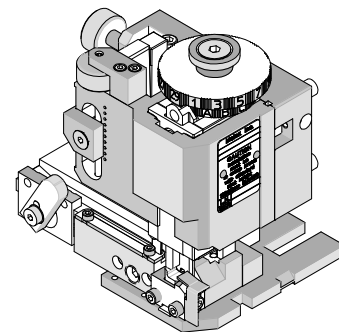




FineAdjust Applicator Applicator Tooling Specification Sheet Order No. 63901-3500



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

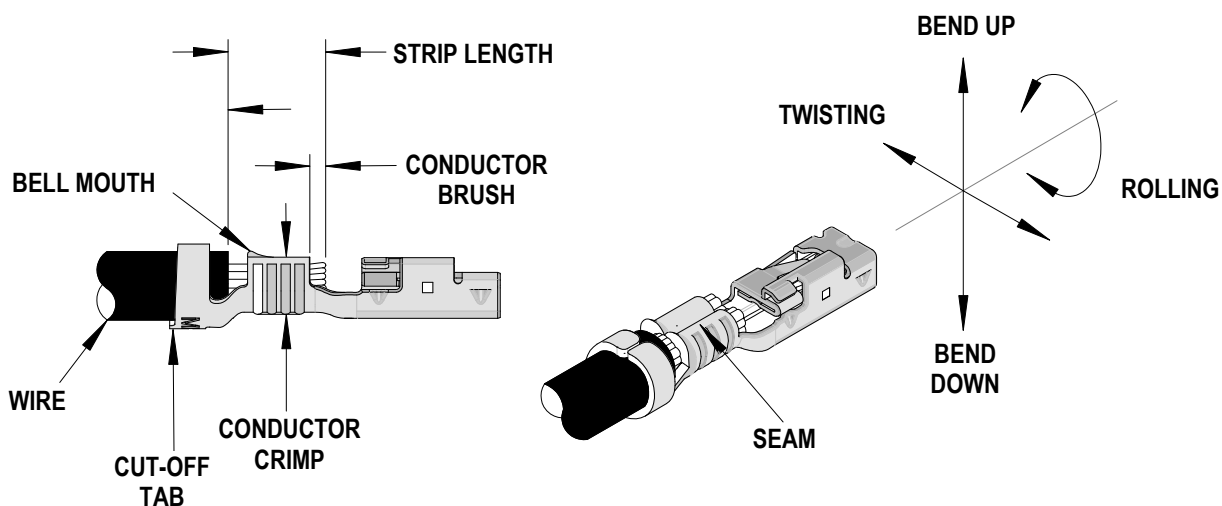
SCOPE

Products: CTX280 Receptacle Terminals: >2.0 - 3.0 mm² metric, type ISO wire.

Terminal Series No.	Terminal Order No.		Wire Size and Type		✗ Insulation Diameter		Strip Length	
			mm ²	Type	mm	In.	mm	In.
98675	98675-0003	98675-0013	>2.0 – 3.0	ISO	2.70-3.40	.106-.134	4.30-4.80	.169-.189
	98675-0023	98675-0033						

✗ See crimp specification for the individual Insulation Diameter.

DEFINITION OF TERMS



CRIMP SPECIFICATION

Terminal Series No.	Bell mouth		Cut-off Tab Maximum		▶ Conductor Brush	
	mm	In.	mm	In.	mm	In.
98675	0.40-0.60	.016-.024	0.30	.012	0.20-0.60	.008-.024
▶ Not to exceed above the conductor crimp height.						

