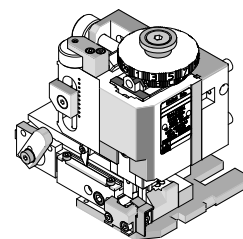


FineAdjust Applicator

molex

Application Tooling Specification Sheet


Order No. 63902-0700

FEATURES

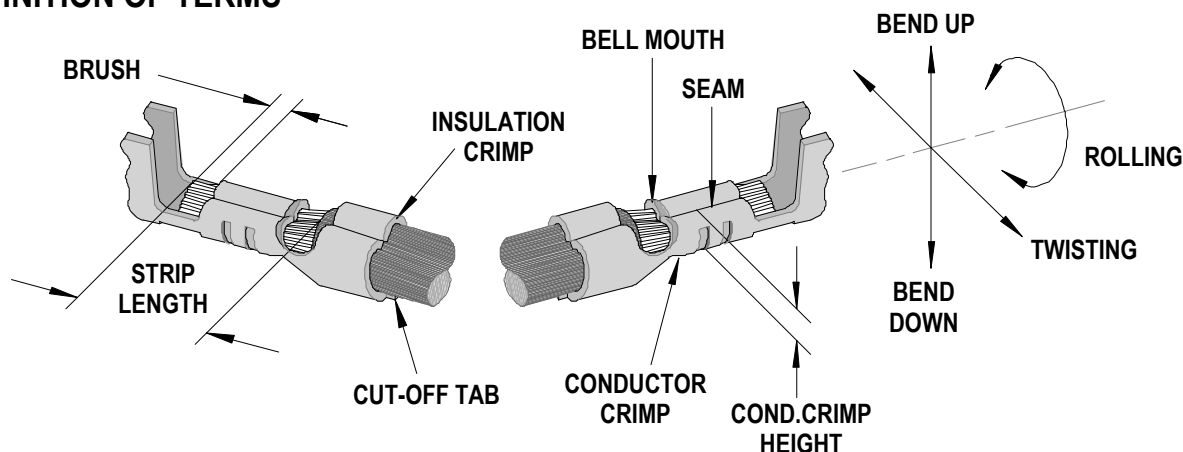
- Quick punch removal with the push of a button for fast and easy tooling change
- Applicator designed to industry standard mounting and shut height 135.80mm (5.346")
- Quick set-up time; plus the crimp height, track and feed adjustments can be set without removing the applicator from the press
- Fine 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: .070 Male Crimp Terminals, 24-26 AWG.

Terminal Series No.	Terminal Order No.	Wire Size		Insulation Diameter				Strip Length	
				IPC/WHMA-A60 (1)		Terminal (2)			
		AWG	mm ²	mm	In.	mm	In.	mm	In.
35745	35745-0410	24	0.20	1.32-1.45	.052-.057	1.32-1.45	.052-.057	4.0-4.8	.157-.189
		26	0.12						
35747	35747-0410	24	0.20	1.32-1.45	.052-.057	1.32-1.45	.052-.057	4.0-4.8	.157-.189
		26	0.12						
(1) To achieve optimum IPC-A620 Class 2 insulation crimps, use this insulation OD.									
(2) Overall insulation OD specification for terminal.									

DEFINITION OF TERMS



The above terminal drawing is a generic terminal representation. It is not an image of any terminal listed in the scope.

CRIMP SPECIFICATION

Terminal Series No.	Bell mouth		Cut-off Tab Maximum		Conductor Brush	
	mm	In.	mm	In.	mm	In.
35745	0.2-0.5	.008-.020	0.40	.016	0.3-0.8	.012-.032
35747	0.2-0.5	.008-.020	0.40	.016	0.3-0.8	.012-.032

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
	Degree	Degree	mm	In	Conductor		Insulation		
					mm	In	mm	In	
35745	3	3	3	5	1.40	.055	2.30	.091	
35747	3	3	3	5	1.40	.055	2.30	.091	

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 (Ref)		Crimp Width (Ref)			
	AWG	mm²	mm	In.	mm	In.	mm	In.	mm	In.	N	Lb.
35745	24	0.20	1.00-1.10	.039-.043	1.40-1.60	.055-.063	2.55	.100	2.30-2.50	.091-.098	29.4	6.61
	26	0.12	0.90-1.00	.035-.039	1.40-1.60	.055-.063	2.45	.097	2.30-2.50	.091-.098	19.6	4.41
35747	24	0.20	1.00-1.10	.039-.043	1.40-1.60	.055-.063	2.55	.100	2.30-2.50	.091-.098	29.4	6.61
	26	0.12	0.90-1.00	.035-.039	1.40-1.60	.055-.063	2.45	.097	2.30-2.50	.091-.098	19.6	4.41

