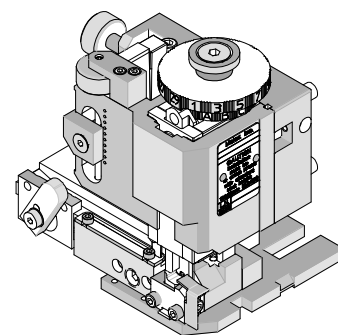




FineAdjust Applicator

Applicator Tooling Specification Sheet

Order No. 63901-6500



FEATURES

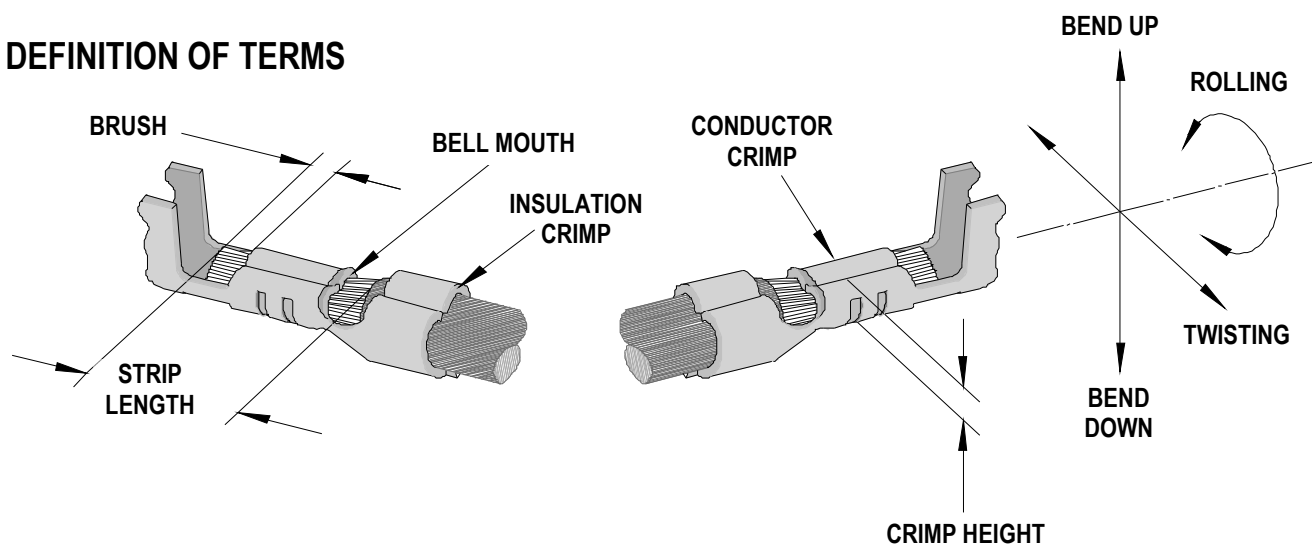
- Quick punch removal with the push of a button for fast and easy tooling change
- Applicator designed to industry standard mounting and shut height 135.80mm (5.346")
- Quick set-up time; plus the crimp height, track and feed adjustments can be set without removing the applicator from the press
- Fine 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: HDX™ Crimp Receptacle Terminal, Female, 0.635mm (.025"), AWG 20-24 (0.22-0.60mm²).

Terminal Series No.	Terminal Order No.	Wire Size		Insulation Diameter				Strip Length	
				IPC/WHMA-A620 ♦		Terminal ♦♦			
		AWG	mm²	mm	In.	mm	In.	mm	In.
98587	98587-0014	0.22 R1	0.22	1.15-1.25	.045-.049	1.15-1.25	.045-.049	3.60-4.40	.142-.173
		0.35 R1 R3	0.34	1.25-1.40	.049-.055	1.25-1.40	.049-.055		
		0.35 D3	0.34	1.20-1.35	.047-.053	1.20-1.35	.047-.053		
		0.50 R1 R3	0.478	1.45-1.60	.057-.063	1.45-1.60	.057-.063		
		0.50 D3	0.478	1.40-1.50	.055-.059	1.40-1.50	.055-.059		
		0.60 R1 R3	0.59	1.75-1.90	.069-.075	1.75-1.90	.069-.075		
98588	98588-0014	0.22 R1	0.22	1.15-1.25	.045-.049	1.15-1.25	.045-.049	3.60-4.40	.142-.173
		0.35 R1 R3	0.34	1.25-1.40	.049-.055	1.25-1.40	.049-.055		
		0.35 D3	0.34	1.20-1.35	.047-.053	1.20-1.35	.047-.053		
		0.50 R1 R3	0.478	1.45-1.60	.057-.063	1.45-1.60	.057-.063		
		0.50 D3	0.478	1.40-1.50	.055-.059	1.40-1.50	.055-.059		
		0.60 R1 R3	0.59	1.75-1.90	.069-.075	1.75-1.90	.069-.075		
♦ To achieve optimum IPC-A620 insulation crimps, use this insulation OD range.									
♦♦ Overall insulation OD specification for terminal.									

