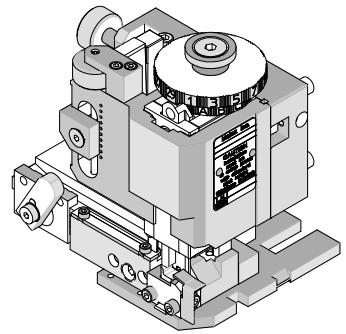




FineAdjust Applicator Applicator Tooling Specification Sheet Order No. 63901-7100



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

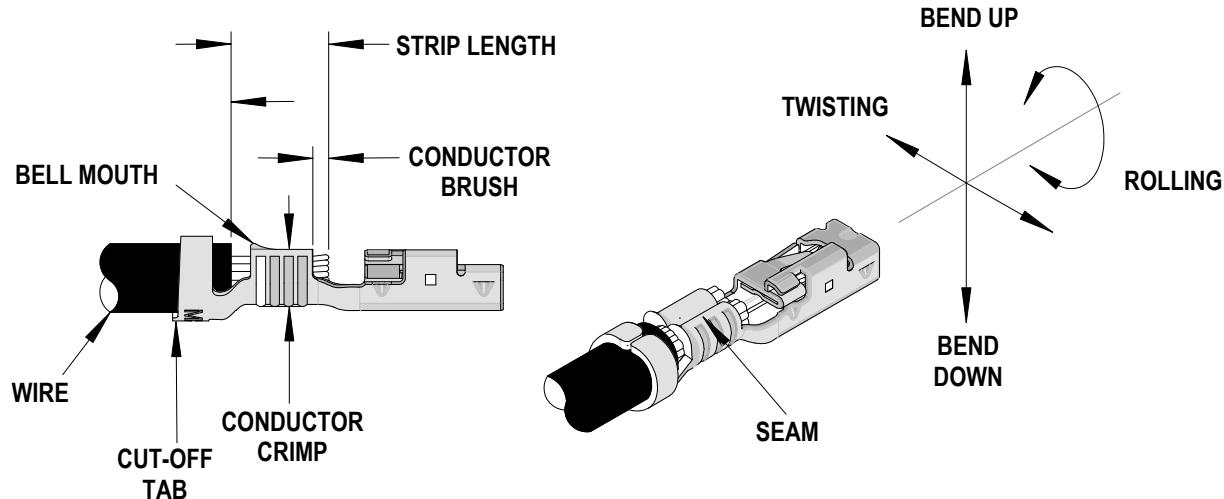
SCOPE

Products: 2.80mm (.110") Pitch UCC2 Receptacle Terminal, 1.50-2.50 mm² metric wire.

Terminal Series No.	Terminal Order No.	Wire Size and Type		Insulation Diameter		Strip Length	
		mm ²	Type	mm	In.	mm	In.
98898	98898-1019	1.50	IR	2.10-3.00	.082-.118	4.50	.177
		2.50	IR	2.10-3.00	.082-.118	4.50	.177

✖ 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.
98898	0.05-1.00	.002-.039	0.30	.012	0.20-1.50	.008-.059
► 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
					Conductor	Insulation	mm	In.	
	Degree		Degree		mm	In.	mm	In.	
98898	3	3	5	3	2.50	.098	4.50	.177	

After crimping, the crimp profiles should measure the following:

Terminal Series No.	Wire Size	Conductor				Pull Force Minimum	
		Crimp Height		Crimp Width (Ref.)		N	Lb.
		mm ²	mm	In.	mm		
98898	1.50	1.75-1.85	.069-.073	2.50	.089	155.0	34.85
	2.50	1.95-2.05	.077-.081	2.50	.089	235.0	52.83

Terminal Series No.	Wire Size	✖ Insulation Diameter		Single Wire Seal		Insulation			
				Crimp Height (Ref.)		Crimp Width (Ref.)			
		mm ²	mm	In.	Order No.	Color	mm	In.	mm
98898	1.50	2.00-2.80	.079-.110	0984921175	Green	4.35-4.65	.171-.183	4.50-4.70	.177-.185
	2.50	2.00-2.80	.079-.110			4.35-4.65	.171-.183	4.50-4.70	.177-.185

► Tool Qualification Notes:

