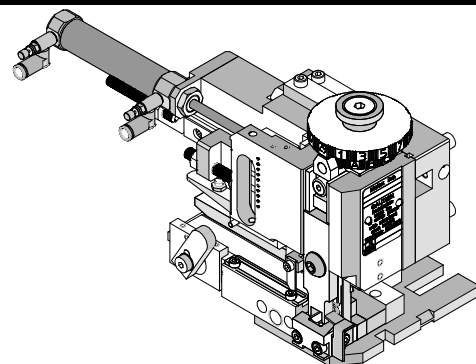




Applicator Air Feed Assembly **Application Tooling Specification** **Order No. 63801-3501**



FEATURES

- Feed stroke adjustable up to 35mm (1.378")
- Fine adjustment of forward feed position
- Air-fed applicator must be installed in a press equipped with an air valve

SCOPE

The air feed assembly is installed in certain Molex FineAdjust™ and Mini-Mac™ applicators. It is not compatible with other manufacturer's applicators.

Molex applicators with air feed require presses equipped with an air valve. Molex presses with air valves include the TM-3000 (63801-7200, 63801-7300) and TM-4000 (63801-7600).

DEFINITION OF TERMS

The principal parts of the air feed assembly are shown in Figure 1 (applicator not shown for clarity)

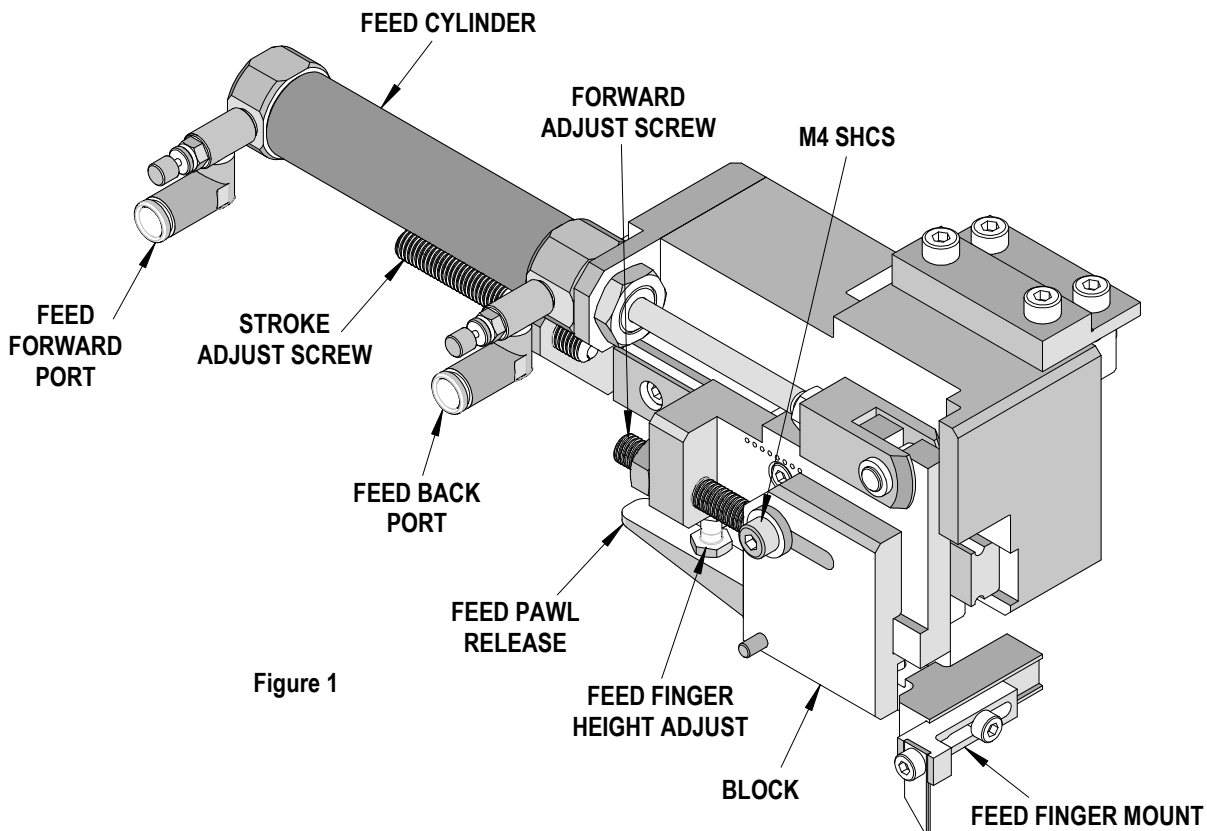


Figure 1

INSTALLATION AND OPERATION

Install the applicator in the press, following the press manufacturer's procedure.

