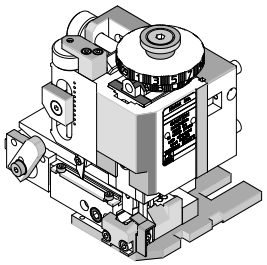
Order Number
63902-8700

molex

Application Tooling Specification



FEATURES

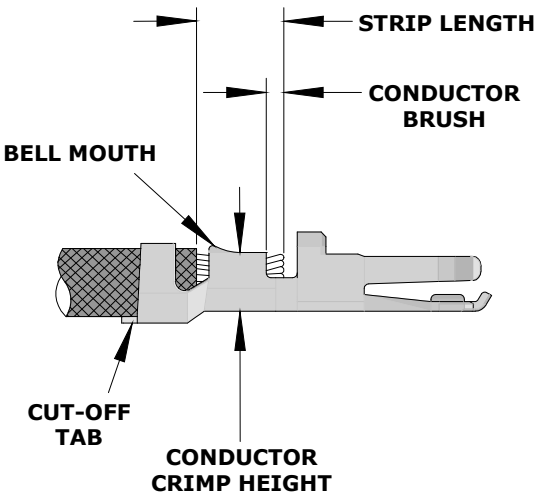
- Quick punch removal with the push of a button for fast and easy tooling change
- Applicator designed to industry-standard mounting and 135.80mm (5.346") shut height
- Quick setup time; plus, the crimp height, track and feed adjustments can be set without removing the applicator from the press
- Fine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

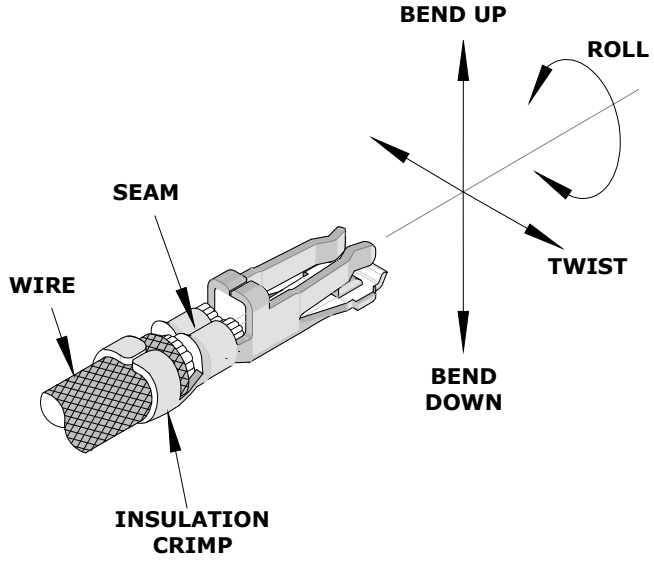
SCOPE

Products: 1.50mm Pitch Pico-Lock Receptacle Crimp Terminals, 24-28 AWG UL1061 Wires.

Terminal Series No.	Terminal Order No.	Wire Size		Insulation Diameter		Strip Length	
		AWG	mm²	mm	In.	mm	In.
504052	504052-0098	24-28	—	0.80-1.15	.032-.045	1.50-1.90	.059-.075

DEFINITION OF TERMS





CRIMP SPECIFICATION

Terminal Series No.	Bell Mouth		Cut-Off Tab Maximum		Conductor Brush	
	mm	In.	mm	In.	mm	In.
504052	0.10-0.40	.004-.016	0.10	.004	0.10-0.60	.004-.024

Terminal Series No.	Bend Up	Bend Down	Twist	Roll	Punch Width (Ref)				Seam
					Conductor		Insulation		
	Degree Max.		Degree Max.		mm	In.	mm	In.	
504052	3	2	3	6	1.00	.039	1.05	.041	Seam shall not be open and no wire allowed out of the crimping area

