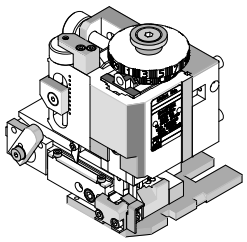
FineAdjust Applicator

molex

Application Tooling Specification Sheet



Order No. 63902-2000

FEATURES

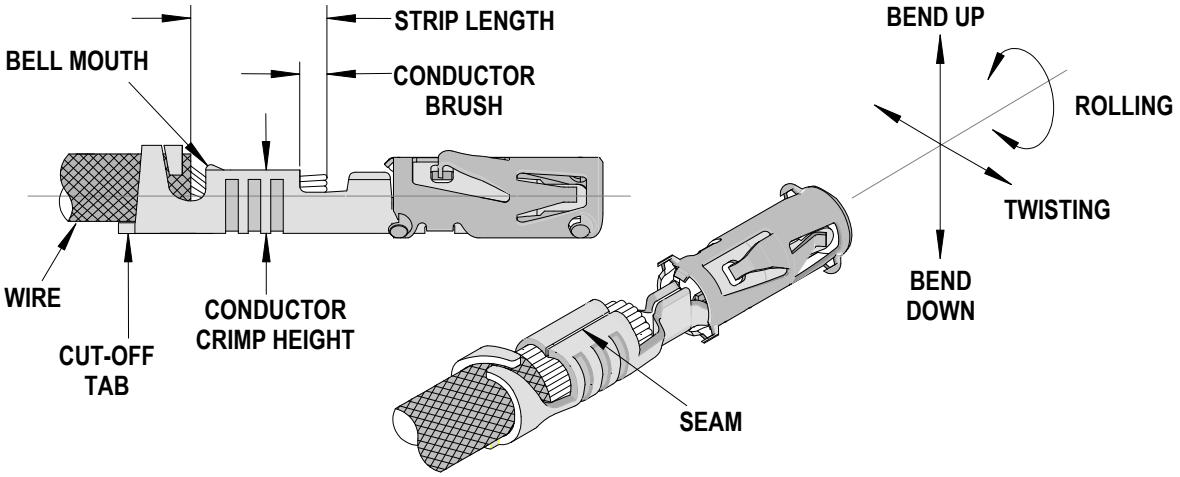
- Quick punch removal with the push of a button for fast and easy tooling change
- Applicator designed to industry standard mounting and shut height 135.80mm (5.346")
- Quick set-up time; plus the crimp height, track and feed adjustments can be set without removing the applicator from the press
- Fine 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: 0.60mm (.024") CP Crimp Terminal for CMC connector 0.50-0.75mm².

Terminal Series No.	Terminal Order No.		Wire Size		Insulation Type	Insulation Diameter		Strip Length	
			AWG	mm²		mm	In.	mm	In.
98913	98913-1029 98913-1219 98913-1319	98913-1339 98913-3029	---	0.75	ID	1.65-1.80	.065-.071	3.50	.138
			---	0.60	IR	1.75-1.90	.069-.075	3.50	.138
			---	0.50	ID	1.35-1.50	.053-.059	3.50	.138
64322	64322-1029 64322-1219	64322-1319 64322-1339	---	0.75	ID	1.65-1.80	.065-.071	3.50	.138
			---	0.60	IR	1.75-1.90	.069-.075	3.50	.138
			---	0.50	ID	1.35-1.50	.053-.059	3.50	.138

DEFINITION OF TERMS



CRIMP SPECIFICATION

Terminal Series No.	Bell mouth		Cut-off Tab Maximum		Conductor Brush	
	mm	In.	mm	In.	mm	In.
98913	0.00-0.30	.000-.012	0.30	.012	0.20-0.60	.008-.024
64322	0.00-0.30	.000-.012	0.30	.012	0.20-0.60	.008-.024

Terminal Series No.	Bend up Bend down		Twist Roll		Punch Width (Ref)				Seam
					Conductor		Insulation		
	Degree Maximum		Degree Maximum		mm	In	mm	In	
98913	1	1.5	1.5	2	1.60	.063	1.70	.067	Seam shall not be open and no wire allowed out of the crimping area
64322	1	1.5	1.5	2	1.60	.063	1.70	.067	

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^2	mm	In.	mm	In.	N	Lb.
98913		0.75	1.00-1.10	.039-.043	1.85-2.00	.073-.079	90.0	20.25
		0.60	0.98-1.08	.038-.042	1.85-2.00	.073-.079	80.0	18.00
		0.50	0.95-1.05	.037-.041	1.75-1.90	.069-.075	70.0	15.75
64322		0.75	1.00-1.10	.039-.043	1.85-2.00	.073-.079	90.0	20.25
		0.60	0.98-1.08	.038-.042	1.85-2.00	.073-.079	80.0	18.00
		0.50	0.95-1.05	.037-.041	1.75-1.90	.069-.075	70.0	15.75

