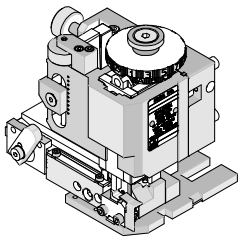
FineAdjust Applicator

molex

Application Tooling Specification Sheet



Order No. 63902-5100

FEATURES

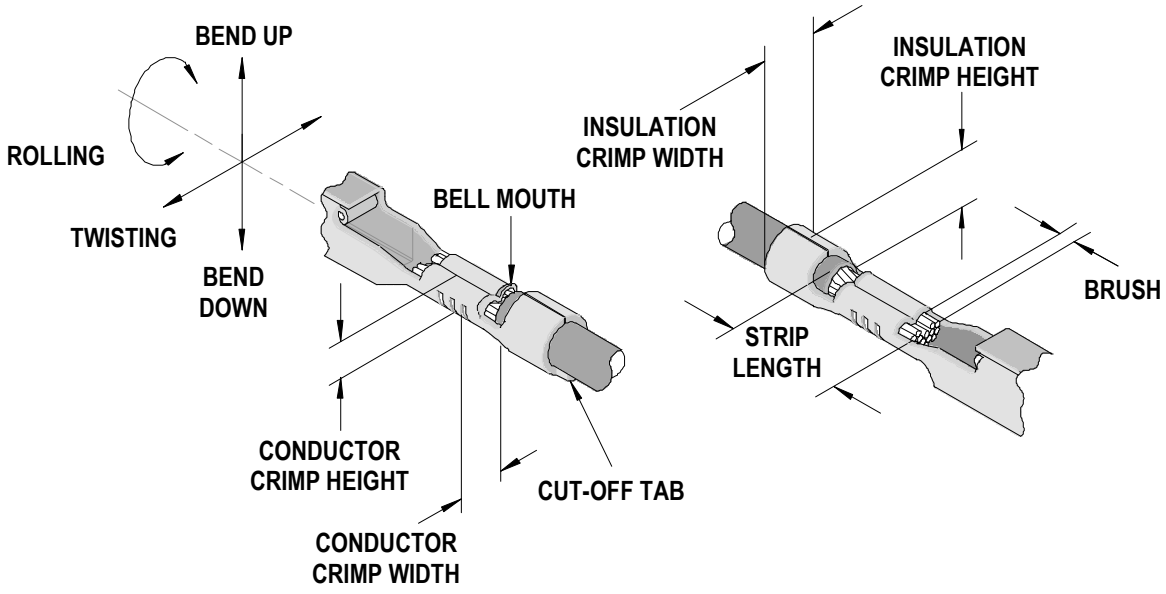
- Quick punch removal with the push of a button for fast and easy tooling change
- Applicator designed to industry standard mounting and shut height 135.80mm (5.346")
- Quick set-up time; plus the crimp height, track and feed adjustments can be set without removing the applicator from the press
- Fine adjustment allows users to achieve target with little effort by adjusting in increments of 0.15mm (.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: MX64™ ISO Terminal, 0.35mm² wire.

Terminal Series No.	Terminal Order No.	Wire Size		Insulation Diameter Maximum		Strip Length (Ref)	
		Wire Type	mm²	mm	In.	mm	In.
33467	33467-0021	FLR2X-A	0.35	1.30	.051	4.10	.161
33468	33468-0021						
34736	34736-0025						
Terminal validated per USCAR-21 with the following wire specifications: ISO 6722, GMW15626 and Ford ES-AU5T-1A348-AA, PSA B25 1110:NTS–Conventional Electrical Conductor.							