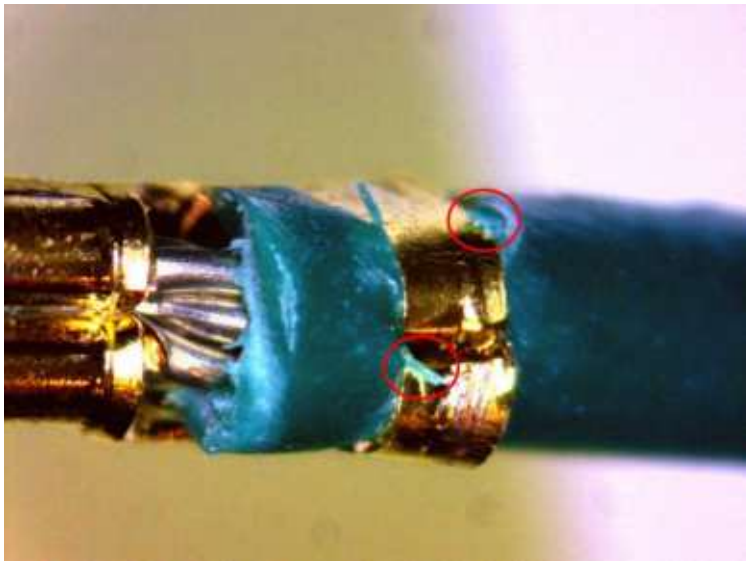
After crimping, the crimp profiles should measure the following:

Terminal Series No.	Wire Size		Conductor				Insulation				Pull Force Minimum	
			Crimp Height		Crimp Width (Ref)		Crimp Height (Max)		Crimp Width (Max)			
	AWG	mm^2	mm	In.	mm	In.	mm	In.	mm	In.	N	Lb.
504052	24	—	0.56-0.61	.022-.024	1.00	.039	1.40	.055	1.15	.045	29.4	6.6
	26	—	0.52-0.57	.020-.022	1.00	.039	1.40	.055	1.15	.045	19.6	4.4
	28	—	0.48-0.53	.019-.021	1.00	.039	1.30	.051	1.15	.045	9.8	2.2

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.
3. Oiler (63801-7240) required to crimp terminals to improve tooling life and also to minimize the crimp extrusions. See 63800-4900 FineAdjust manual.

Note: Insulation skiving may occur, but it is acceptable for crimps made with this applicator. See picture below.



PARTS LIST

FineAdjust Applicator 63902-8700				
Item	**Order No.**	**Engineering No.**	**Description**	**Quantity**
Perishable Tooling				
	63902-8770	63902-8770	Tool Kit (All "Y" Items)	REF
1	63457-0014	63457-0014	Conductor Punch	1 Y
2	63455-0126	63455-0126	Conductor Anvil	1 Y
3	63454-0142	63454-0142	Insulation Punch	1 Y
4	63456-0098	63456-0098	Insulation Anvil	1 Y
5	63443-0005	63443-0005	Cut-Off Plunger	1 Y
6	63443-0012	63443-0012	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	63443-1719	63443-1719	Height Spacer (18.90mm)	1
13	63443-2217	63443-2217	Coarse Spacer (17.00mm)	1
14	63443-2303	63443-2303	Fine Spacer (3.15mm)	1
15	63443-2806	63443-2806	Front Plunger Striker	1
16	63443-2905	63443-2905	Wire Hold-Down Plunger	1
17	63443-6108	63443-6108	Rear Cover	1
18	63600-0021	63600-0021	Striker Plunger Spring	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	—	—	M3 by 6 Long SHCS	2*
23	—	—	M3 by 6 Long FHCS	1*
24	—	—	M4 by 6 Long SHCS	2*
25	—	—	M4 by 12 Long BHCS	2*
26	—	—	M4 by 50 Long SHCS	2*
27	—	—	M5 by 12 Long SHCS	1*
28	—	—	#10-32 by 3/8"Long Flat Point SSS	1*
29	—	—	#10-32 Hex Jam Nut	1*
* Available from an industrial supply company.				

