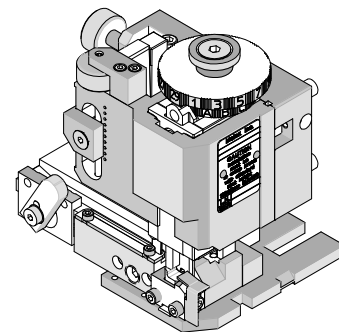




FineAdjust Applicator Applicator Tooling Specification Sheet Order No. 63901-3600



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

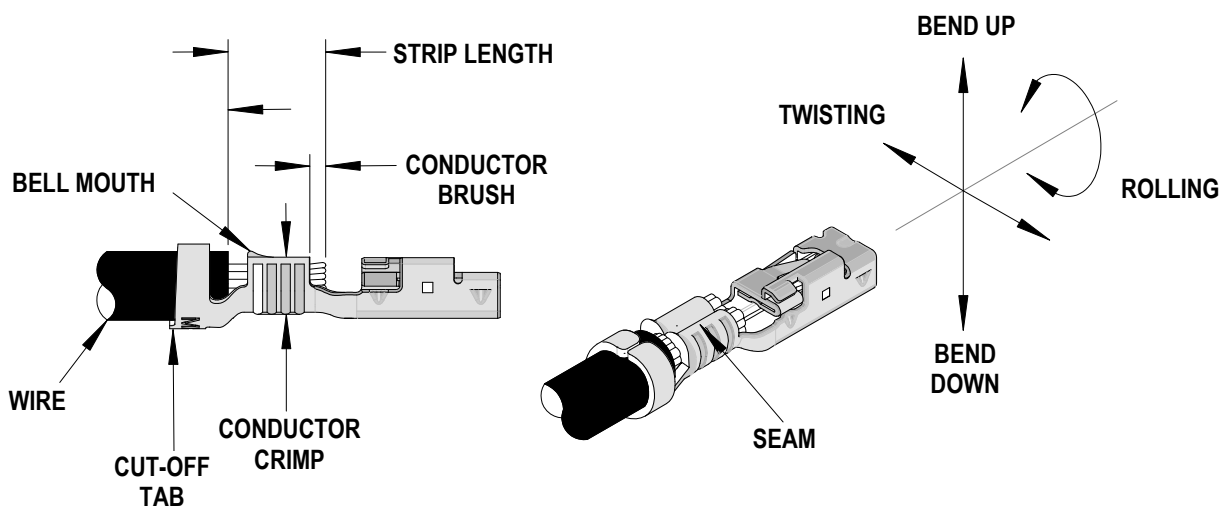
SCOPE

Products: CTX280 Receptacle Terminals: >1.00-2.00 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	98675-0002	98675-0012	>1.00 – 2.00	ISO	2.10-2.80	.083-.110	4.30-4.80	.169-.189
	98675-0022	98675-0032						

✗ 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	2.50	.098	3.00	.118	

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	1.50	1.40-1.50	.055-.059	2.50-2.60	.098-.102	155.0	34.8
	2.00	1.50-1.60	.059-.063	2.50-2.60	.098-.102	195.0	43.8

Terminal Series No.	Wire Size	✗ Insulation Diameter		Insulation			
				Crimp Height		Crimp Width	
		mm	In.	mm	In.	mm	In.
98675	1.50	2.10-2.40	.083-.094	2.75-2.95	.108-.116	3.04-3.14	.120-.124
	2.00	2.30-2.80	.091-.110	3.05-3.25	.120-.128	3.04-3.14	.120-.124

▶ 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 63901-3600				
Item	Order No	Engineering No.	Description	Quantity
Perishable Tooling				
	63901-3670	63901-3670	Tool Kit (All "Y" Items)	REF
1	63444-2521	63444-2521	Conductor Punch	1 Y
2	63455-0082	63455-0082	Conductor Anvil	1 Y
3	63454-0091	63454-0091	Insulation Punch	1 Y
4	63456-0069	63456-0069	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	63443-1710	63443-1710	18.00mm Height Spacer	1
13	63443-2207	63443-2207	7.00mm Coarse Spacer	1
14	63443-2308	63443-2308	3.40mm Fine Spacer	1
15	63443-2804	63443-2804	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	63890-0087	63890-0087	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