DEFINITION OF TERMS



CRIMP SPECIFICATION

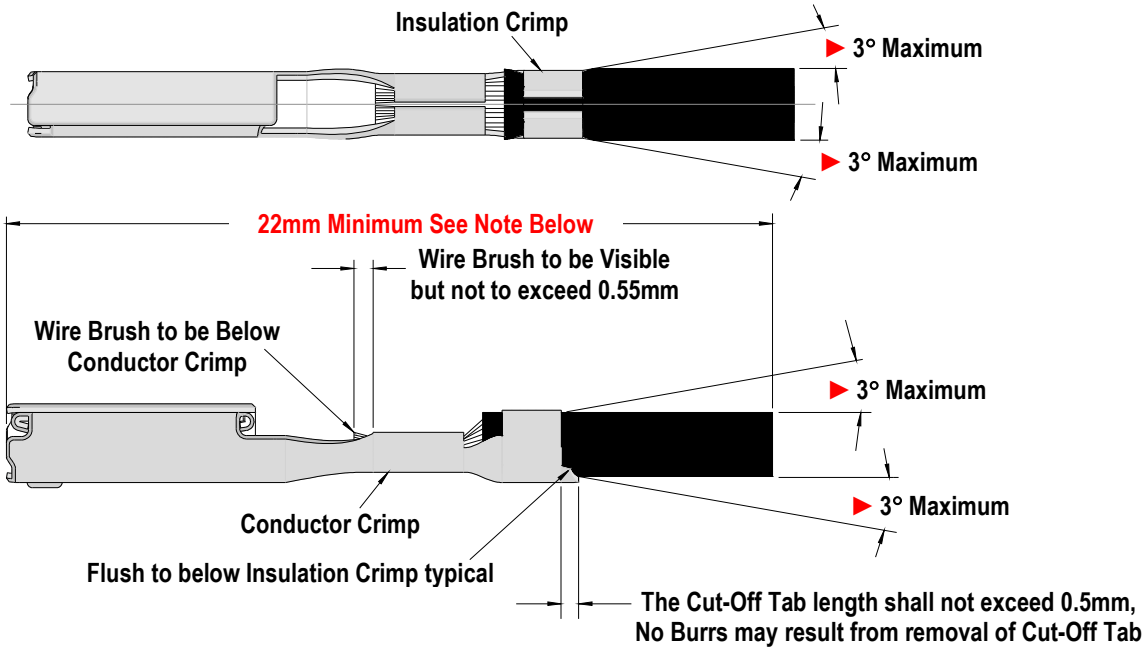
Terminal Series No.	Bell mouth		Cut-off Tab Maximum		▶ Conductor Brush Maximum	
	mm	In.	mm	In.	mm	In.
33467 33468 34736	0.25-0.45	.010-.018	0.50	.020	0.55	.022
▶ Wire brush must be flush or below top of Conductor Crimp.						

Terminal Series No.	Bend up Bend down	Twist Roll	Seam
33467 33468 34736	3 Degree Max, Crimped Samples must pass thru the 63867-3008 Checking Aid ▶ ▶ Ordered separately		Seam shall not be open and no wire allowed out of the crimping area

After crimping, the conductor profile should measure the following.

Terminal Series No.	Wire Size		Conductor				Insulation				Pull Force Minimum	
			Crimp Height		Crimp Width		Crimp Height		Crimp Width			
	Wire Type	mm²	mm	In.	mm	In.	mm	In.	mm	In.	N	Lb.
33467 33468 34736	FLR2X-A	0.35	0.93-0.99	.037-.039	1.35-1.45	.053-.057	1.45-1.65	.057-.065	1.64-1.84	.065-.072	50	11.3

Pull Force should be measured with no influence from the insulation crimp. The above specifications are guidelines to an optimum crimp.



NOTE:

▶ Straightness:

A Crimped terminal lead must be able to pass freely through the Checking Aid▶ , Part No.63867-3008.

B Wire on the crimped lead must meet all specification above.

Wire Stop Set-Up Positioning Procedure

In order to maintain the conductor brush within the specifications the following set-up procedure needs to be followed.

	WARNING
	Never install or service this machine while connected to any electrical power source. Disconnect power by unplugging the press from its power source. Failure to observe this warning could result In severe injury or death.
	Always hand cycle the applicator in the equipment to ensure the tooling is properly aligned. Failure to observe these precautions may result in injury or property damage.

1. Manually cycle the press until the press ram with the punches is in the full down position.
2. Adjust the wire stop blade down towards the terminal as close as possible to the terminal transitional surface. See Figure 1.
3. Adjust the clearance between the wire stop blade and the conductor punch to.03mm (.001") maximum.

