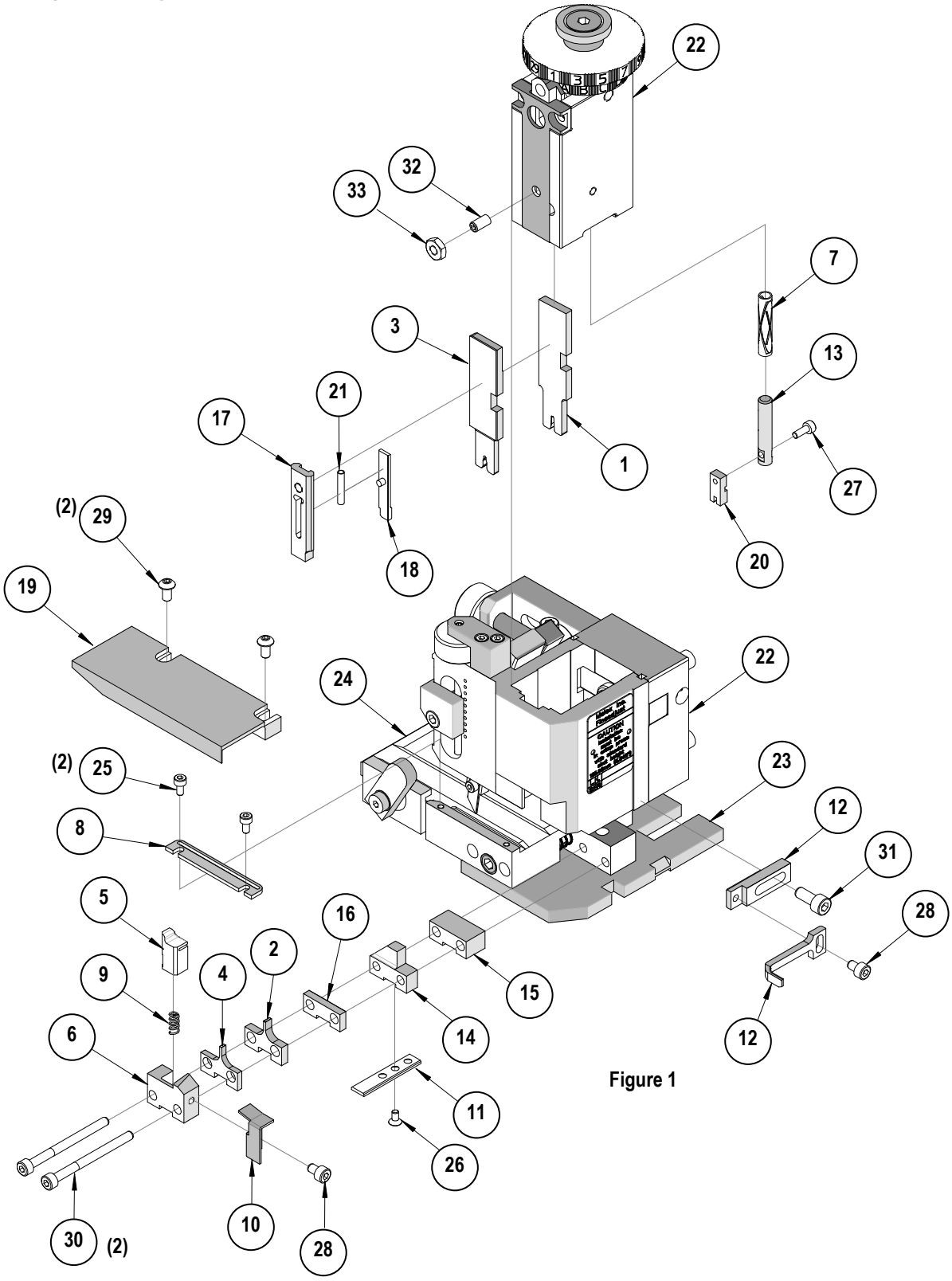


Figure 1

NOTES

1. Molex recommends 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 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 135.80 mm (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.

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