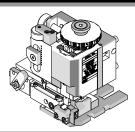


### FineAdjust Applicator

# Application Tooling Specification Sheet



### Order No. 63868-8000

# FEATURES

- Directly adapts to most automatic wire processing machines
- 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

# SCOPE

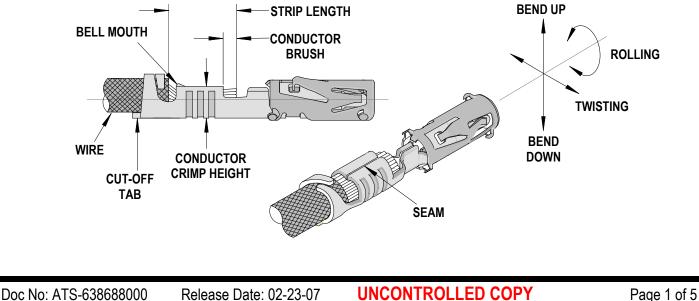
Revision: D

Products: 1.50mm (.059") CP Crimp Terminal for CMC connector, 0.50-1.00mm<sup>2</sup>.

Revision Date: 04-05-11

Terminal Series No.	Terminal Order No.	Wire Size		Insulation	Insulation	Strip Length		
Terminal Series NO.	Terminal Order No.	AWG	mm²	Туре	mm	In.	mm	In.
	98915-1029 98915-1319		1.00	ID and IR	1.75-2.00	.069079	4.50	.177
98915			0.75	ID	1.65-1.80	.065071	4.50	.177
			0.60	IR	1.75-1.90	.069075	4.50	.177
			0.50	ID	1.35-1.50	.053059	4.50	.177
			1.00	ID and IR	1.75-2.00	.069079	4.50	.177
64323	64323-1029		0.75	ID	1.65-1.80	.065071	4.50	.177
	64323-1319		0.60	IR	1.75-1.90	.069075	4.50	.177
			0.50	ID	1.35-1.50	.053059	4.50	.177

### **DEFINITION OF TERMS**



## **CRIMP SPECIFICATION**

Terminal Series No.	Bell n	nouth	Cut-off Tab	Maximum	Conductor Brush		
	mm	In.	mm	ln.	mm	In.	
98915	0.00-0.30	.000012	0.30	.012	0.20-0.80	.008031	
64323	0.00-0.30	.000012	0.30	.012	0.20-0.80	.008031	

	Bend up Bend down		Twist	Roll	Punch Width (Ref)				Seam
Terminal Series No.			IWISU	RUII	Conductor		Insulation		
	Degree Maximum		Degree Maximum		mm	In	mm	In	Seam shall not be open
98915	2	2	2	2	2.00	.079	2.50	.098	and no wire allowed out
64323	2	2	2	2	2.00	.079	2.50	.098	of the crimping area

After crimping, the conductor profile should measure the following.

