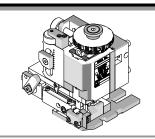




Application Tooling Specification Sheet



Order No. 63900-1400

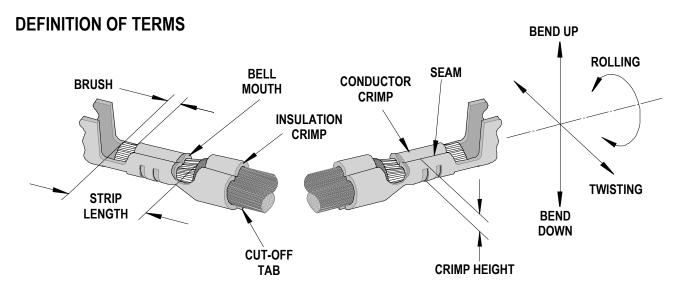
FEATURES

- 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

<u>Products:</u> Low Force Micro-Fit 3.0™ Crimp Terminal 20-24 AWG.

Terminal Series No.	Terminal Order No.		Wire Size		Insulation Diameter		Strip Length	
Terminal Series No.			AWG	mm²	mm	ln.	mm	ln.
46235	46235-0001	46235-0002	20-24	0.50-0.20	1.30-1.85	.051073	2.54-2.92	.100115
	46235-5001	46235-5002	20-24					



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

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CRIMP SPECIFICATION

Terminal Series No.	Bell n	nouth	Cut-off Tak	Maximum (Conductor Brush		
	mm	ln.	mm	ln.	mm	ln.	
46235	0.05-0.40	.002016	0.25	.010	0.20-0.80	.008031	

	Bend up Bend down		Twist F	Roll	Pı	Punch Width (Ref)			Seam	
Terminal Series No.	Bend up	Della dowli	I WISL	KOII	Cond	Conductor Insulation		ation	Seam shall not be open	
	Degree		Degree		mm	ln.	mm	ln.	And no wire allowed out	
46235	3	3	4	8	1.20	.047	1.90	.075	of the crimping area	

After crimping, the crimp profiles should measure the following:

Terminal Series No.	Wire Size			Condu	Pull Force Minimum			
			Crimp	Height	Crimp W	idth (Ref)	Full Folce Willimum	
	AWG	mm ²	mm	ln.	mm	ln.	N	Lb.
46235	20	0.50	0.76-0.81	.030032	1.25	.049	57.9	13.0
	22	0.35	0.71-0.76	.028030	1.25	.049	35.6	8.0
	24	0.20	0.66-0.71	.026028	1.25	.049	22.3	5.0

* Tool Qualification Notes:

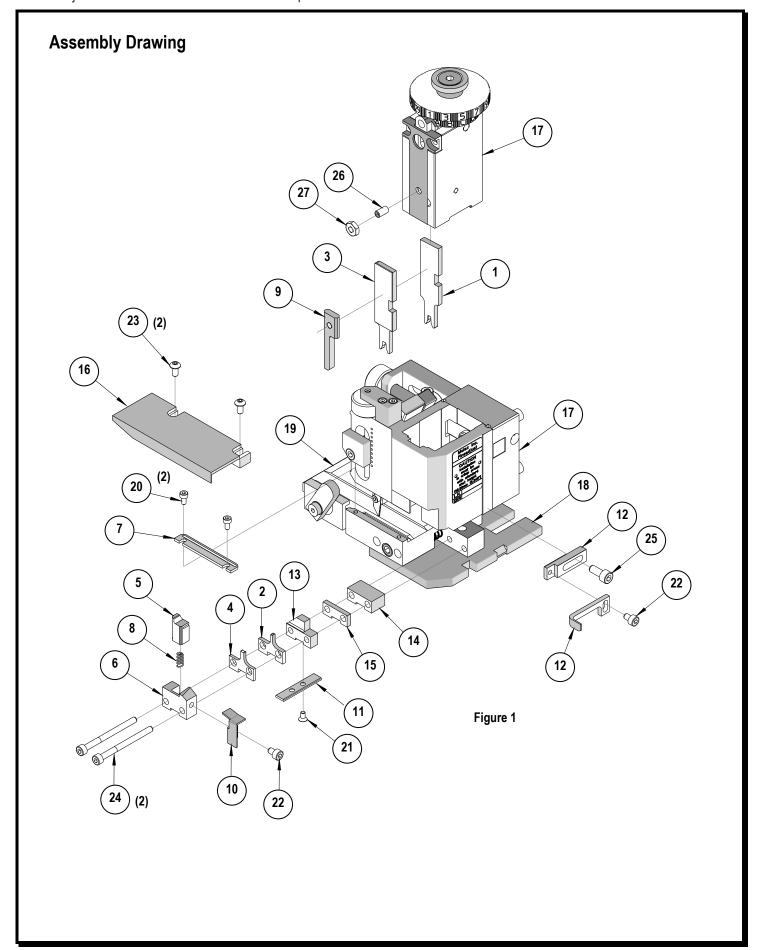
- 1. Pull Force should be measured with no influence from the insulation crimp.
- 2. The above specifications are guidelines to an optimum crimp.

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PARTS LIST

FineAdjust Applicator 63900-1400									
Item	Order No Engineering No. Description								
Perishable Tooling									
	63900-1470	63900-1470	Tool Kit (All "Y" Items)	REF					
1	63457-0037	63457-0037	Conductor Punch	1 Y					
2	63455-0051	63455-0051	Conductor Anvil	1 Y					
3	63446-1902	63446-1902	Insulation Punch	1 Y					
4	63445-1910	63445-1910	Insulation Anvil	1 Y					
5	63443-0002	63443-0002	Cut-Off Plunger Front	1 Y					
6	63443-0012	63443-0012	Plunger Retainer Front	1 Y					
			Components						
7	11-18-4083	60707-8	Feed Guide	1					
8	11-24-1067	4996-4	Cut-Off Plunger Spring	1					
9	11-40-4039	8302-5	Plunger Striker	1					
10	63443-0009	63443-0009	Front Scrap Chute	1					
11	63443-0025	63443-0025	Key	1					
12	63443-0090	63443-0090	Wire Stop	1					
13	63443-1717	63443-1717	Height Spacer	1					
14	63443-2216	63443-2216	Coarse Spacer (16.00mm)	1					
15	63443-2302	63443-2302	Fine Spacer (3.10mm)	1					
16	63443-6109	63443-6109	Rear Cover	1					
Frame									
17	63800-4901	63800-4901	Тор	1					
18	63801-3281	63801-3281	Base	1					
19	63801-4650	63801-4650	Track	1					
		Н	lardware						
20	N/A	N/A	M3 by 6 Long SHCS	2**					
21	N/A	N/A	M3 by 6 Long FHCS	1**					
22	N/A	N/A	M4 by 6 Long SHCS	2**					
23	N/A	N/A	M4 by 12 Long BHCS	2**					
24	N/A	N/A	M4 by 50 Long SHCS	2**					
25	N/A	N/A	M5 by 12 Lg SHCS	1**					
26	N/A	N/A	#10-32 by 3/8"Long Flat Point SSS	1**					
27	N/A	N/A	#10-32 Hex Jam Nut	1**					
*:	** Available from an industrial supply company such as MSC (1-800-645-7270).								

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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.

http://www.molex.com

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