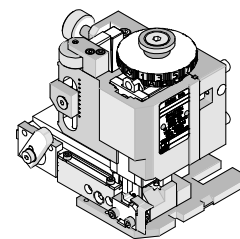


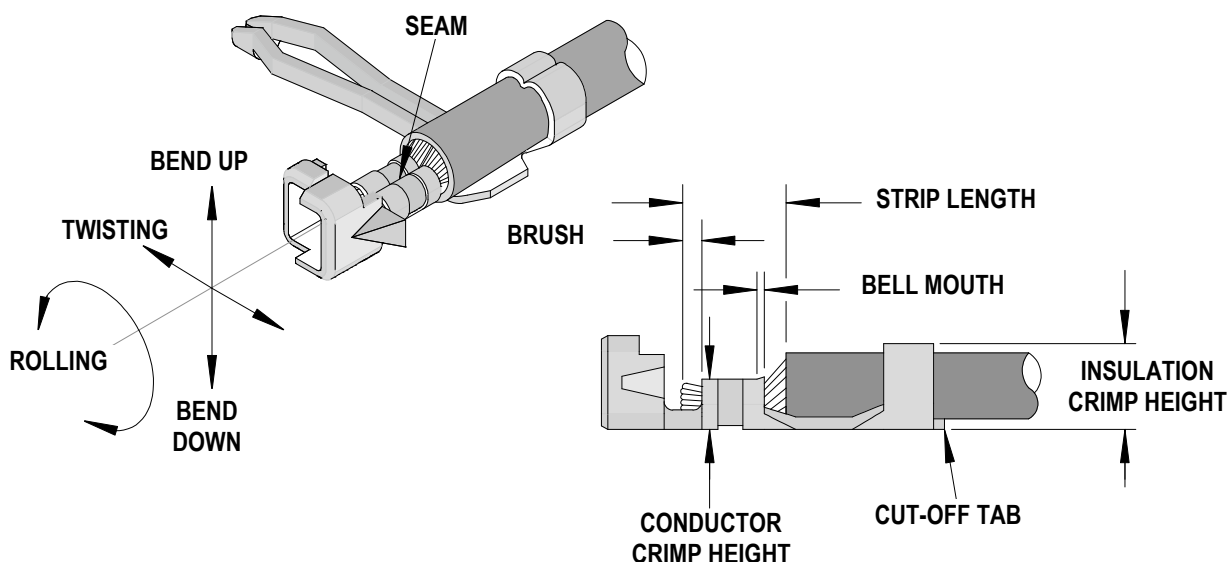
**FineAdjust
Applicator****molex****Application Tooling
Specification Sheet****Order No. 63904-2500****FEATURES**

- Directly adapts to most automatic wire processing machines
- 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

SCOPE

Products: Hybrid Board-In Power Terminal for 1.50mm².

Terminal Series No.	Terminal Order No.	Wire Size		Insulation Diameter Maximum		Strip Length	
		AWG	mm ²	mm	In.	mm	In.
201231	201231-8003	-	1.50	2.40	.095	4.0-4.7	.157-.185

DEFINITION OF TERMS

CRIMP SPECIFICATION

Terminal Series No.	Bell mouth		Cut-off Tab Maximum		Conductor Brush	
	mm	In.	mm	In.	mm	In.
201231	0.20-0.50	.008-.020	0.20	.008	0.3-1.0	.012-.039

Terminal Series No.	Bend up Bend down		Twist Roll		Punch Width mm (Ref)				Seam
	Degree		Degree		Conductor		Insulation		Seam shall not be open and no wire allowed out of the crimping area
					mm	In	mm	In	
201231	3	3	3	3	2.35	.093	3.00	.118	

After crimping, the conductor profile should measure the following.

Terminal Series No.	Wire Size		Conductor			
			Crimp Height		Crimp Width (Ref)	
	AWG	mm ²	mm	In.	mm	In.
201231	-	1.50	1.45-1.54	.057-.061	2.35-2.45	.093-.096

Terminal Series No.	Wire Size		Insulation				Pull Force Minimum	
			Crimp Height (Max)		Crimp Width (Ref)			
	AWG	mm ²	mm	In.	mm	In.	N	Lb.
201231	-	1.50	3.10	.122	3.10	.122	49.0	11.02

