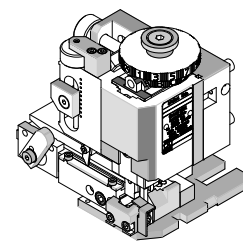


FineAdjust Applicator

molex

Application Tooling Specification Sheet


Order No. 63868-9000

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

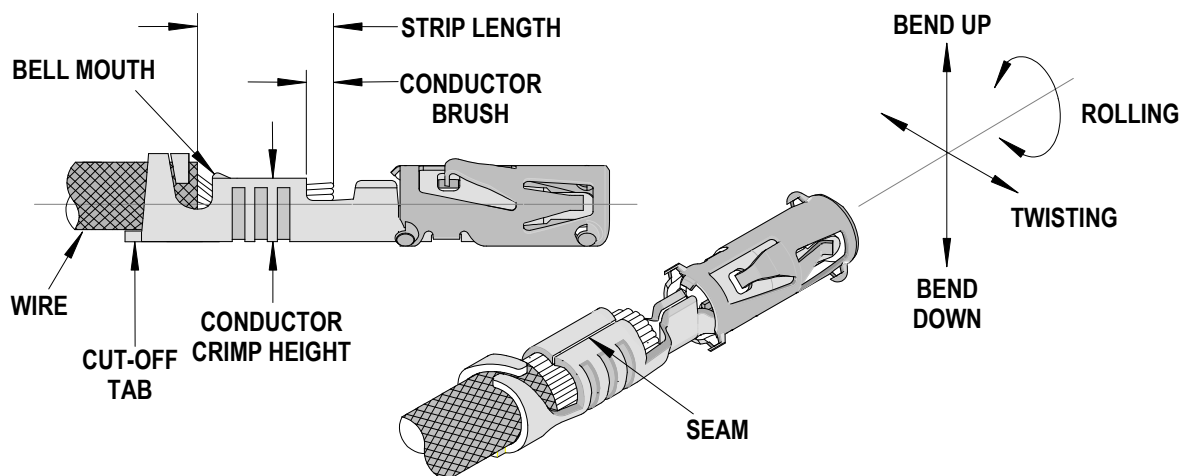
SCOPE

Products: 0.60mm (.024") CP Crimp Terminal for CMC connector, 22 AWG and 0.22, 0.35, 0.50mm².

Terminal Series No.	Terminal Order No.			Wire Size		Insulation Type	Insulation Diameter		Strip Length	
				AWG	mm ²		mm	In.	mm	In.
98913	98913-1019	98913-1349	64322-1229	22	---	TXL	1.50-1.65	.059-.065	3.40-3.60	.134-.142
	98913-1229	98913-3019	64322-1329	---	0.35	ID and IR	1.25-1.40	.049-.055	3.40-3.60	.134-.142
	98913-1329	64322-1019	64322-1349	---	0.22	ID and IR	1.15-1.25	.045-.049	3.40-3.60	.134-.142
	98913-1039	98913-1419	64322-1039	---	0.50	ID and IR	1.40-1.70	.055-.067	3.40-3.60	.134-.142
	98913-1239	98913-3039	64322-1239							
	98913-1359		64322-1359							

Note: Terminal will accommodate the thin wall small insulation with the TXL type American wires and the IR or ID type Metric wires

DEFINITION OF TERMS



CRIMP SPECIFICATION

Terminal Series No.	Bell mouth		Cut-off Tab Maximum		Conductor Brush	
	mm	In.	mm	In.	mm	In.
98913	0.20-0.40	.008-.016	0.30	.012	0.20-0.60	.008-.024

Terminal Series No.	Bend up Bend down		Twist Roll		Punch Width (Ref)				Seam Seam shall not be open and no wire allowed out of the crimping area
					Conductor		Insulation		
	Degree (Max)		Degree (Max)		mm	In	mm	In	
98913	1	1	1	2	1.40	.055	1.85	.073	

After crimping, the conductor profile should measure the following.

Terminal Order No.			Wire Size		Conductor				Pull Force Minimum	
					Crimp Height		Crimp Width (Ref.)			
			AWG	mm ²	mm	In.	mm	In.	N	Lb.
98913-1019	98913-1349	64322-1229	22		0.78-0.88	.031-.035	1.45	.057	50.0	11.25
98913-1229	98913-3019	64322-1329		0.35	0.80-0.86	.031-.034	1.43	.056	55.0	12.38
98913-1329	64322-1019	64322-1349		0.22	0.72-0.78	.028-.031	1.42	.056	40.0	9.00
98913-1039	98913-1419	64322-1039		0.50	0.87-0.93	.034-.037	1.44	.057	70.0	15.75
98913-1239	98913-3039	64322-1239								
98913-1359		64322-1359								

Terminal Order No.			Wire Size		Insulation			
					Crimp Height		Crimp Width (Ref.)	
			AWG	mm ²	mm	In.	mm	In.
98913-1019	98913-1349	64322-1229	22		1.55-1.70	.061-.067	1.88	.074
98913-1229	98913-3019	64322-1329		0.35	1.50-1.65	.059-.065	1.86	.073
98913-1329	64322-1019	64322-1349		0.22	1.35-1.50	.053-.059	1.85	.073
98913-1039	98913-1419	64322-1039		0.50	1.60-1.75	.063-.069	1.87	.074
98913-1239	98913-3039	64322-1239						
98913-1359		64322-1359						

Pull Force should be measured with no influence from the insulation crimp.

The above specifications are guidelines to an optimum crimp.