DEFINITION OF TERMS



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

CRIMP SPECIFICATION

Terminal Series No.	Bell mouth		Cut-off Tab Maximum		Conductor Brush Minimum	
	mm	In.	mm	In.	mm	In.
98587	*	*	0.25	.010	0.10	.004
98588	*	*	0.25	.010	0.10	.004

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	
98587	*	*	3	3	1.50	.059	2.30	.090	
98588	*	*	3	3	1.50	.059	2.30	.090	

* Specifications not available

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		Crimp Width (Ref.)			
	AWG	mm ²	mm	In.	mm	In.	mm	In.	mm	In.	N	Lb.
98587	0.22 R1	0.22	0.98-1.04	.039-.041	1.40-1.60	.055-.063	1.46-1.66	.057-.065	2.10-2.30	.082-.090	50.0	11.24
	0.35 R1 R3	0.34	1.02-1.08	.040-.042	1.40-1.60	.055-.063	1.50-1.70	.059-.067	2.10-2.30	.082-.090	60.0	13.49
	0.35 D3	0.34	1.02-1.08	.040-.042	1.40-1.60	.055-.063	1.35-1.55	.053-.061	2.10-2.30	.082-.090	60.0	13.49
	0.50 R1 R3	0.478	1.04-1.10	.041-.043	1.40-1.60	.055-.063	1.90-2.00	.075-.078	2.20-2.40	.087-.094	80.0	17.98
	0.50 D3	0.478	1.04-1.10	.041-.043	1.40-1.60	.055-.063	1.45-1.65	.057-.065	2.20-2.40	.087-.094	80.0	17.98
	0.60 R1 R3	0.59	1.11-1.17	.044-.046	1.40-1.60	.055-.063	1.90-2.00	.075-.078	2.25-2.35	.089-.093	100.0	22.48
98588	0.22 R1	0.22	0.98-1.04	.039-.041	1.40-1.60	.055-.063	1.46-1.66	.057-.065	2.10-2.30	.082-.090	50.0	11.24
	0.35 R1 R3	0.34	1.02-1.08	.040-.042	1.40-1.60	.055-.063	1.50-1.70	.059-.067	2.10-2.30	.082-.090	60.0	13.49
	0.35 D3	0.34	1.02-1.08	.040-.042	1.40-1.60	.055-.063	1.35-1.55	.053-.061	2.10-2.30	.082-.090	60.0	13.49
	0.50 R1 R3	0.478	1.04-1.10	.041-.043	1.40-1.60	.055-.063	1.90-2.00	.075-.078	2.20-2.40	.087-.094	80.0	17.98
	0.50 D3	0.478	1.04-1.10	.041-.043	1.40-1.60	.055-.063	1.45-1.65	.057-.065	2.20-2.40	.087-.094	80.0	17.98
	0.60 R1 R3	0.59	1.11-1.17	.044-.046	1.40-1.60	.055-.063	1.90-2.00	.075-.078	2.25-2.35	.089-.093	100.0	22.48

■ Tool Qualification Notes:

