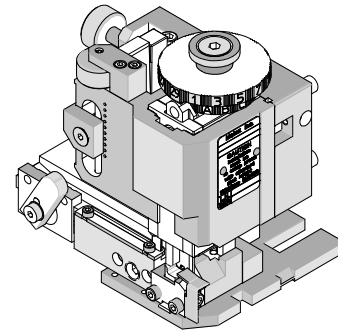




FineAdjust Applicator Applicator Tooling Specification Sheet Order No. 63901-8300



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

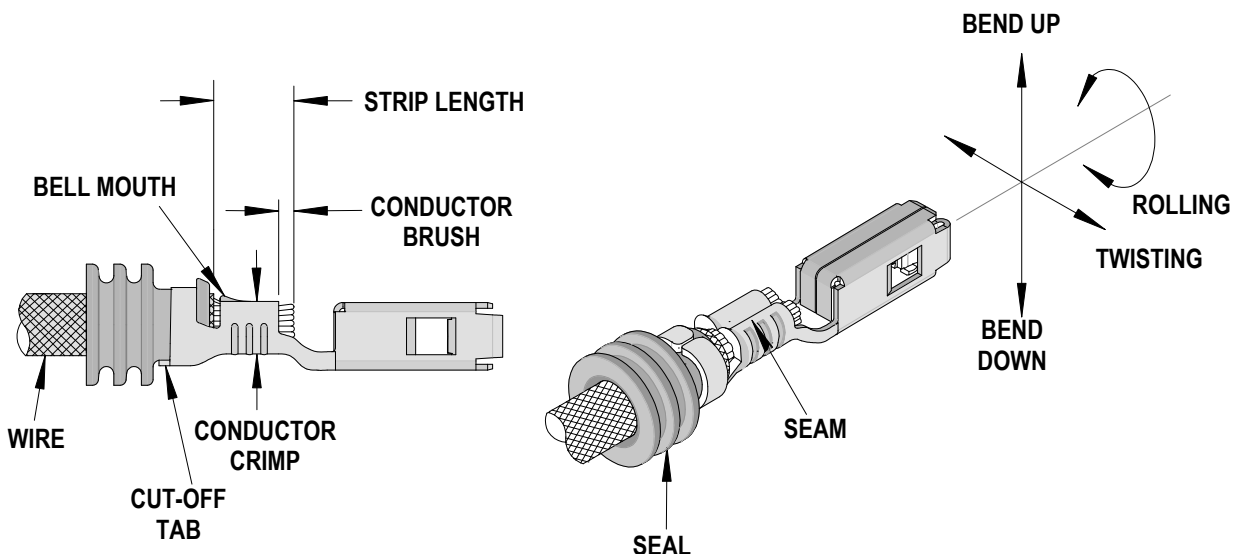
SCOPE

Products: SCC Sealed Receptacle Terminals: >0.50 - 1.0 mm² metric, type IR wire.

Terminal Series No.	Terminal Order No.	Wire Size and Type		✗ Insulation Diameter		Strip Length	
		mm ²	Type	mm	In.	mm	In.
98897	98897-1059	0.50	IR	1.40-1.60	.055-.063	4.10	.161
		0.75	IR	1.70-1.90	.067-.075	4.10	.161
		1.00	IR	1.85-2.05	.073-.081	4.10	.161

✗ 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.
98897	0.40-1.00	.016-.039	0.30	.012	0.20-1.00	.008-.039

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	
98897	2	2	3	2	2.20	.087	4.20	.165	

After crimping, the crimp profiles should measure the following:

Terminal Series No.	Wire Size	Conductor				Pull Force Minimum	
		Crimp Height		Crimp Width (Ref.)		N	Lb.
		mm	In.	mm	In.		
98897	0.50	1.00-1.10	.039-.043	2.20	.087	70.0	15.7
	0.75	1.05-1.15	.041-.045	2.20	.087	90.0	20.2
	1.00	1.15-1.25	.045-.049	2.20	.087	115.0	25.9

Terminal Series No.	Wire Size	Insulation Diameter		Single Wire Seal		Insulation			
		mm	In.	Order No.	Color	Crimp Height (Ref)		Crimp Width (Ref.)	
						mm	In.	mm	In.
98897	0.50	1.40-1.60	.055-.063	0984921056	Blue	3.50-3.70	.138-.146	4.15-4.30	.163-.169
	0.75	1.70-1.90	.067-.075			3.60-3.80	.142-.150	4.15-4.30	.163-.169
	1.00	1.85-2.05	.073-.081	0984921030	White	3.65-3.85	.144-.152	4.15-4.30	.163-.169

