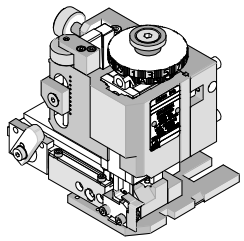
FineAdjust Applicator

molex

Application Tooling Specification Sheet



Order No. 63901-5800

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

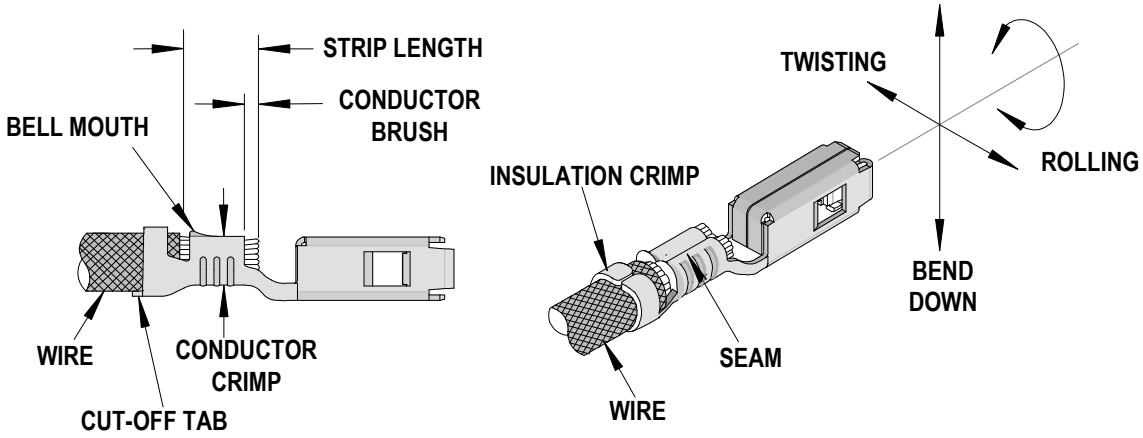
SCOPE

Products: 2.80mm (.110") Pitch UCC2 Receptacle Terminal, 1.00mm² to 2.50mm² 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	98898-1039	1.00	IR	1.99-3.00	.078-.118	1.99-3.00	.078-.118	4.50	.177
		1.40	IR						
		1.50	IR						
		2.00	IR						
		2.50	IR						
		0.35 + 0.60	IR						
		1.00 + 1.00	IR						
		0.35 + 1.00	IR						
		0.35 + 1.40	IR						
		0.35 + 2.00	IR						
		0.60 + 0.60	IR						
		0.60 + 1.00	IR						
		0.60 + 1.40	IR						

✦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) Conductor mm	Conductor In	Insulation mm	Insulation In	Seam
98898	2	2	2	6	2.85	.112	3.85	.152	Seam shall not be open and no wire allowed out of the crimping area

After crimping, the crimp profiles should measure the following:

Terminal Series No.	Wire Size	Conductor Crimp Height		Conductor Crimp Width (Ref.)		Pull Force Minimum	
	mm^2	mm	In.	mm	In.	N	Lb.
98898	1.00	1.40-1.50	.055-.059	2.90	.114	115.0	25.85
	1.40	1.45-1.55	.057-.061	2.90	.114	150.0	33.72
	1.50	1.45-1.55	.057-.061	2.90	.114	155.0	34.85
	2.00	1.60-1.70	.063-.067	2.90	.114	195.0	43.84
	2.50	1.65-1.75	.065-.069	2.90	.114	235.0	52.83
	0.35 + 0.60	1.40-1.50	.055-.059	2.90	.114	60.0	13.49
	1.00 + 1.00	1.60-1.70	.063-.067	2.90	.114	115.0	25.85
	0.35 + 1.00	1.45-1.55	.057-.061	2.90	.114	60.0	13.49
	0.35 + 1.40	1.55-1.65	.061-.065	2.90	.114	60.0	13.49
	0.35 + 2.00	1.65-1.75	.065-.069	2.90	.114	60.0	13.49
	0.60 + 0.60	1.45-1.55	.057-.061	2.90	.114	80.0	17.98
	0.60 + 1.00	1.50-1.60	.059-.063	2.90	.114	80.0	17.98
	0.60 + 1.40	1.60-1.70	.063-.067	2.90	.114	80.0	17.98

Terminal Series No.	Wire Size	Insulation Diameter		Insulation			
				Crimp Height (Ref)		Crimp Width (Ref.)	
	mm^2	mm	In.	mm	In.	mm	In.
98898	1.00	1.99-2.15	.078-.085	2.80-3.00	.110-.118	3.85	.152
	1.40	2.00-2.30	.079-.091	2.95-3.15	.116-.124	3.85	.152
	1.50	2.10-2.40	.083-.095	3.00-3.20	.118-.126	3.85	.152
	2.00	2.50-2.80	.098-.110	3.10-3.30	.122-.130	3.85	.152
	2.50	2.65-3.00	.104-.118	3.25-3.45	.128-.136	3.85	.152
	0.35 + 0.60	1.25-1.80	.049-.071	2.95-3.15	.116-.124	3.85	.152
	1.00 + 1.00	1.99-2.15	.078-.085	3.35-3.55	.132-.140	3.85	.152
	0.35 + 1.00	1.25-2.15	.049-0.85	3.05-3.25	.120-.128	3.85	.152
	0.35 + 1.40	1.25-2.30	.049-.091	3.20-3.40	.126-.134	3.85	.152
	0.35 + 2.00	1.25-2.80	.049-.110	3.40-3.60	.134-.142	3.85	.152
	0.60 + 0.60	1.60-1.80	.063-.071	3.15-3.35	.124-.132	3.85	.152
	0.60 + 1.00	1.60-2.15	.063-.085	3.25-3.45	.128-.136	3.85	.152
	0.60 + 1.40	1.60-2.30	.063-.091	3.40-3.60	.134-.142	3.85	.152