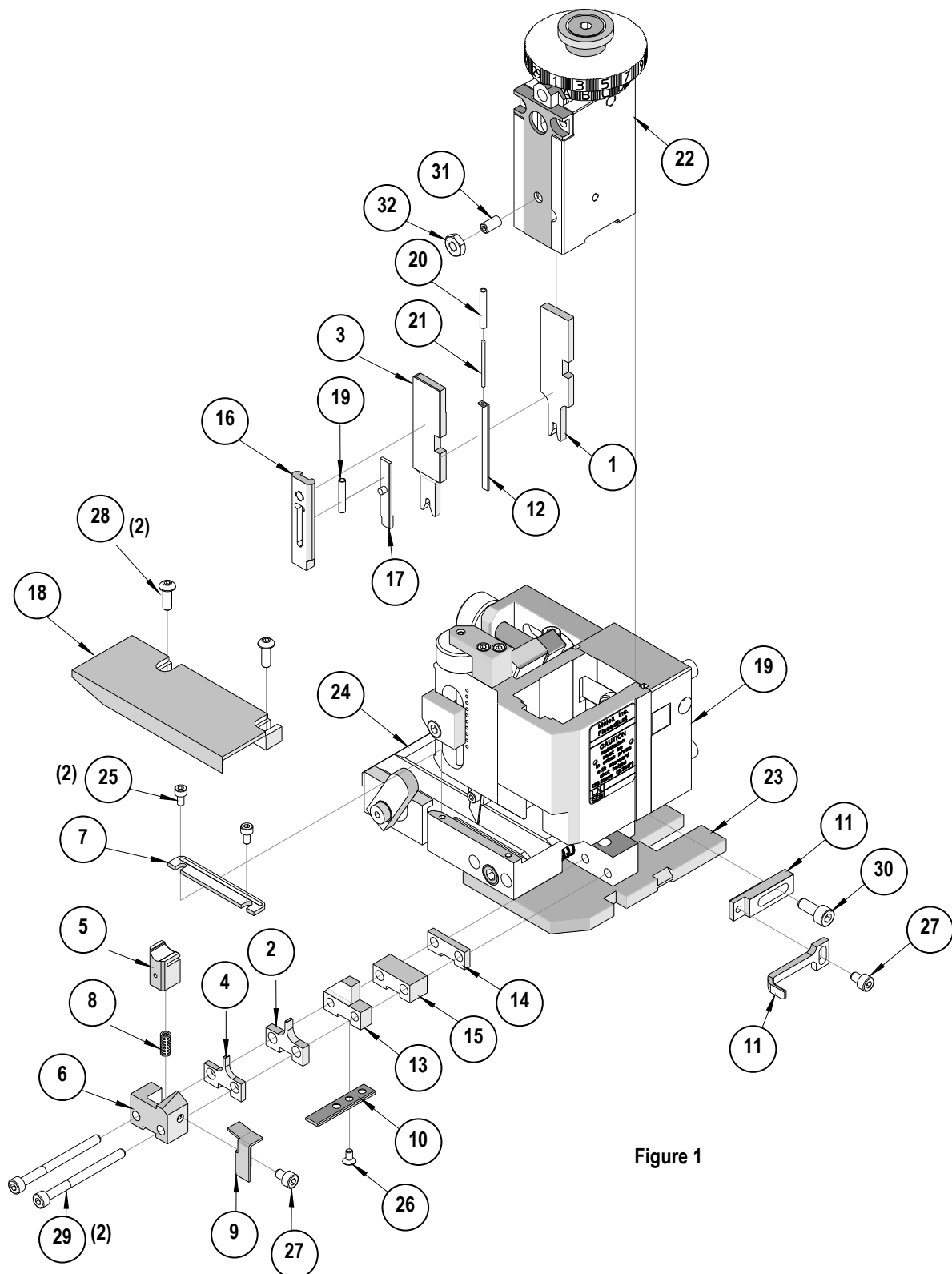
Tool Qualification Notes:

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 63904-2500				
Item	Order No	Engineering No.	Description	Quantity
Perishable Tooling				
	63904-2570	63904-2570	Tool Kit (All "Y" Items)	REF
1	63457-2305	63457-2305	Conductor Punch	1 Y
2	63455-2301	63455-2301	Conductor Anvil	1 Y
3	63454-3007	63454-3007	Insulation Punch	1 Y
4	63456-3002	63456-3002	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	Scrape Chute	1
10	63443-0024	63443-0024	Lower Tooling Key	1
11	63443-0090	63443-0090	Wire Stop	1
12	63443-1168	63443-1168	Blade-Wire Hold Down	1
13	63443-1720	63443-1720	19.00mm (Height Spacer)	1
14	63443-2215	63443-2215	15.00mm (Coarse Spacer)	1
15	63443-2306	63443-2306	3.30mm (Fine Spacer)	1
16	63443-2805	63443-2805	Front Plunger Striker	1
17	63443-2915	63443-2915	Striker Plunger	1
18	63443-6109	63443-6109	Rear Cover	1
19	63600-1057	63600-1057	Striker Plunger Spring	1
20	63600-2673	63600-2673	Mini Rod	1
21	63600-4389	63600-4389	Spring-Compression	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 45 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 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).				

Assembly Drawing



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.

Application Tooling Support

2200 Wellington Court
Lisle, IL 60532 USA
Phone: +1-402-458-TOOL (8665)
E-mail: applicationtooling@molex.com

Visit our Website at www.molex.com/applicationtooling

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Офис по работе с юридическими лицами:

105318, г.Москва, ул.Щербаковская д.3, офис 1107, 1118, ДЦ «Щербаковский»

Телефон: +7 495 668-12-70 (многоканальный)

Факс: +7 495 668-12-70 (доб.304)

E-mail: info@moschip.ru

Skype отдела продаж:

moschip.ru

moschip.ru_4

moschip.ru_6

moschip.ru_9