► 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 63901-8300				
Item	Order No	Engineering No.	Description	Quantity
Perishable Tooling				
	63901-8370	63901-8370	Tool Kit (All "Y" Items)	REF
1	63457-0068	63457-0068	Conductor Punch	1 Y
2	63455-0093	63455-0093	Conductor Anvil	1 Y
3	63454-0109	63454-0109	Insulation Punch	1 Y
4	63456-0075	63456-0075	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	11-18-4083	60707-8	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	63443-1716	63443-1716	18.60mm Height Spacer	1
13	63443-2214	63443-2214	14.00mm Coarse Spacer	1
14	63443-2301	63443-2301	3.05mm Fine Spacer	1
15	63443-2804	63443-2804	Front Plunger Striker	1
16	63443-2915	63443-2915	Wire Hold-Down Plunger	1
17	63443-6130	63443-6130	Rear Cover	1
18	63443-7110	63443-7110	Terminal Hold Down	1
19	63600-0021	63600-0021	Striker Plunger Spring	1
20	63600-3378	63600-3378	Hold Down Spring	1
21	63700-0539	63700-0539	Cut-off Plunger Spring	1
Frame				
22	63800-4901	63800-4901	Top	1
23	63801-3281	63801-3281	Base	1
24	63801-4650	63801-4650	Track	1
Hardware				
25	N/A	N/A	M3 by 6 Long SHCS	2**
26	N/A	N/A	M3 by 6 Long FHCS	1**
27	N/A	N/A	M3 by 8 Long SHCS	1**
28	N/A	N/A	M4 by 6 Long SHCS	2**
29	N/A	N/A	M4 by 12 Long BHCS	2**
30	N/A	N/A	M4 by 50 Long SHCS	2**
31	N/A	N/A	M5 by 12 Long SHCS	1**
32	N/A	N/A	#10-32 by 3/8" Long Flat Point SSS	1**
33	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

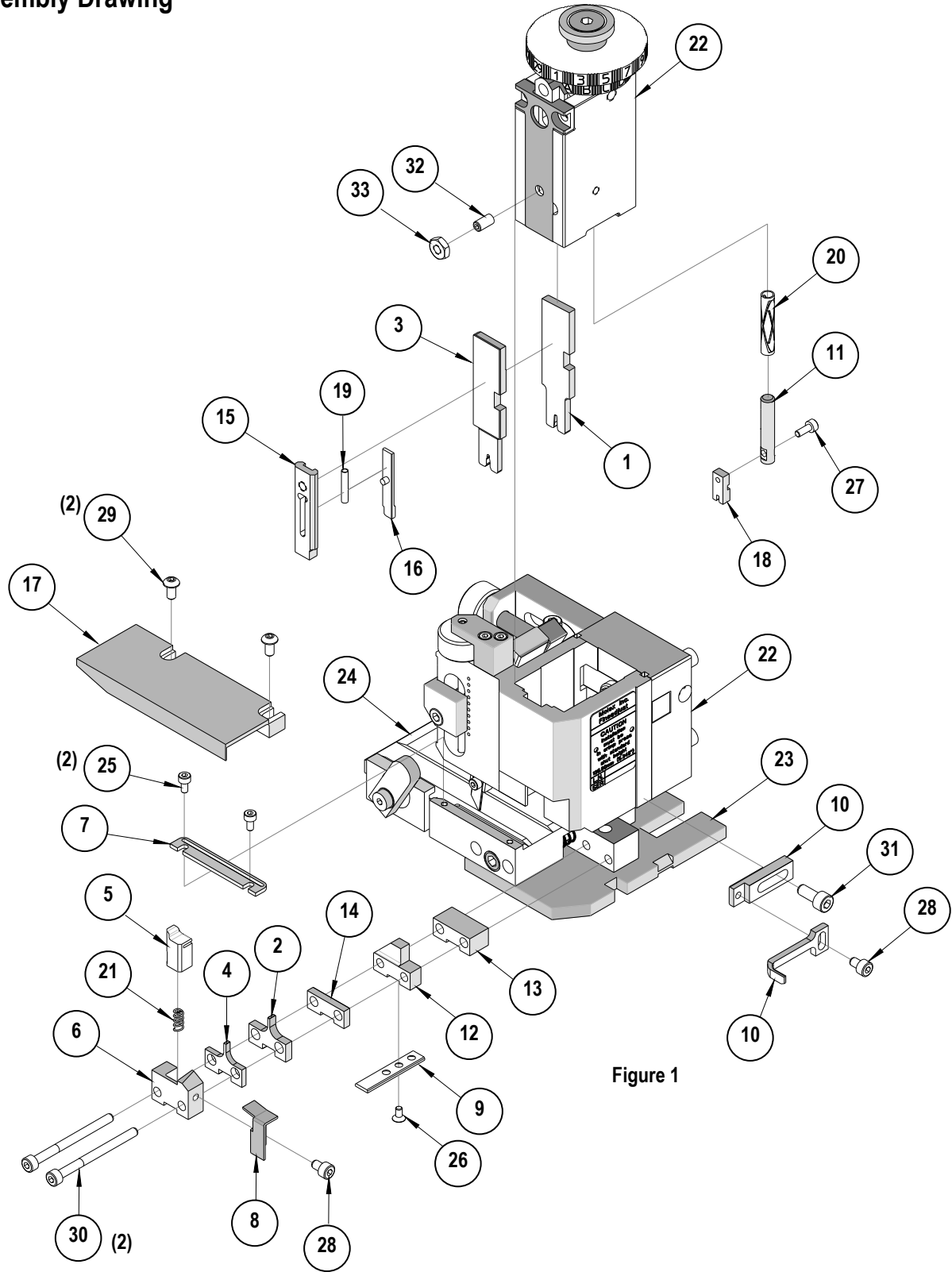


Figure 1

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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