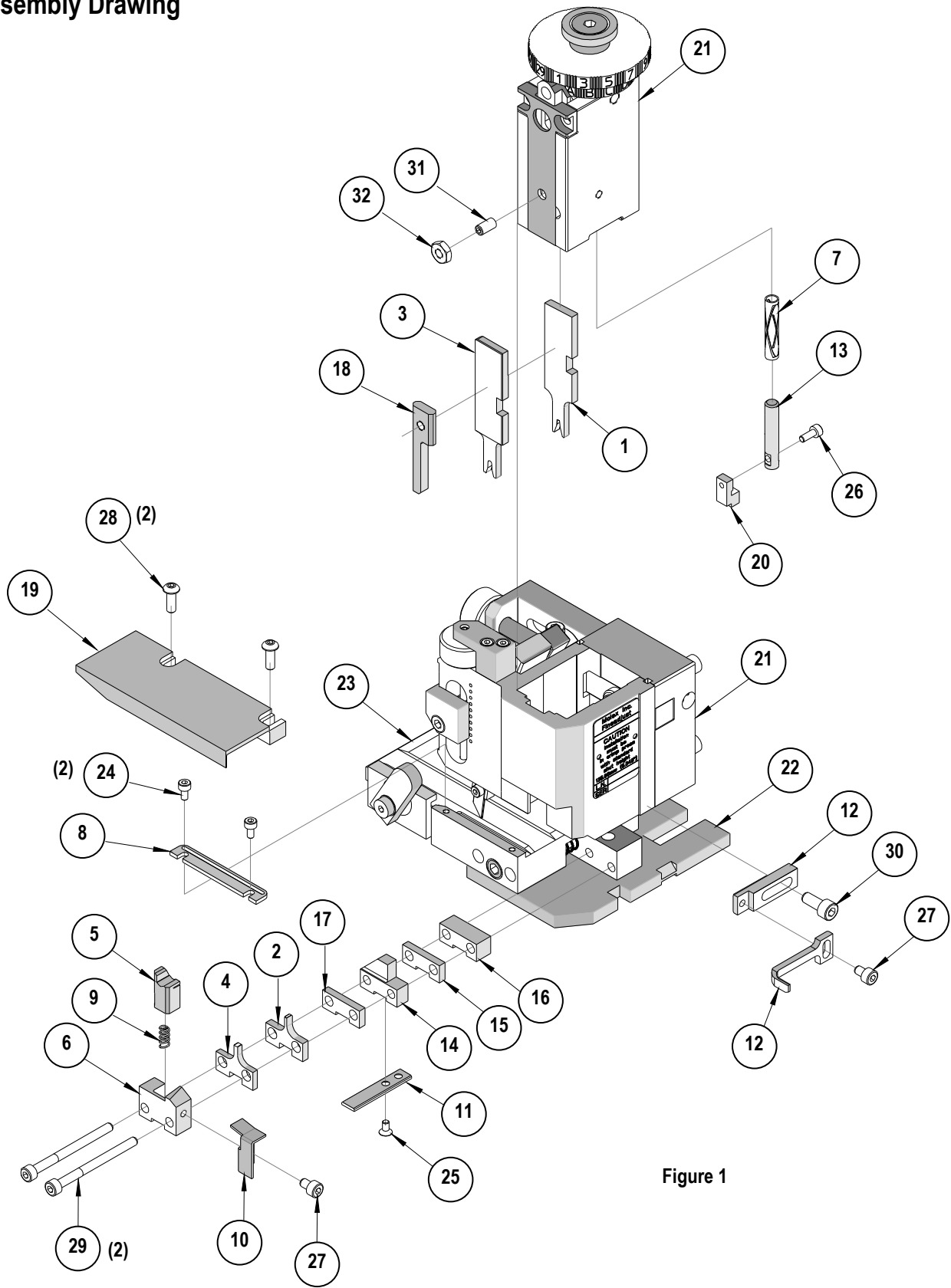
1. Pull Force should be measured with no influence from the insulation crimp.
2. The above specifications are guidelines to an optimum crimp.

PARTS LIST

FineAdjust Applicator 63901-6500				
Item	Order No	Engineering No.	Description	Quantity
Perishable Tooling				
	63901-6570	63901-6570	Tool Kit (All "Y" Items)	REF
1	63457-0062	63457-0062	Conductor Punch	1 Y
2	63455-0086	63455-0086	Conductor Anvil	1 Y
3	63454-1105	63454-1105	Insulation Punch	1 Y
4	63456-0065	63456-0065	Insulation Anvil	1 Y
5	63443-0005	63443-0005	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	11-24-1067	4996-4	Cut-off Plunger Spring	1
10	63443-0009	63443-0009	Scrap Chute	1
11	63443-0024	63443-0024	Key	1
12	63443-0090	63443-0090	Wire Stop	1
13	63443-0093	63443-0093	Shank	1
14	63443-1720	63443-1720	19.00mm Spacer	1
15	63443-2204	63443-2204	4.00mm Spacer	1
16	63443-2210	63443-2210	10.00mm Spacer	1
17	63443-2311	63443-2311	3.55mm Spacer	1
18	63443-3101	63443-3101	Front Plunger Striker	1
19	63443-6112	63443-6112	Rear Cover	1
20	63443-7106	63443-7106	Terminal Hold Down	1
Frame				
21	63800-4901	63800-4901	Top	1
22	63801-3281	63801-3281	Base	1
23	63801-4650	63801-4650	Track	1
Hardware				
24	N/A	N/A	M3 by 6 Long SHCS	2**
25	N/A	N/A	M3 by 6 Long FHCS	1**
26	N/A	N/A	M3 by 8 Long SHCS	1**
27	N/A	N/A	M4 by 6 Long SHCS	2**
28	N/A	N/A	M4 by 12 Long BHCS	2**
29	N/A	N/A	M4 by 50 Long SHCS	2**
30	N/A	N/A	M5 by 12 Long SHCS	1**
31	N/A	N/A	#10-32 by 3/8" Long Flat Point SSS	1**
32	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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Тел: +7 (812) 336 43 04 (многоканальный)

Email: org@lifeelectronics.ru

www.lifeelectronics.ru