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		Conductor		Insulation		
					mm	In	mm	In	
98675	1	1	2	3	2.80	.110	3.60	.142	

After crimping, the crimp profiles should measure the following:

Terminal Series No.	Wire Size	Conductor				Pull Force Minimum	
		Crimp Height		Crimp Width			
	mm²	mm	In.	mm	In.	N	Lb.
98675	2.50	1.80-1.90	.071-.075	2.85-2.95	.112-.116	235.0	52.8
	3.00	1.90-2.00	.075-.079	2.85-2.95	.112-.116	260.0	58.5

Terminal Series No.	Wire Size	✖Insulation Diameter		Insulation			
				Crimp Height		Crimp Width	
	mm²	mm	In.	mm	In.	mm	In.
98675	2.50	2.70-3.00	.106-.118	3.10-3.30	.122-.130	3.65-3.75	.144-.148
	3.00	3.00-3.40	.118-.134	3.50-3.70	.138-.146	3.65-3.75	.144-.148

▶ Tool Qualification Notes:

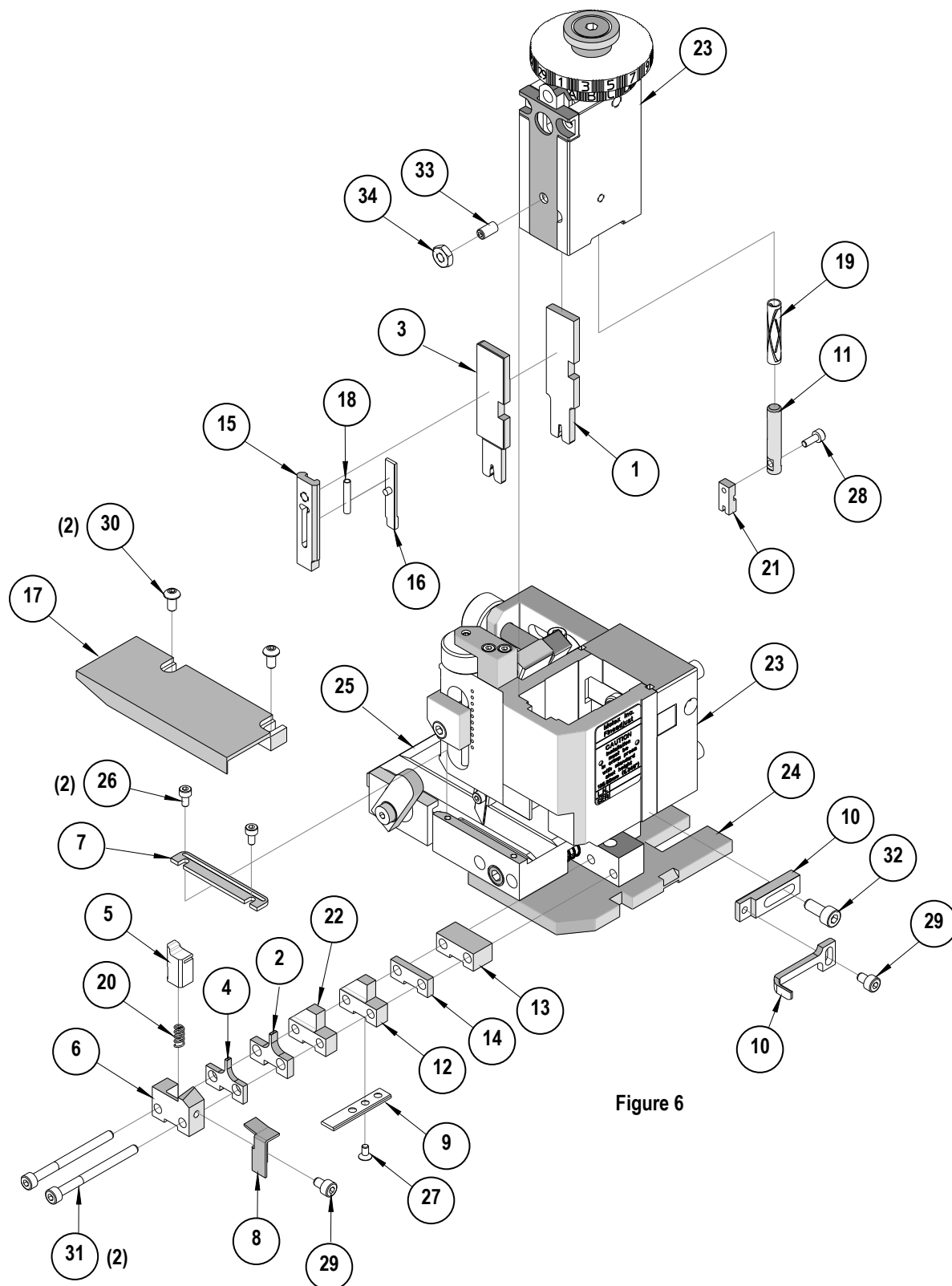
1. Pull Force should be measured with no influence from the insulation crimp.
2. The above specifications are guidelines to an optimum crimp.