Air line connections are 1/4" nylon tubing. When connecting the tubing to the feed cylinder, the feed forward port must be connected to the "off" valve port. The "on" valve port must be connected to the feed back port. That is, when the press is at rest (with the ram up) the air feed must be forward, not back.

Do not use lubricated air with this air feed. If the press valve is connected to an F-R-L, turn off the lubricator.

When operating the air feed, make sure the terminal drag brake is engaged.

To disengage the feed pawl from the terminal strip, hold down the feed pawl release.

ADJUSTMENTS

Feed speed:

The needle valve on the feed back port controls the feed forward speed. Turn the valve clockwise (CW) to reduce the speed or counterclockwise (CCW) to increase the speed. Tighten the locking ring on the valve when adjustment is complete.

Back feed stroke:

The back stroke of the feed is adjusted with the stroke adjust screw. This adjustment is made if the feed finger is not engaging the terminal strip hole when the feed is back.

Forward feed stroke:

The forward stroke of the feed (to position the terminal over the anvils) is adjusted by loosening the M4 SHCS and turning the forward adjust screw. Make sure the block is against the adjust screw before retightening the M4 SHCS.

Feed finger alignment:

To position the feed finger in the groove of the applicator track, loosen the M3 SHCS on the front of the feed finger mount and slide the feed finger in or out to the correct position.

Feed finger height:

To prevent excessive engagement of the feed finger tip with the applicator track, the finger can be adjusted up using the feed finger height adjust screw.

NOTE: If the feed finger is adjusted too high, it may not consistently engage the terminal strip hole during feeding.

PARTS LIST

Applicator Air Feed Assembly 63801-3501				
Item	Order No	Engineering No.	Description	Quantity
1	62500-1583	62500-1583	Flow Control, Cylinder Mounted	2
2	63600-2030	63600-2030	Cylinder Clevis	1
3	63600-2031	63600-2031	Miniature Linear Guide Rail	1
4	63600-2032	63600-2032	Compression Spring	1
5	63600-2033	63600-2033	Air Cylinder	1
6	63600-2037	63600-2037	Locating Bolt	1
7	63600-3026	63600-3026	M6 Hex Nut	2
8	63801-3502	63801-3502	Feed Mount	1
9	63801-3503	63801-3503	Feed Mount Clamp	1
10	63801-3504	63801-3504	Slide Plate	1
11	63801-3505	63801-3505	Feed Arm Guide	1
12	63801-3508	63801-3508	Feed Arm	1
13	63801-3509	63801-3509	Cylinder Mount	1
14	63801-3510	63801-3510	Back Stop	1
15	63801-3512	63801-3512	Feed Mount Aligner	1
16	63801-4462	63801-4462	Feed Finger Mount	1
17	63801-4561	63801-4561	Feed Pawl	1
Hardware				
18	N/A	N/A	M3 by 5 Long SHCS	1**
19	N/A	N/A	M3 by 6 Long SHCS	4**
20	N/A	N/A	M3 by 8 Long SHCS	5**
21	N/A	N/A	M4 by 8 Long SHCS	2**
22	N/A	N/A	M4 by 10 Long SHCS	4**
23	N/A	N/A	M4 by 12 Long SHCS	3**
24	N/A	N/A	M4 by 20 Long SHCS	2**
25	N/A	N/A	M6 by 35 Long Set Screw	1**
26	N/A	N/A	M6 by 50 Long Set Screw	1**
27	N/A	N/A	M4 Flat Hard Washer	1**
28	N/A	N/A	M3 by 25 Long Dowel	1**