ASSEMBLY DRAWING

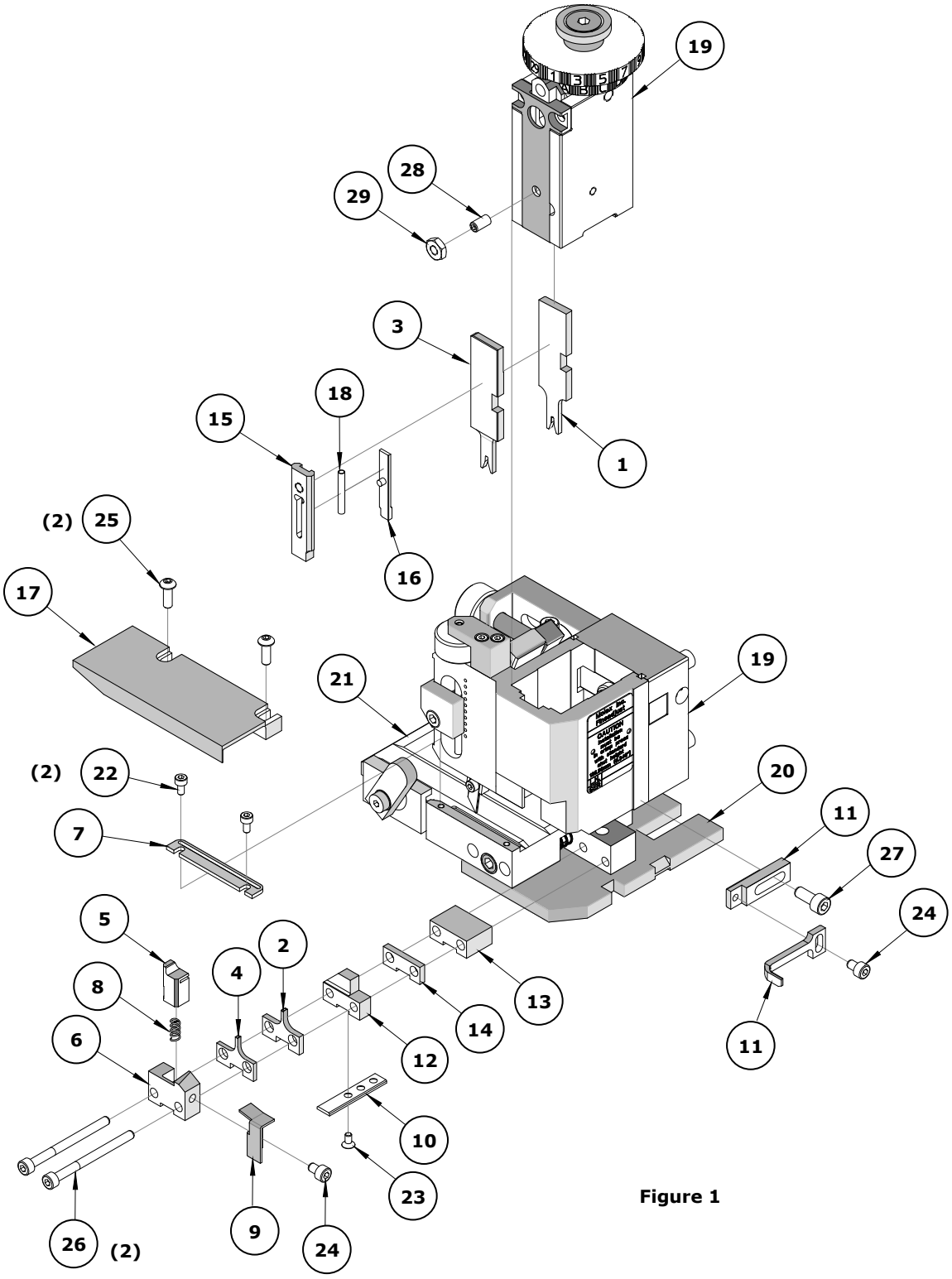


Figure 1

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

E-Mail: toolingsupport@molex.com
Website: www.molex.com/applicationtooling

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