PARTS LIST

FineAdjust Applicator 63901-3500				
Item	Order No	Engineering No.	Description	Quantity
Perishable Tooling				
	63901-3570	63901-3570	Tool Kit (All "Y" Items)	REF
1	63444-2821	63444-2821	Conductor Punch	1 Y
2	63455-0081	63455-0081	Conductor Anvil	1 Y
3	63454-0093	63454-0093	Insulation Punch	1 Y
4	63456-0068	63456-0068	Insulation Anvil	1 Y
5	63443-0037	63443-0037	Cut-Off Plunger	1 Y
6	63443-0038	63443-0038	Front Plunger Retainer	1 Y
Other Components				
7	11-18-4094	60709A111	Feed Guide	1
8	63443-0009	63443-0009	Scrap Chute	1
9	63443-0024	63443-0024	Key	1
10	63443-0090	63443-0090	Wire Stop	1
11	63443-0093	63443-0093	Shank	1
12	63443-1715	63443-1715	18.50mm Height Spacer	1
13	63443-2207	63443-2207	7.00mm Coarse Spacer	1
14	63443-2308	63443-2308	3.40mm Fine Spacer	1
15	63443-2801	63443-2801	Front Plunger Striker	1
16	63443-2913	63443-2913	Wire Hold-Down Plunger	1
17	63443-6130	63443-6130	Rear Cover	1
18	63600-1057	63600-1057	Striker Plunger Spring	1
19	63600-3378	63600-3378	Hold Down Spring	1
20	63700-0539	63700-0539	Cut-off Plunger Spring	1
21	63890-0084	63890-0084	Terminal Hold Down	1
22	63890-0085	63890-0085	Spacer	1
Frame				
23	63800-4901	63800-4901	Top	1
24	63801-3281	63801-3281	Base	1
25	63801-4650	63801-4650	Track	1
Hardware				
26	N/A	N/A	M3 by 6 Long SHCS	2**
27	N/A	N/A	M3 by 6 Long FHCS	1**
28	N/A	N/A	M3 by 8 Long SHCS	1**
29	N/A	N/A	M4 by 6 Long SHCS	2**
30	N/A	N/A	M4 by 12 Long BHCS	2**
31	N/A	N/A	M4 by 50 Long SHCS	2**
32	N/A	N/A	M5 by 12 Long SHCS	1**
33	N/A	N/A	#10-32 by 3/8" Long Flat Point SSS	1**
34	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 135.80 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.

Americas Headquarters
Lisle, Illinois 60532 U.S.A.
1-800-78MOLEX
amerinfo@molex.com

Far East North Headquarters
Yamato, Kanagawa, Japan
81-462-65-2324
feninfo@molex.com

Far East South Headquarters
Jurong, Singapore
65-6-268-6868
fesinfo@molex.com

European Headquarters
Munich, Germany
49-89-413092-0
eurinfo@molex.com

Corporate Headquarters
2222 Wellington Ct.
Lisle, IL 60532 U.S.A.
630-969-4550
Fax: 630-969-1352

Visit our Web site at <http://www.molex.com>

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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