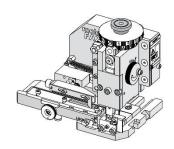
# **Order Number** 63808-3600







### **FEATURES**

- 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 0.015mm (.0006") for conductor crimp height and 0.025mm (.001") 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
- This applicator was designed for use in a wire processor only
- Fine adjustment of the bend is achieved using the bend adjust dial

#### **SCOPE**

**Products:** CTX150 Receptacle S Grip Terminals, 0.50mm<sup>2</sup> Wire.

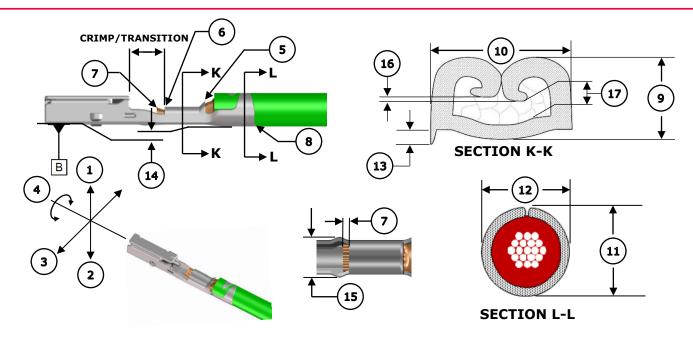
<b>Terminal Series</b>	Terminal Order	Wire		Insulation Diameter		Strip Length	
No.	No.	Wire Type	Size	mm	In.	mm	In.
502307	502307-0111	T3-ZHID	0.50mm <sup>2</sup>	1.25-1.70	.049067	4.50-5.00	.177197
		AVSS					
	502307-0411	T3-ZHID					
		FLRY-A					
34805	34805-0111	T3-ZHID					
		AVSS					
	34805-0411	T3-ZHID					
		FLRY-A					
34864	34864-0111	T3-ZHID					
		AVSS					
	34864-0411	T3-ZHID					
		FLRY-A					

**CAUTION:** This applicator was designed for use in a wire processor only.

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# **DEFINITION OF TERMS**



# **CRIMP SPECIFICATIONS**

The following crimp specifications are based on document AS-502307-001 Rev. E:

Fasture	Dagwiyamant						
Feature	Requirement						
1. Bend Up	1.5° Max						
2. Bend Down	1.5° Max						
3. Twist	4° Max						
4. Roll	6° Max						
5. Bell Mouth Rear	0.20-0.55mm (.008022") for Wire Types T3-ZHID and AVSS						
	0.20-0.65mm (.008026") for Wire Type FLRY-A						
6. Bell Mouth Front	Not Applicable						
7. Conductor Brush	0.20-1.20mm (.008047")						
8. Cut-Off Tab	0.30mm (.012") Max						
	Wire Type	Wire Size	9. Crim	p Height	10. Crimp Width		
Conductor Cuinon	AVSS	0.50mm <sup>2</sup>	0.85-0.95mm	.033037 in.	1.55-1.65mm	.061065 in.	
Conductor Crimp	T3-ZHID	0.50mm <sup>2</sup>	0.80-0.90mm	.031035 in.	1.55-1.65mm	.061065 in.	
	FLRY-A	0.50mm <sup>2</sup>	0.75-0.81mm	.030032 in.	1.55-1.65mm	.061065 in.	
	Wire Type	Wire Size	11. Crin	11. Crimp Height		12. Crimp Width	
Inculation Coincu	AVSS	0.50mm <sup>2</sup>	1.90-2.10mm	.075083 in.	1.75-1.95mm	.069077 in.	
Insulation Crimp	T3-ZHID	0.50mm <sup>2</sup>	1.80-2.00mm	.071079 in.	1.75-1.95mm	.069077 in.	
	FLRY-A	0.50mm <sup>2</sup>	1.90-2.10mm	.075083 in.	1.75-1.95mm	.069077 in.	
	Wire Type	Wire Size	Minimum Force				
Pull Force	AVSS	0.50mm <sup>2</sup>	90 N	20.20 lb.	To be measured with no		
Pull Force	T3-ZHID	0.50mm <sup>2</sup>	80 N	18.00 lb.	influence from the insulation crimp.		
	FLRY-A	0.50mm <sup>2</sup>	50N	11.20 lb.			
13. Conductor Anvil Flash	0.125mm (.005") Max						
14. Insulation Grip Step	0.00-0.30mm (.000012") Below Datum B						
15. Crimp Bulge	2.24mm (.088") Max within crimp/transition area						
16. Wing Dissymmetry	0.25mm (.010") Max						
17. Space Between Wing	0.125mm (.005") Min						
Tips and Crimp Bottom							

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#### **NOTES**

#### **Applicator Notes**

- This applicator is for automatic wire processor use only.
- This applicator does not include a cutting insert.
- Installing a cutting insert will cause jamming in this applicator.