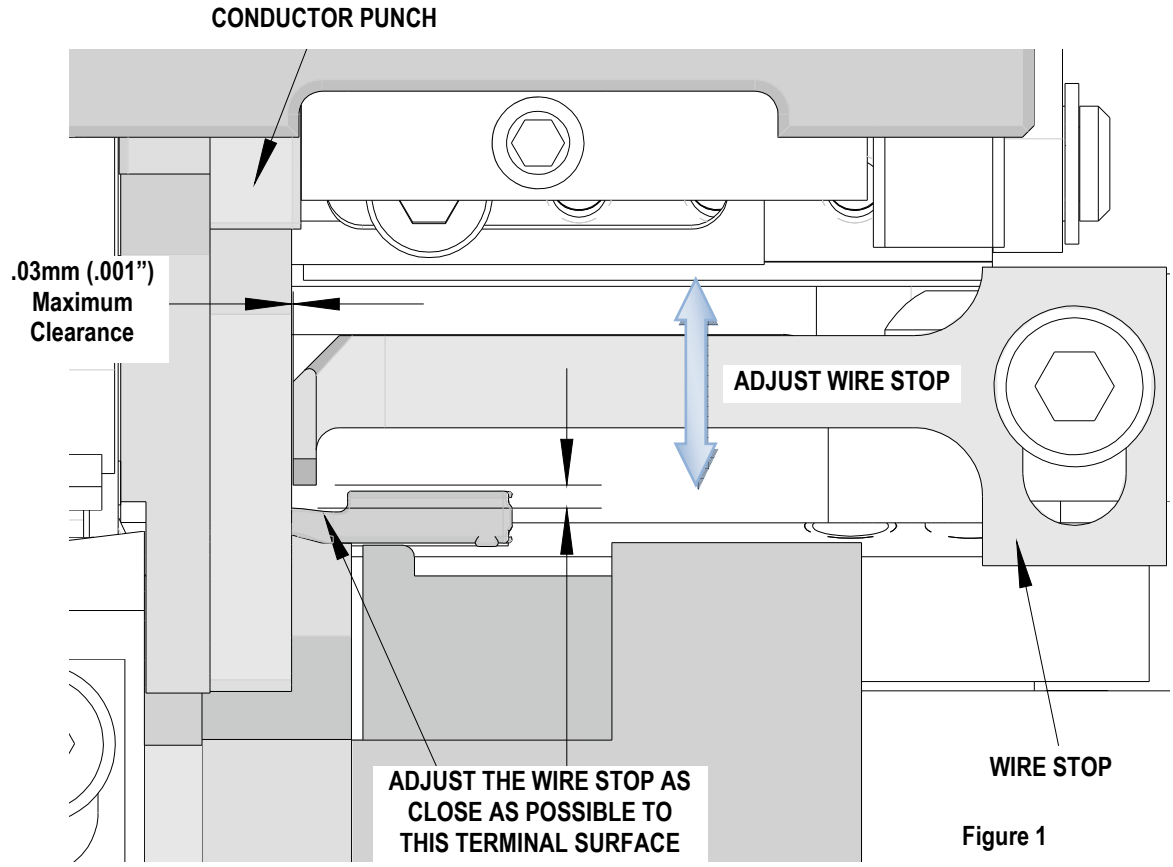


Figure 1

4. Manually cycle the press until the press ram is in the full up position.
5. Manually cycle the press again, to make sure the terminals are feeding properly.
6. Power up the press and crimp terminals without wire to make sure they are feeding properly
7. Crimp terminals with wire and check for proper feeding.

PARTS LIST

FineAdjust Applicator 63902-5100				
Item	**Order No**	**Engineering No.**	**Description**	**Quantity**
Perishable Tooling				
	63902-5170	63902-5170	Tool Kit (All "Y" Items)	REF
1	63457-0078	63457-0078	Conductor Punch	1 Y
2	63455-0106	63455-0106	Conductor Anvil	1 Y
3	63454-0128	63454-0128	Insulation Punch	1 Y
4	63456-0088	63456-0088	Insulation Anvil	1 Y
5	63890-0078	63890-0078	Cut-Off Plunger	1 Y
6	63443-0046	63443-0046	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	63443-2801	63443-2801	Front Plunger Striker	1
13	63443-6115	63443-6115	Rear Cover	1
14	63600-0021	63600-0021	Wire Hold Down Spring	1
15	63867-3007	63867-3007	Bottom Cap	1
16	63867-3008	63867-3008	► Checking Aid	REF
17	63890-0096	63890-0096	Wire Hold Down Plunger	1
18	63902-5107	63902-5107	Anvil Mount	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	N/A	N/A	M3 by 6 Long SHCS	2**
23	N/A	N/A	M3 by 6 Long FHCS	1**
24	N/A	N/A	M4 by 6 Long SHCS	2**
25	N/A	N/A	M4 by 8 Long SHSS	1**
26	N/A	N/A	M4 by 12 Long SHCS	2**
27	N/A	N/A	M4 by 12 Long BHCS	2**
28	N/A	N/A	M4 by 16 Long SHCS	1**
29	N/A	N/A	M4 by 50 Long SHCS	2**
30	N/A	N/A	M5 by 12 Long SHCS	1**
31	N/A	N/A	#10-32 by 3/8"Long Flat Point SSS	1**
32	N/A	N/A	#10-32 Hex Jam Nut	1**
** Available from an industrial supply company such as MSC (1-800-645-7270).				

