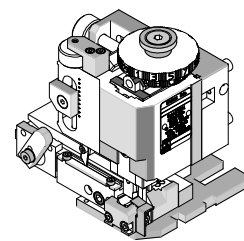




**FineAdjust
Applicator**

**Application Tooling
Specification Sheet**



Order No. 63901-0600

FEATURES

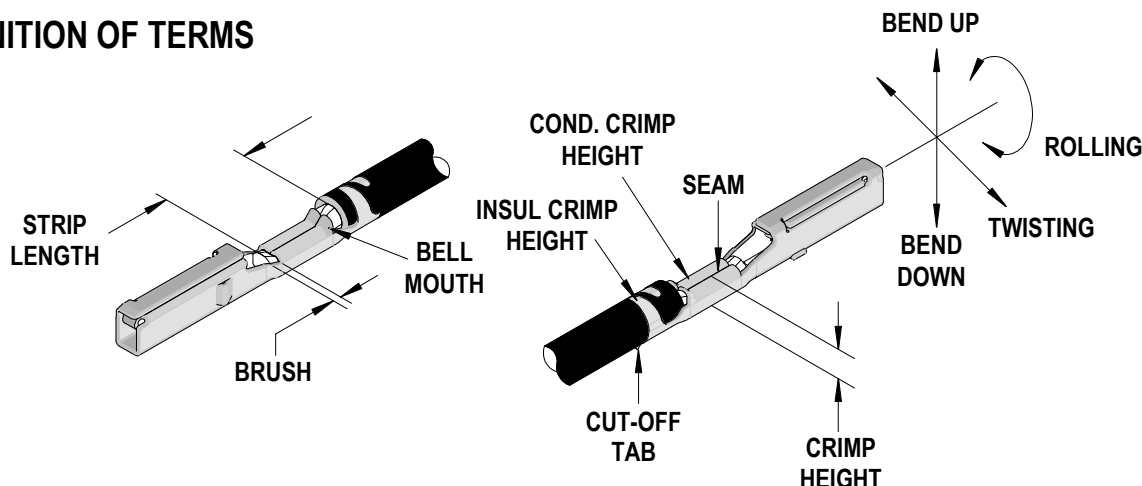
- Quick punch removal with the push of a button for fast and easy tooling change
- Applicator designed to industry standard mounting and shut height 135.80mm (5.346")
- Quick set-up time; plus the crimp height, track and feed adjustments can be set without removing the applicator from the press
- Fine 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: CTX150 Receptacle Terminals, 1.25, 1.50, 2.00mm² wires.

Terminal Series No.	Terminal Order No.		Wire Size		Insulation Diameter		Strip Length (Ref.)	
			AWG	mm ²	mm	In.	mm	In.
502307	502307-0113	502307-0123	Metric Only	JASO 1.25	2.10-2.80	.083-.110	4.50-5.00	.177-.197
	502307-1113	502307-1123	Metric Only	ISO 1.5				
	502307-2113	502307-2123	Metric Only	ISO 2				
			Metric Only	JASO 2				
34805	34805-0113		Metric Only	JASO 1.25	2.10-2.80	.083-.110	4.50-5.00	.177-.197
		Metric Only	ISO 1.5					
		Metric Only	ISO 2					
		Metric Only	JASO 2					

DEFINITION OF TERMS



CRIMP SPECIFICATION

Terminal Series No.	Bell mouth		Cut-off Tab Maximum		* Conductor Brush	
	mm	In.	mm	In.	mm	In.
502307	0.20-0.55	.008-.022	0.30	.012	0.20-1.20	.008-.047
34805						
* Wire brush must be flush or below top of Conductor Crimp.						

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		Degree		mm	In	mm	In	
502307	1.5	1.5	4	6	2.10	.083	2.60	.102	
34805									

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 Maximum		Crimp Width Maximum (Ref.)			
	AWG	mm ²	mm	In.	mm	In.	mm	In.	mm	In.	N	Lb.
502307 34805	Metric Only	JASO 1.25	1.20-1.30	.047-.051	2.10	.083	2.60	.102	2.80	.110	180	40.5
	Metric Only	ISO 1.5	1.30-1.40	.051-.055	2.10	.083	2.65	.104	2.80	.110	155	34.9
	Metric Only	ISO 2	1.45-1.55	.057-.061	2.10	.083	2.80	.110	2.80	.110	245	55.1
	Metric Only	JASO 2	1.50-1.60	.059-.063	2.10	.083	2.80	.110	2.80	.110	245	55.1