### **Specification Notes**

This applicator should only be run in a properly set up wire processor to consistently achieve the brush length

#### **General Notes**

- 1. Molex recommends that an extra perishable tooling kit be maintained at your facility.
- 2. Verify tooling alignment by hand 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 FA2 manual (TM-638080200).
- 6. Molex recommends crimping stranded copper wire only.

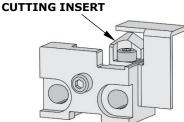
### **WARNINGS**

CAUTION: This applicator must be installed in a press with a standard shut height of 135.80mm (5.346"). Tooling damage could result at a lower setting.

CAUTION: To prevent injury, never operate this applicator without the quards supplied with the press or wireprocessing machine in place. Reference the press or wire processing manufacturer's instruction manual.

CAUTION: Molex tooling crimp specifications are valid only when used with Molex terminals and tooling manufactured by Molex and sold by Molex or authorized distributors ("Molex Tooling"). When using tooling other than Molex Tooling with Molex-specific connector systems listed in our ATS documents, the Molex Tooling qualification does not apply, and the responsibility for full qualification of the connector system is that of the customer. Molex accepts no liability for connector performance or tooling support where tooling other than Molex Tooling is used or where Molex Tooling is modified.

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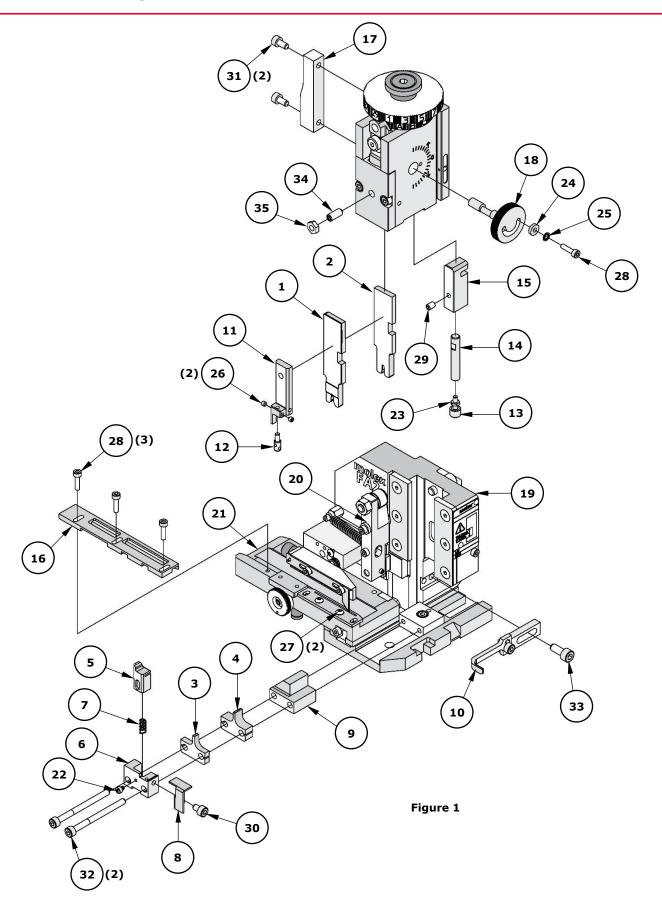
# **PARTS LIST**