✳ 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 63902-2000				
Item	**Order No**	**Engineering No.**	**Description**	**Quantity**
Perishable Tooling				
	63902-2070	63902-2070	Tool Kit (All "Y" Items)	REF
1	63457-0034	63457-0034	Conductor Punch	1 Y
2	63455-0039	63455-0039	Conductor Anvil	1 Y
3	63454-0059	63454-0059	Insulation Punch	1 Y
4	63456-0039	63456-0039	Insulation Anvil	1 Y
5	63443-0005	63443-0005	Front 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	11-24-1149	4996-37	Shank	1
10	63443-0009	63443-0009	Front Scrap Chute	1
11	63443-0024	63443-0024	Key	1
12	63443-0090	63443-0090	Wire Stop	1
13	63443-1716	63443-1716	Height Spacer	1
14	63443-2215	63443-2215	Coarse Spacer (15.00mm)	1
15	63443-2312	63443-2312	Fine Spacer (3.60mm)	1
16	63443-2805	63443-2805	Front Plunger Striker	1
17	63443-2911	63443-2911	Wire Hold Down Plunger	1
18	63443-6111	63443-6111	Rear Cover	1
19	63443-7003	63443-7003	Terminal Hold Down	1
20	63600-1057	63600-1057	Wire Hold Down Spring	1
21	63700-0539	63700-0539	Cut-Off 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	M4 by 6 Long SHCS	2**
28	N/A	N/A	M4 by 12 Long BHCS	2**
29	N/A	N/A	M4 by 50 Long SHCS	2**
30	N/A	N/A	M5 by 12 Lg SHCS	1**
31	N/A	N/A	#5-40 by 3/8"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

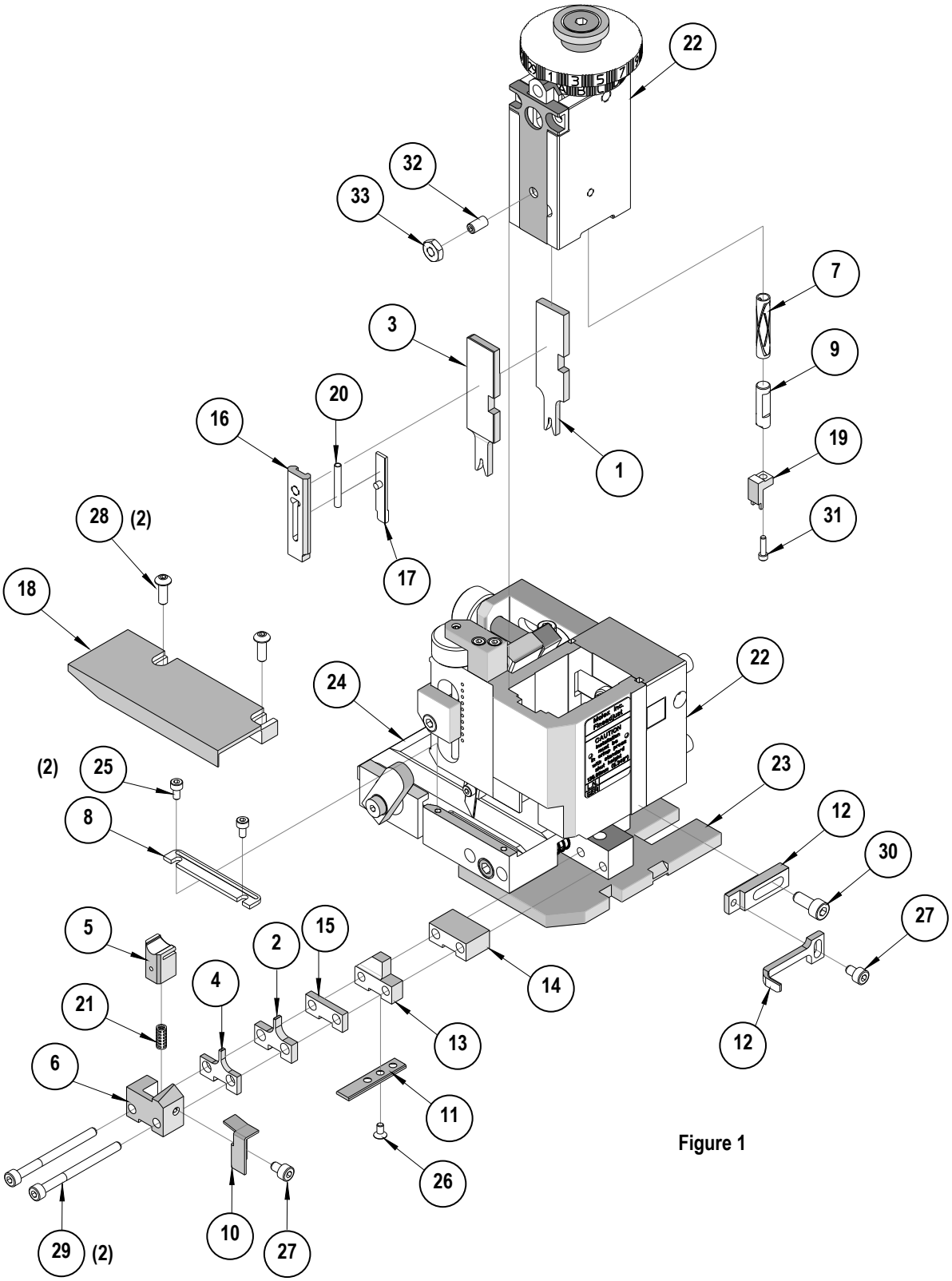


Figure 1

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 135.8mm (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.

http://www.molex.com