■ 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 63901-0600				
Item	Order No	Engineering No.	Description	Quantity
Perishable Tooling				
	63901-0670	63901-0670	Tool Kit (All "Y" Items)	REF
1	63457-0073	63457-0073	Conductor Punch	1 Y
2	63455-0089	63455-0089	Conductor Anvil	1 Y
3	63454-0075	63454-0075	Insulation Punch	1 Y
4	63456-0049	63456-0049	Insulation Anvil	1 Y
5	63443-0003	63443-0003	Cut-Off Plunger	1 Y
6	63443-0012	63443-0012	Front Plunger Retainer	1 Y
Other Components				
7	11-17-0022	1739-21	Hold Down Spring	1
8	11-18-4083	60707-8	Feed Guide	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	63443-0093	63443-0093	Shank	1
13	63443-2209	63443-2209	Coarse Spacer (9.00mm)	1
14	63443-2302	63443-2302	Fine Spacer (3.10mm)	1
15	63443-2804	63443-2804	Front Plunger Striker	1
16	63443-2915	63443-2915	Striker Plunger	1
17	63443-6119	63443-6119	Rear Cover	1
18	63600-1057	63600-1057	Striker Plunger Spring	1
19	11-24-1067	4996-4	Cut-off Plunger Spring	1
20	63443-7104	63443-7104	Terminal Hold Down	1
21	63890-0033	63890-0033	Guide Height Spacer	1
22	63890-0035	63890-0035	Secondary Height 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

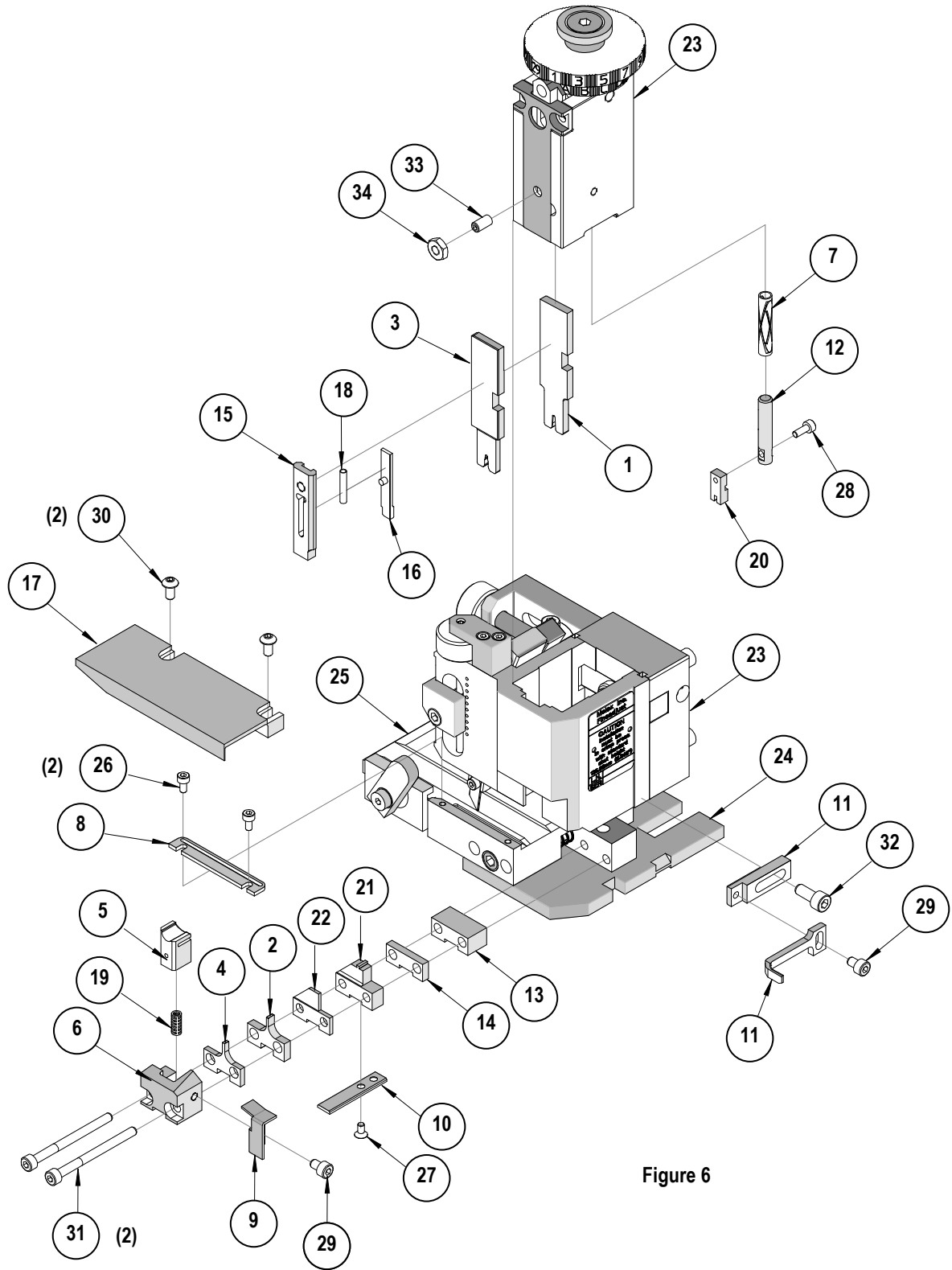


Figure 6

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>