Applicator 63808-3600								
Item	Order No.			Quantity				
Perishable Tooling								
	63808-3670	63808-3670	Tool Kit (All "Y" Items)	Ref				
1	63454-1806	63454-1806	Insulation Punch	1 Y				
2	200216-1604	200216-1604	Conductor Punch	1 Y				
3	63456-1804	63456-1804	Insulation Anvil	1 Y				
4	63455-1604	63455-1604	Conductor Anvil	1 Y				
5	63443-0121	63443-0121	Cut-Off Plunger	1 Y				
Non-Perishable Components								
6	63443-0118	63443-0118	Front Plunger Retainer	1				
7	01124-1067	4996-4	Cut-Off Plunger Spring	1				
8	63443-0117	63443-0117	Front Scrap Chute	1				
9	63443-7511	63443-7511	Anvil Mount	1				
10	63443-0090	63443-0090	Wire Stop Assembly	1				
11	63443-3603	63443-3603	Front Plunger Striker	1				
12	63443-3702	63443-3702	Wire Hold Down Plunger	1				
13	63600-5776	63600-5776	Nose Hold Down	1				
14	63600-5775	63600-5775	Nose Hold Down Shank	1				
15	63808-0220	63808-0220	Nose Hold Down Block	1				
16	63443-4716	63443-4716	Terminal Guide	1				
17	63443-4404	63443-4404	Feed Cam	1				
18	63808-0229	63808-0229	Bend Adjust Dial	1				
		Fran	ne					
19	63808-0200	63808-0200	Applicator Core	1				
20	63808-0197	63808-0197	Mechanical Feed Assembly	1				
21	63808-0191	63808-0191	Track Assembly	1				
		Hardv	vare					
22	_	_	M2.5 x 4 SHCS	1*				
23	_	_	M3 Hex Nut	1*				
24	_		M3 Flat Washer Hard	1*				
25	_	_	M3 Inner Tooth Lock Washer	1*				
26	_	_	M3 x 3 SSS	2*				
27	_		M3 x 6 BHCS	2*				
28	_		M3 x 12 SHCS	4*				
29	_		M4 x 5 SSS	1*				
30	_	_	M4 x 6 SHCS	1*				
31	_	_	M4 x 8 SHCS	2*				
32	_	<u> </u>	M4 x 45 SHCS	2*				
33	_		M5 x 12 SHCS	1*				
34	_	_	M5 x 10 Long Cup Point SSS	1*				
35	_	_	M5 Hex Jam Nut	1*				

<sup>\*</sup>Fastener parts can be purchased through most industrial suppliers by using the description in the table above.

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# **ASSEMBLY DRAWING**



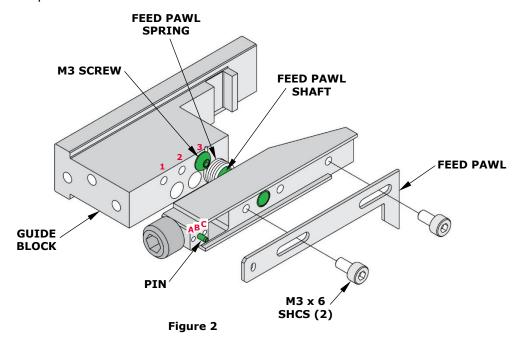
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#### **FACTORY SETTINGS**

#### **Feed Pawl Assembly**

The FA2 applicator number 63808-3600 ships with the following factory settings. See Figure 2:

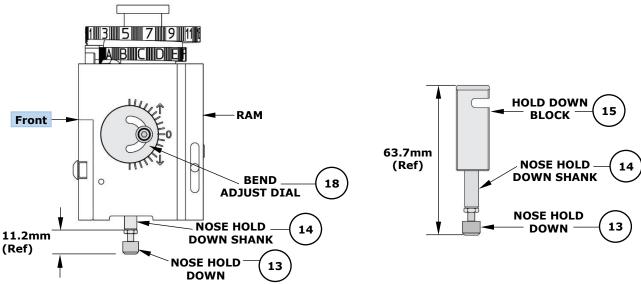
- The feed pawl shaft and M3 screw that holds the feed pawl spring are in position 3.
- The pin is in position B.



**Note:** Each applicator is configured and tested by Molex prior to shipping, and the above settings were used to produce the included sample crimps.

# Third Dial/Ram Assembly

Indicates item number on the Parts List and Assembly Drawing



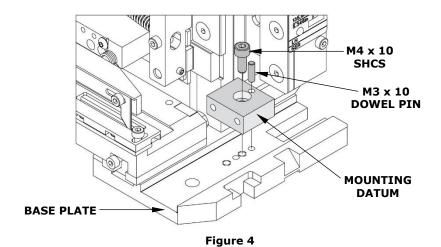
**Note:** The above dimensions were measured during setup and are included as a reference only. Additional adjustments may be required before crimping for production.

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### **Mounting Datum Location**

This applicator was assembled and tested by Molex with the mounting datum in the location shown in Figure 4. Do not remove the mounting datum.



**Application Tooling Support** 

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

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