- 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 63901-5800				
Item	**Order No**	**Engineering No.**	**Description**	**Quantity**
Perishable Tooling				
	63901-5870	63901-5870	Tool Kit (All "Y" Items)	REF
1	63457-0065	63457-0065	Conductor Punch	1 Y
2	63455-0088	63455-0088	Conductor Anvil	1 Y
3	63454-0106	63454-0106	Insulation Punch	1 Y
4	63456-0066	63456-0066	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	11-18-4083	60707-8	Feed Guide	1
8	11-24-1067	4996-4	Cut-off Plunger Spring	1
9	63443-0009	63443-0009	Scrap Chute	1
10	63443-0024	63443-0024	Key	1
11	63443-0090	63443-0090	Wire Stop	1
12	63443-0093	63443-0093	Shank	1
13	63443-1707	63443-1707	Height Spacer (17.70mm)	1
14	63443-2214	63443-2214	Spacer (14.00mm)	1
15	63443-2314	63443-2314	Spacer (3.70mm)	1
16	63443-2804	63443-2804	Front Plunger Striker	1
17	63443-2911	63443-2911	Wire Hold-Down Plunger	1
18	63443-6130	63443-6130	Rear Cover	1
19	63443-7113	63443-7113	Terminal Hold Down	1
20	63600-0021	63600-0021	Striker Plunger Spring	1
21	63600-3378	63600-3378	Hold Down 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

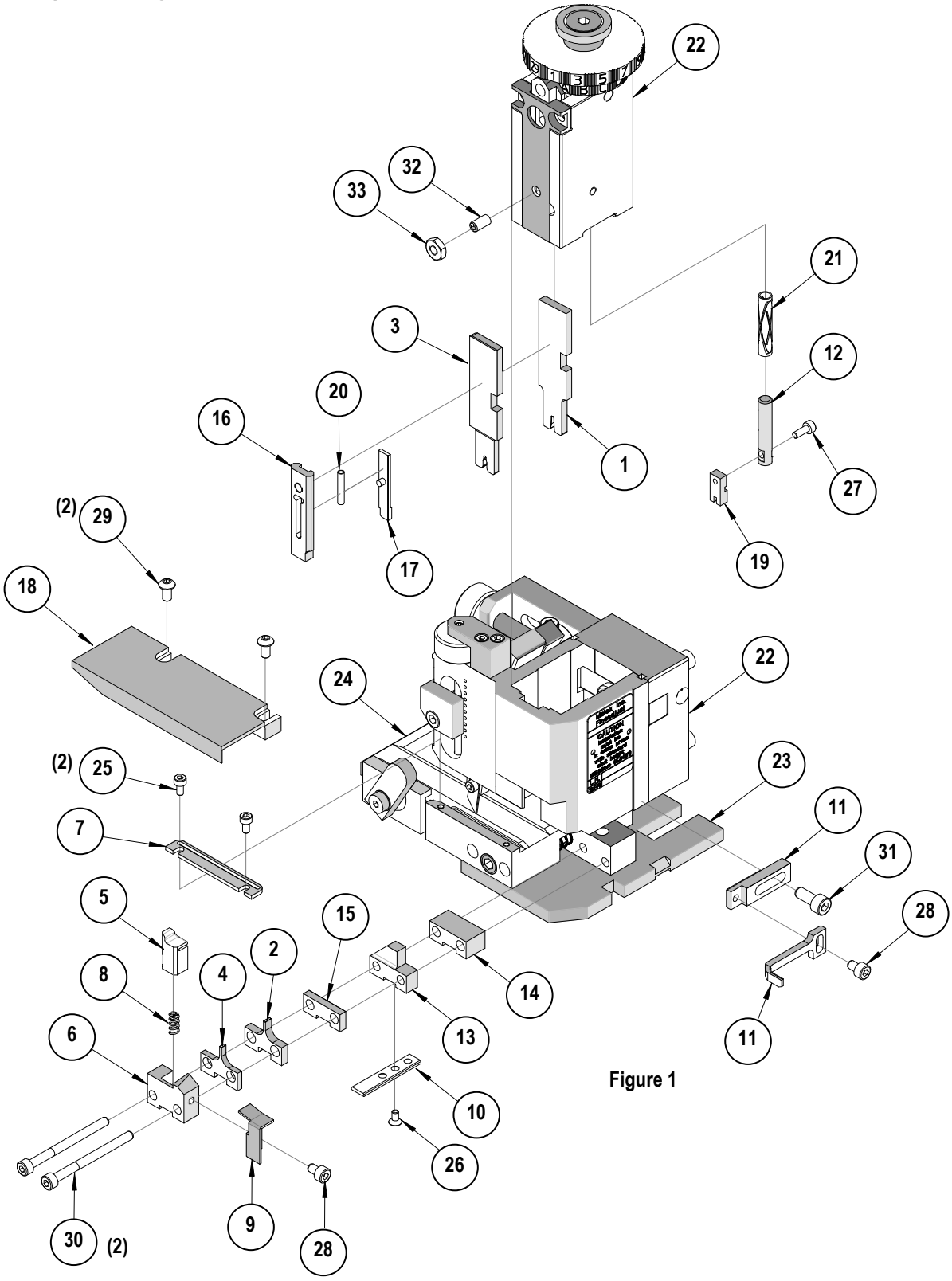


Figure 1

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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