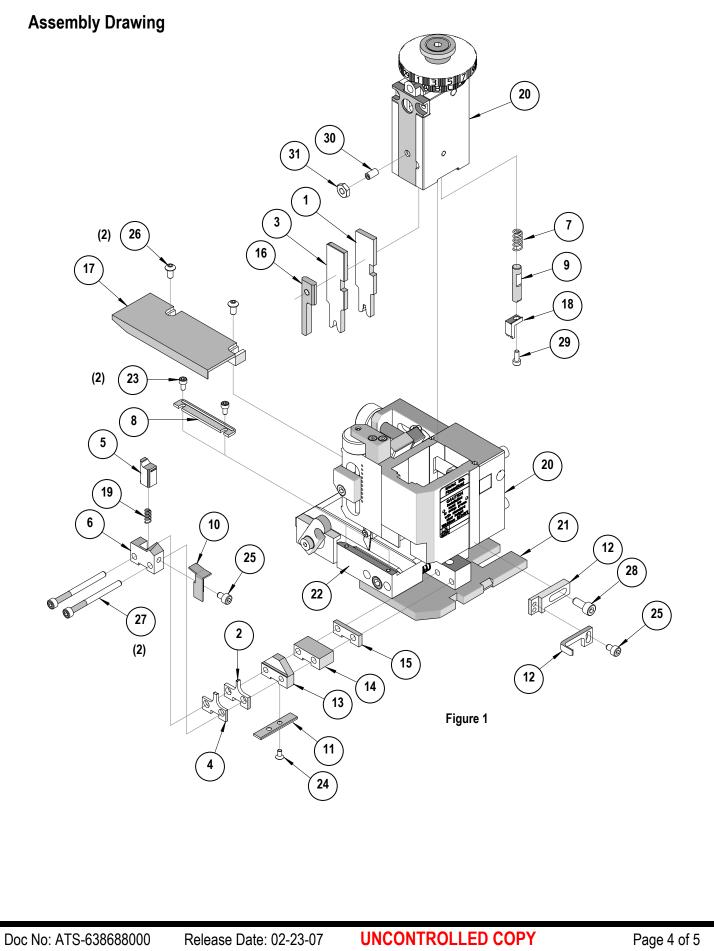
Terminal Series No.	Wire Size		Conductor C	rimp Height	Insulation Crim	p Height (Ref.)	Pull Force Minimum		
Terminal Series No.	AWG	mm <sup>2</sup>	mm	ln.	mm	ln.	Ν	Lb.	
		1.00	1.27-1.37	.050054	2.55-2.70	.100106	115.0	25.90	
98915		0.75	1.20-1.30	.047051	2.35-2.50	.093098	90.0	20.25	
		0.60	1.15-1.25	.045049	2.35-2.50	.093098	80.0	18.00	
		0.50	1.10-1.20	.043047	2.20-2.35	.087093	70.0	15.75	
		1.00	1.27-1.37	.050054	2.55-2.70	.100106	115.0	25.90	
64323		0.75	1.20-1.30	.047051	2.35-2.50	.093098	90.0	20.25	
04323		0.60	1.15-1.25	.045049	2.35-2.50	.093098	80.0	18.00	
		0.50	1.10-1.20	.043047	2.20-2.35	.087093	70.0	15.75	

#### \* 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 63868-8000								
ltem	Order No	Engineering No.	Description	Quantity					
	Perishable Tooling								
	63868-8070	63868-8070	Tool Kit (All "Y" Items)	REF					
1	63457-0033	63457-0033	Conductor Punch	1 Y					
2	63455-0038	63455-0038	Conductor Anvil	1 Y					
3	63454-0058	63454-0058	Insulation Punch	1 Y					
4	63456-0038	63456-0038	Insulation Anvil	1 Y					
5	63443-0035	63443-0035	Cut-Off Plunger	1 Y					
6	63443-0036	63443-0036	Front Plunger Retainer	1 Y					
			Components						
7	11-17-0022	1739-21	Hold Down Spring	1					
8	11-18-4083	60707-8	Feed Guide	1					
9	11-24-1149	4996-37	Shank	1					
10	63443-0009	63443-0009	Scrape Chute	1					
11	63443-0024	63443-0024	Key	1					
12	63443-0090	63443-0090	Wire Stop	1					
13	63443-1715	63443-1715	Height Spacer	1					
14	63443-2214	63443-2214	Course Spacer (14.0mm)	1					
15	63443-2307	63443-2307	Fine Spacer (3.35mm)	1					
16	63443-3160	63443-3160	Front Plunger Striker	1					
17	63443-6121	63443-6121	Rear Cover	1					
18	63443-7002	63443-7002	Terminal Hold Down	1					
19	63700-0539	63700-0539	Cut-off Plunger Spring	1					
			Frame	•					
20	63800-4901	63800-4901	Тор	1					
21	63801-3281	63801-3281	Base	1					
22	63801-4650	63801-4650	Track	1					
		Н	ardware						
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	M4 by 6 Long SHCS	2**					
26	N/A	N/A	M4 by 12 Long BHCS	2**					
27	N/A	N/A	M4 by 50 Long SHCS	2**					
28	N/A	N/A	M5 by 12 Long SHCS	1**					
29	N/A	N/A	#5-40 by 3/8"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).								



Revision Date: 04-05-11

# **Optional Applicator Parts:**

The following parts are *not included* with this Applicator and may be purchased separately.

### 63901-6106 Cut-Off Plunger Retainer

### For wire processing applications:

It is recommended for fully automatic, high speed operations, where the press and the applicator are mounted to a wire processing machine.

Applicator down time for scrap clean-up may be reduced.

This cut-off plunger retainer leaves the scrap terminal carrier intact.

Not recommended for bench operation, where a continuous scrap strip can tangle or build up inside of the safety guards resulting in jams or tooling damage.

### 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 135.8mm (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

, cut-off PLUNGER RETAINER CONTINUOUS CARRIER STRIP