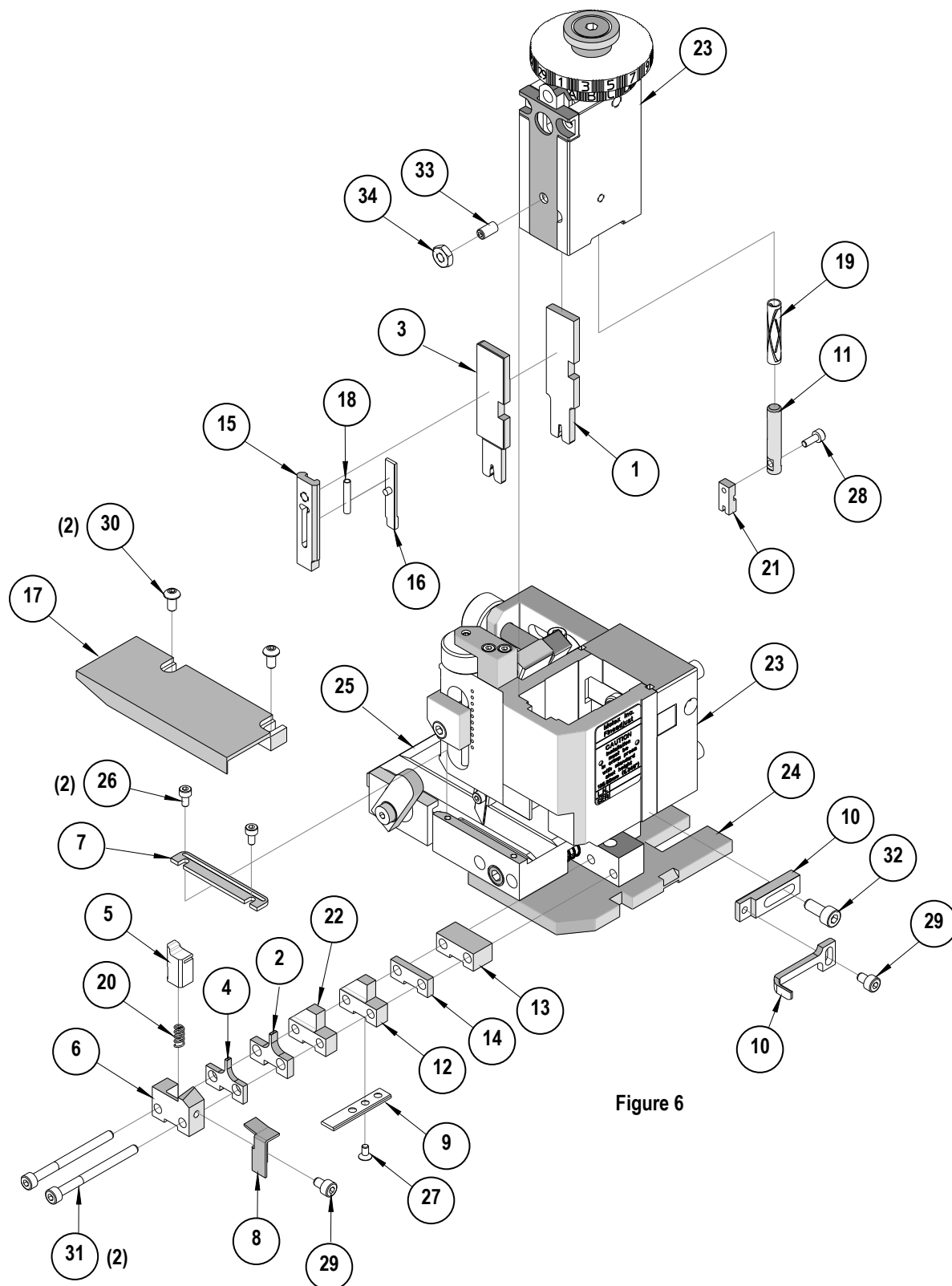


Figure 6

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.

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