PARTS LIST

FineAdjust Applicator 63868-9000				
Item	Order No	Engineering No.	Description	Quantity
Perishable Tooling				
	63868-9070	63868-9070	Tool Kit (All "Y" Items)	REF
1	63457-0035	63457-0035	Conductor Punch	1 Y
2	63455-0040	63455-0040	Conductor Anvil	1 Y
3	63454-0060	63454-0060	Insulation Punch	1 Y
4	63456-0040	63456-0040	Insulation Anvil	1 Y
5	63443-0035	63443-0035	Cut-Off Plunger	1 Y
6	63443-0036	63443-0036	Front Plunger Retainer	1 Y
Other Components (689050)				
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	Scrape Chute	1
11	63443-0024	63443-0024	Key	1
12	63443-0090	63443-0090	Wire Stop	1
13	63443-1713	63443-1713	18.30mm Spacer	1
14	63443-2215	63443-2215	15.00mm Spacer	1
15	63443-2312	63443-2312	3.60mm Spacer	1
16	63443-3160	63443-3160	Front Plunger Striker	1
17	63443-6111	63443-6111	Rear Cover	1
18	63443-7003	63443-7003	Terminal Hold Down	1
19	63700-0539	63700-0539	Cut-off Plunger Spring	1
Frame				
20	63800-4901	63800-4901	Top	1
21	63801-3281	63801-3281	Base	1
22	63801-4650	63801-4650	Track	1
Hardware				
23	N/A	N/A	M3 by 6 Long SHCS	2**
24	N/A	N/A	M3 by 6 Long FHCS	1**
25	N/A	N/A	M4 by 6 Long SHCS	2**
26	N/A	N/A	M4 by 12 Long BHCS	2**
27	N/A	N/A	M4 by 50 Long SHCS	2**
28	N/A	N/A	M5 by 12 Long SHCS	1**
29	N/A	N/A	#5-40 by 3/8" Long SHCS	1**
30	N/A	N/A	#10-32 by 3/8" Long Flat Point SSS	1**
31	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

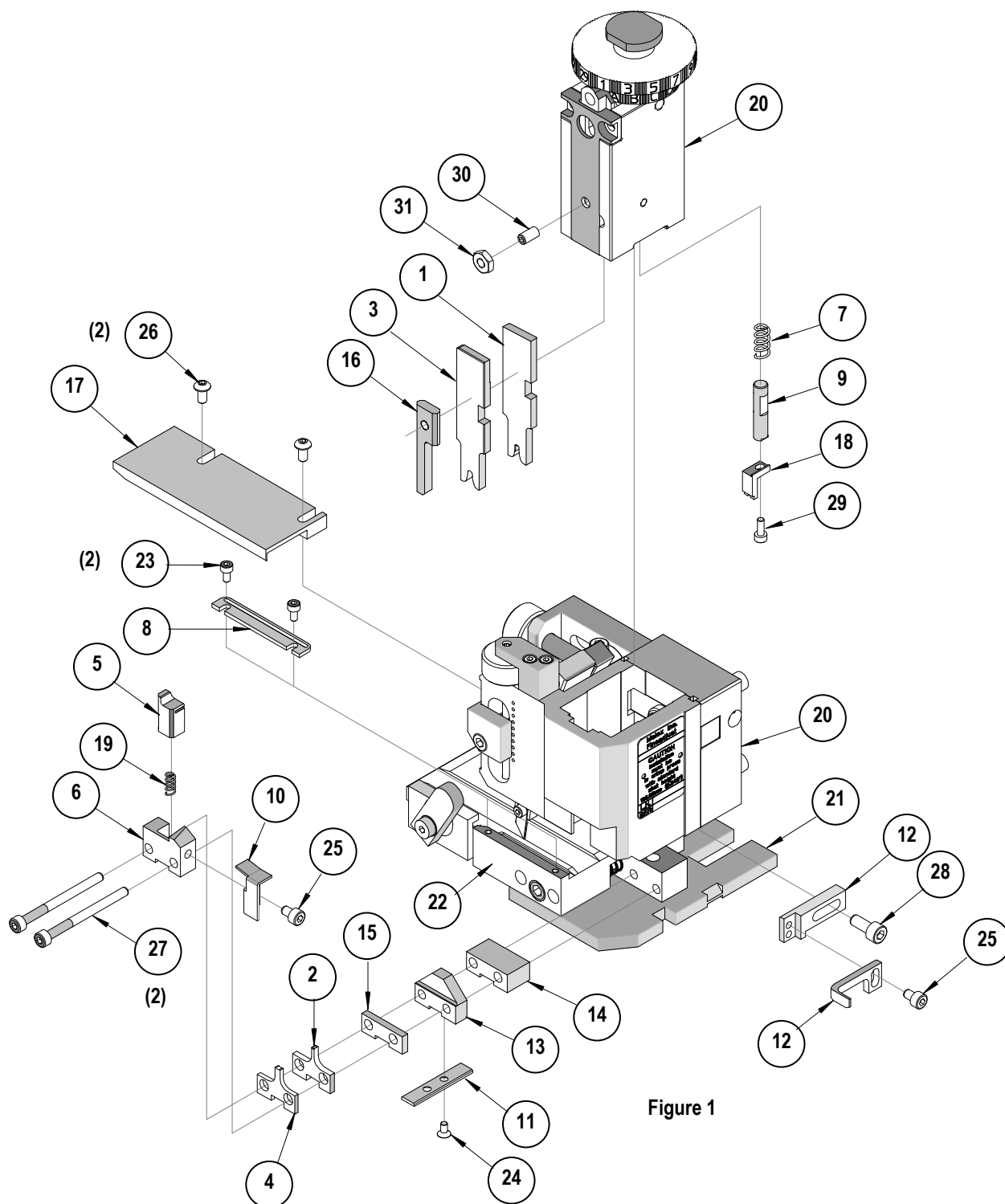


Figure 1

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>

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