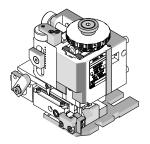
Order Number 63902-8700





Application Tooling Specification

FEATURES

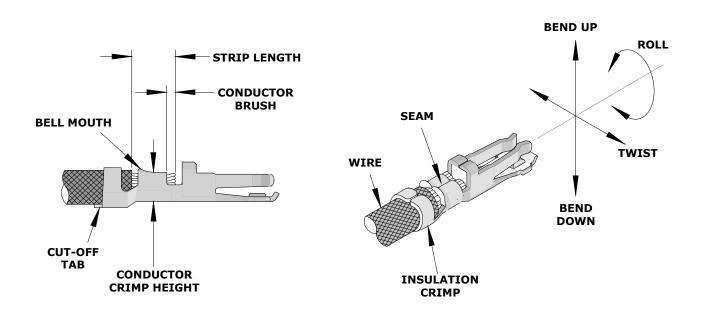
- Quick punch removal with the push of a button for fast and easy tooling change
- Applicator designed to industry-standard mounting and 135.80mm (5.346") shut height
- Quick setup time; plus, the crimp height, track and feed adjustments can be set without removing the applicator from the press
- Fine 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: 1.50mm Pitch Pico-Lock Receptacle Crimp Terminals, 24-28 AWG UL1061 Wires.

Terminal Series No.	Terminal Order No.	Wire Size		Insulation	Diameter	Strip Length		
	Terminal Order No.	AWG	mm²	mm	In.	mm	In.	
504052	504052-0098	24-28	I	0.80-1.15	.032045	1.50-1.90	.059075	

DEFINITION OF TERMS



CRIMP SPECIFICATION

Terminal Series No.	Na	Bell M	louth	Cut-Off Tab	Conductor Brush		
Terminal Series	NO.	mm	In.	mm	In.	mm	In.
504052	C	0.10-0.40	.004016	0.10	.004	0.10-0.60	.004024

Terminal Series	Bend Up	Bend Down	Twist	Roll	Punch Width (Ref) Conductor Insulation				Seam	
	No.	Degree Max.		Degree Max.		mm	In.	mm	In.	Seam
	504052	3	2	3	6	1.00	.039	1.05	.041	Seam shall not be open and no wire allowed out of the crimping area

After crimping, the crimp profiles should measure the following:

			Conductor				Insulation				Dull Fares	
Terminal Series No.	Wire Size		Crimp Height		Crimp Width (Ref)		Crimp Height (Max)		Crimp Width (Max)		Pull Force Minimum	
	AWG	mm ²	mm	In.	mm	In.	mm	In.	mm	In.	N	Lb.
	24	-	0.56-0.61	.022024	1.00	.039	1.40	.055	1.15	.045	29.4	6.6
504052	26	-	0.52-0.57	.020022	1.00	.039	1.40	.055	1.15	.045	19.6	4.4
	28	—	0.48-0.53	.019021	1.00	.039	1.30	.051	1.15	.045	9.8	2.2

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.
- 3. Oiler (63801-7240) required to crimp terminals to improve tooling life and also to minimize the crimp extrusions. See 63800-4900 FineAdjust manual.

Note: Insulation skiving may occur, but it is acceptable for crimps made with this applicator. See picture below.

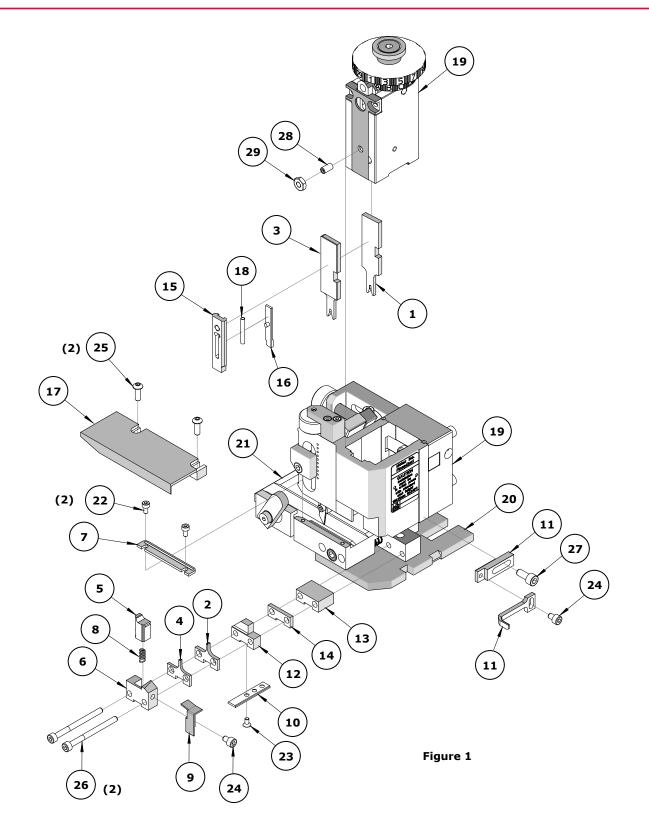


Release Date: 01-30-14 Revision Date: 03-13-20

PARTS LIST

	FineAdjust Applicator 63902-8700									
Item	Order No.	Engineering No.	Description	Quantity						
		Perish	able Tooling							
	63902-8770	63902-8770	Tool Kit (All "Y" Items)	REF						
1	63457-0014	63457-0014	Conductor Punch	1 Y						
2	63455-0126	63455-0126	Conductor Anvil	1 Y						
3	63454-0142	63454-0142	Insulation Punch	1 Y						
4	63456-0098	63456-0098	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	11-18-4083	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	Кеу	1						
11	63443-0090	63443-0090	Wire Stop	1						
12	63443-1719	63443-1719	Height Spacer (18.90mm)	1						
13	63443-2217	63443-2217	Coarse Spacer (17.00mm)	1						
14	63443-2303	63443-2303	Fine Spacer (3.20mm)	1						
15	63443-2806	63443-2806	Front Plunger Striker	1						
16	63443-2905	63443-2905	Wire Hold-Down Plunger	1						
17	63443-6108	63443-6108	Rear Cover	1						
18	63600-0021	63600-0021	Striker Plunger Spring	1						
			Frame							
19	63800-4901	63800-4901	Тор	1						
20	63801-3281	63801-3281	Base	1						
21	63801-4650	63801-4650	Track	1						
		Н	ardware	_						
22	—	—	M3 by 6 Long SHCS	2*						
23	—	—	M3 by 6 Long FHCS	1*						
24	—	—	M4 by 6 Long SHCS	2*						
25	—	—	M4 by 12 Long BHCS	2*						
26	—	—	M4 by 50 Long SHCS	2*						
27	—	—	M5 by 12 Long SHCS	1*						
28			#10-32 by 3/8"Long Flat Point SSS	1*						
29		—	#10-32 Hex Jam Nut	1*						
	* Available from an industrial supply company.									

ASSEMBLY DRAWING



Release Date: 01-30-14 Revision Date: 03-13-20

NOTES

- 1. Molex recommends that 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 the 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.

Application Tooling Support

Phone: (402) 458-TOOL (8665) E-Mail: applicationtooling@molex.com Website: www.molex.com/applicationtooling

Molex is a registered trademark of Molex, LLC in the United States of America and may be registered in other countries; all other trademarks listed herein belong to their respective owners.

Doc. No: ATS-639028700 Revision: C Release Date: 01-30-14 Revision Date: 03-13-20 UNCONTROLLED COPY