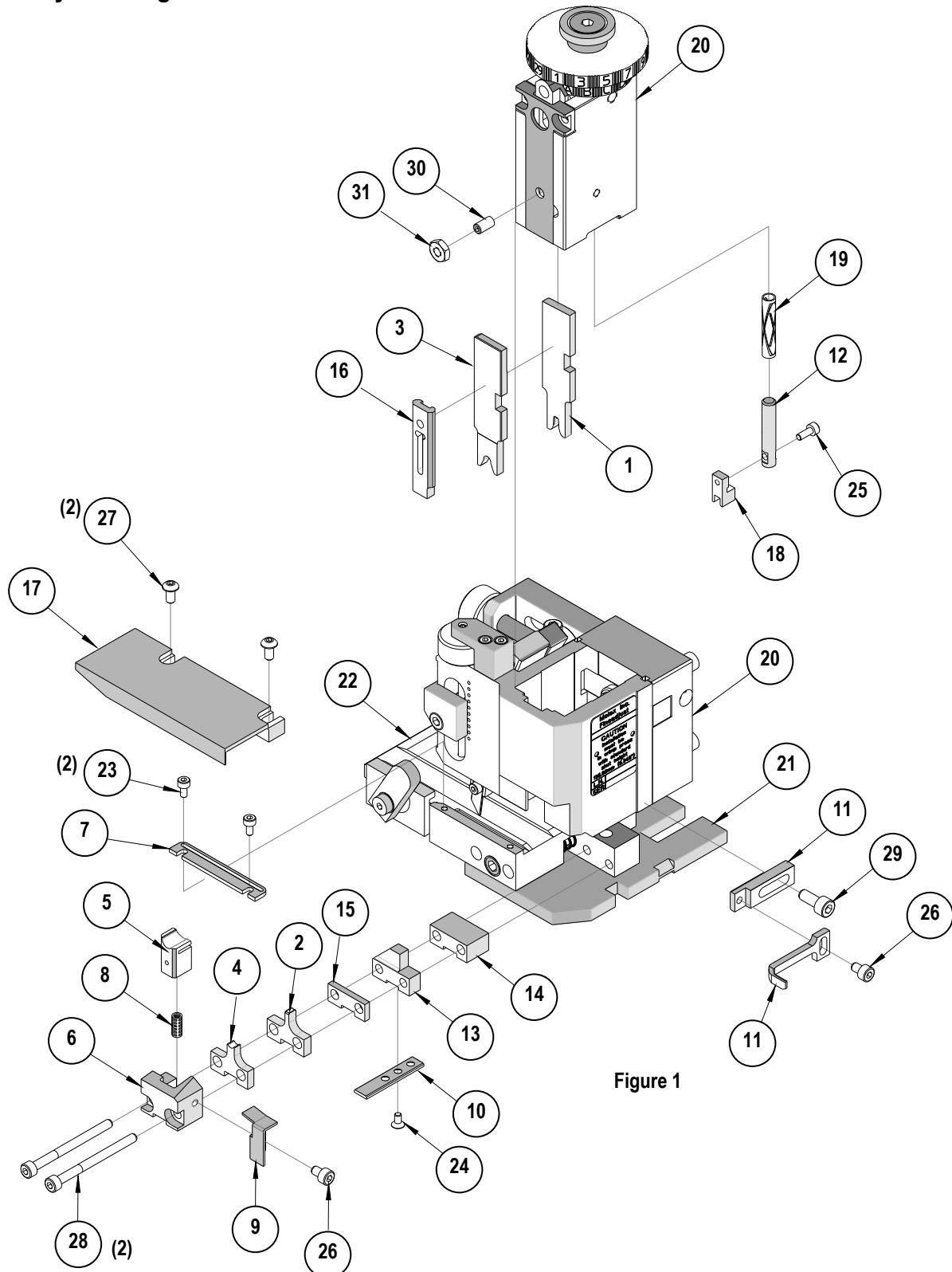
1. Pull Force should be measured with no influence from the insulation crimp.
2. The above specifications are guidelines to an optimum crimp.

PARTS LIST

Fine Adjust Applicator 63901-7100				
Item	Order No	Engineering No.	Description	Quantity
Perishable Tooling				
	63901-7170	63901-7170	Tool Kit (All "Y" Items)	REF
1	63457-0067	63457-0067	Conductor Punch	1 Y
2	63455-0092	63455-0092	Conductor Anvil	1 Y
3	63454-0110	63454-0110	Insulation Punch	1 Y
4	63456-0074	63456-0074	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	11-18-4083	60707-8	Feed Guide	1
8	11-24-1067	4996-4	Cut-off Plunger Spring	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	63443-1716	63443-1716	18.60mm Height Spacer	1
14	63443-2214	63443-2214	14.00mm Spacer	1
15	63443-2301	63443-2301	3.05mm Spacer	1
16	63443-2804	63443-2804	Front Plunger Striker	1
17	63443-6130	63443-6130	Rear Cover	1
18	63443-7113	63443-7113	Terminal Hold Down	1
19	63600-3378	63600-3378	Hold Down 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	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



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.

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