► The Checking Aid 63867-3008 to be ordered separately if required.
(This item is not included with the Applicator and is shown for Reference purpose only)

Assembly Drawing

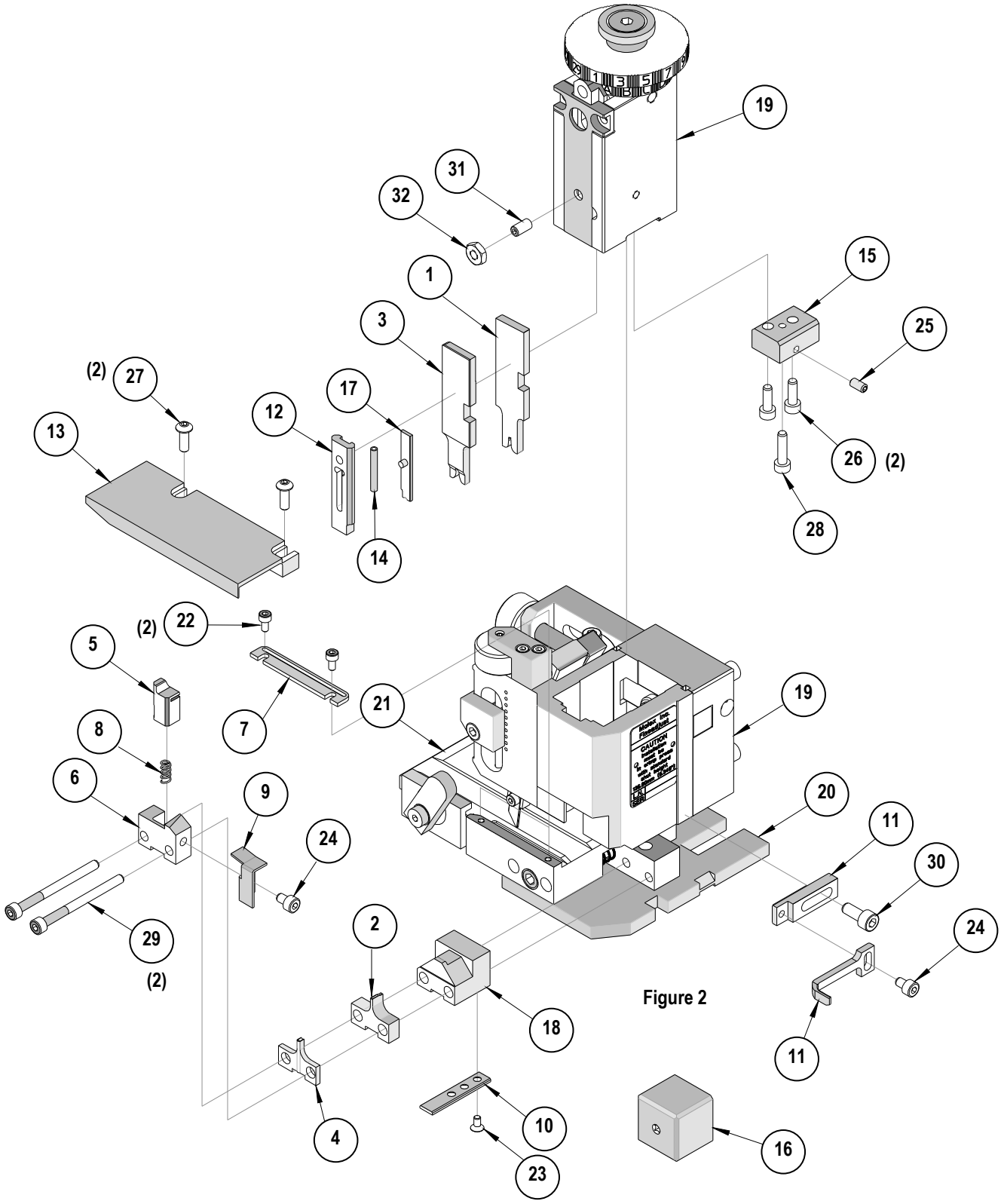


Figure 2

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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