T 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 63902-0700				
Item	Order No	Engineering No.	Description	Quantity
Perishable Tooling				
	63902-0770	63902-0770	Tool Kit (All "Y" Items)	REF
1	63444-1441	63444-1441	Conductor Punch	1 Y
2	63445-1467	63445-1467	Conductor Anvil	1 Y
3	63446-2313	63446-2313	Insulation Punch	1 Y
4	63445-2315	63445-2315	Insulation Anvil	1 Y
5	63443-0002	63443-0002	Cut-Off Plunger Front	1 Y
6	63443-0012	63443-0012	Plunger Retainer Front	1 Y
Other Components				
7	11-17-0022	1739-21	Hold-Down Spring	1
8	11-18-4083	60707-8	Front Cover	1
9	11-24-1067	4996-4	Cut-Off Plunger Spring	1
10	11-40-4039	8302-5	Plunger Striker	1
11	63443-0009	63443-0009	Front Scrap Chute	1
12	63443-0024	63443-0024	Key	1
13	63443-0090	63443-0090	Wire Stop	1
14	63443-0093	63443-0093	Shank	1
15	63443-1715	63443-1715	18.50mm Height Spacer	1
16	63443-2214	63443-2214	14.00mm Coarse Spacer	1
17	63443-2319	63443-2319	3.95mm Fine Spacer	1
18	63443-6119	63443-6119	Rear Cover	1
19	63443-7115	63443-7115	Nose Hold-Down	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	M3 by 8 Long SHCS	1**
26	N/A	N/A	M4 by 6 Long SHCS	2**
27	N/A	N/A	M4 by 12 Long BHCS	2**
28	N/A	N/A	M4 by 50 Long SHCS	2**
29	N/A	N/A	M5 by 12 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

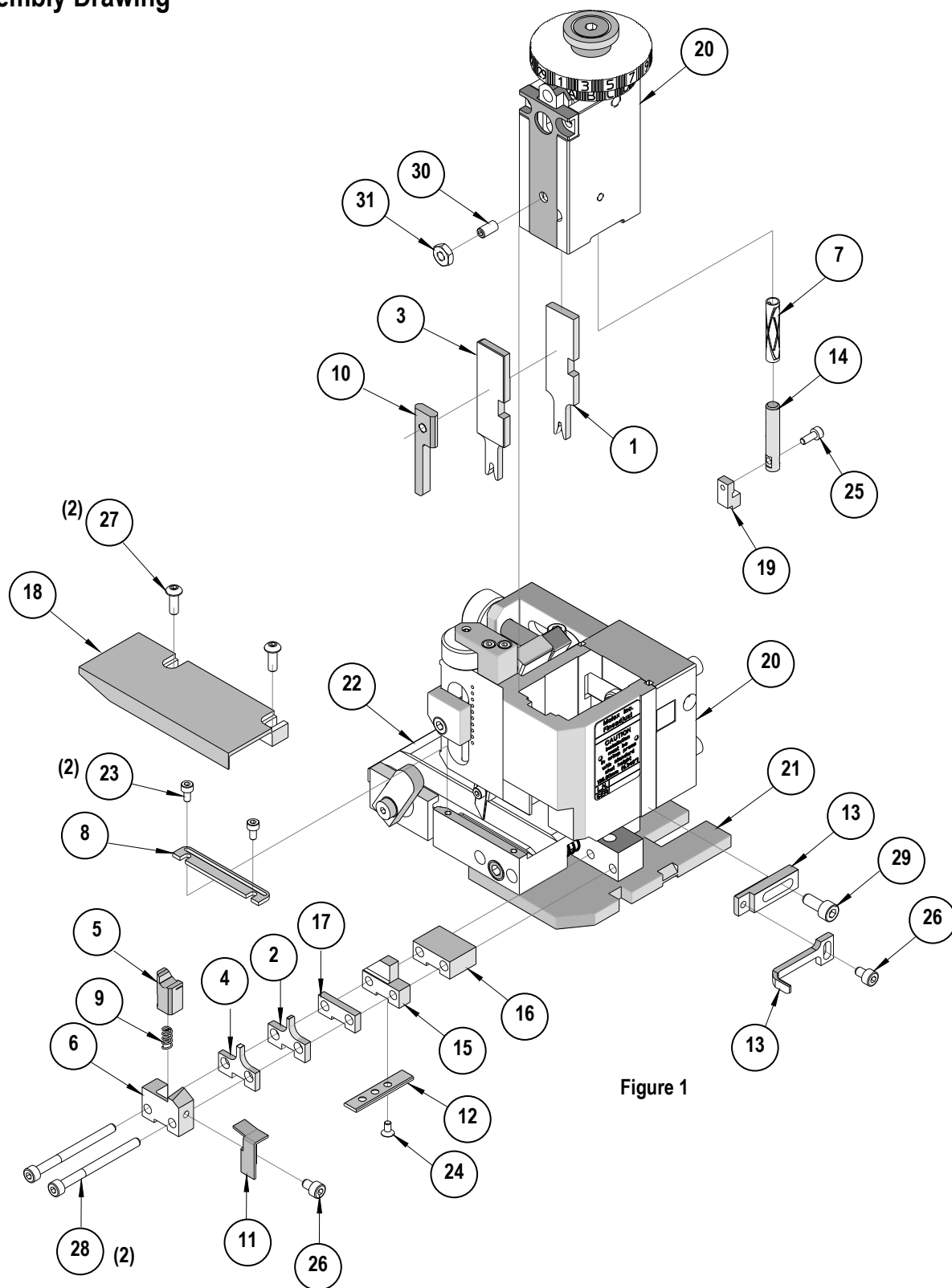


Figure 1

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 135.80 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.

<http://www.molex.com>

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