** Available from an industrial supply company such as MSC (1-800-645-7270).

Assembly Drawing

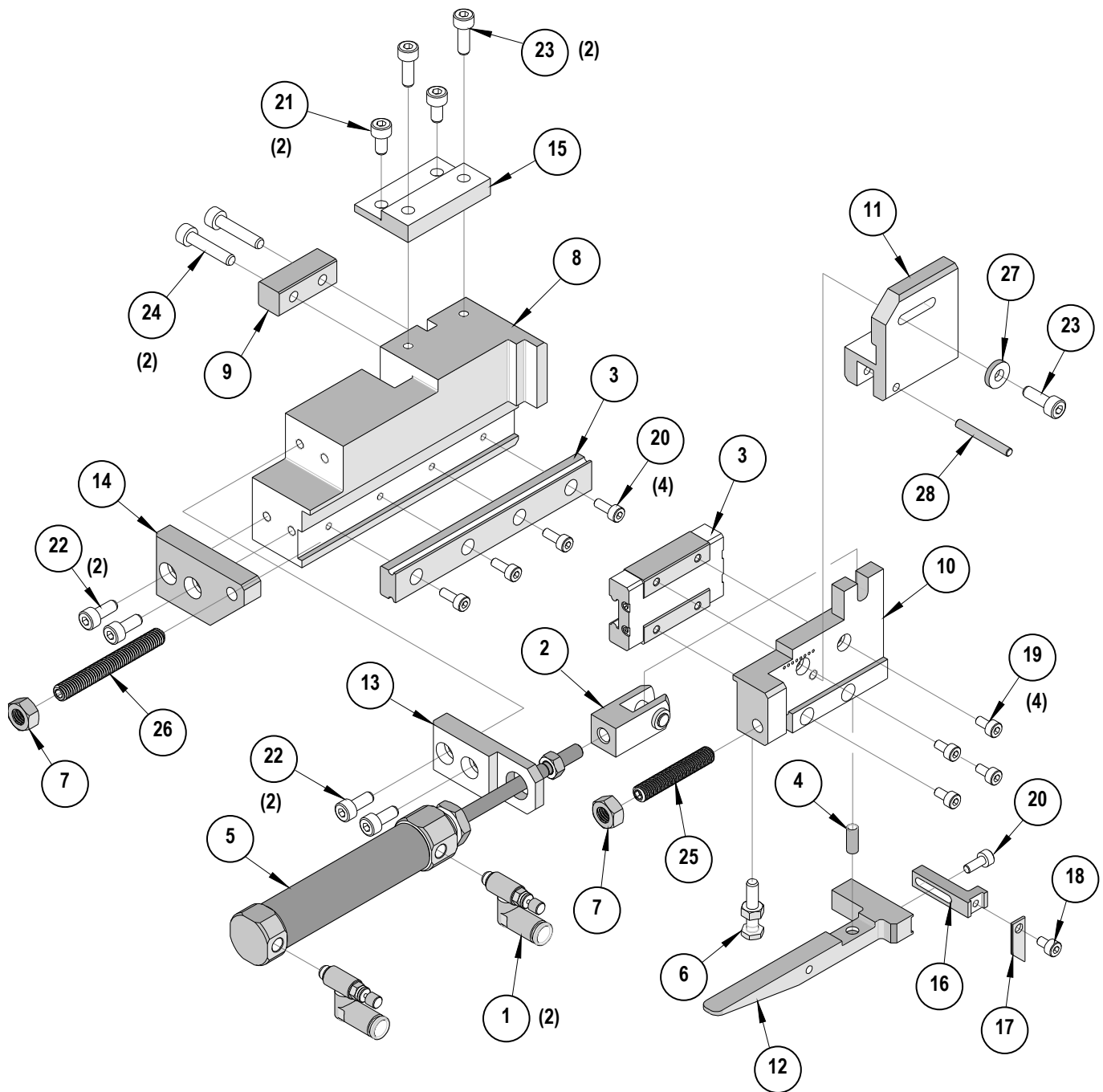


Figure 1

NOTES

1. Molex recommends an extra applicator perishable tooling kit be maintained at your facility.
2. Verify tooling alignment by manually cycling the press with 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 Mini-Mac Applicator Manual (Document no. 63880-0000).

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.

Contact Information

For more information on Molex Application Tooling please contact Molex at 1-800-786-6539.

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