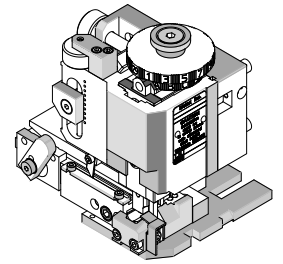


Order Number
203702-1900



Application Tooling Specification

FEATURES

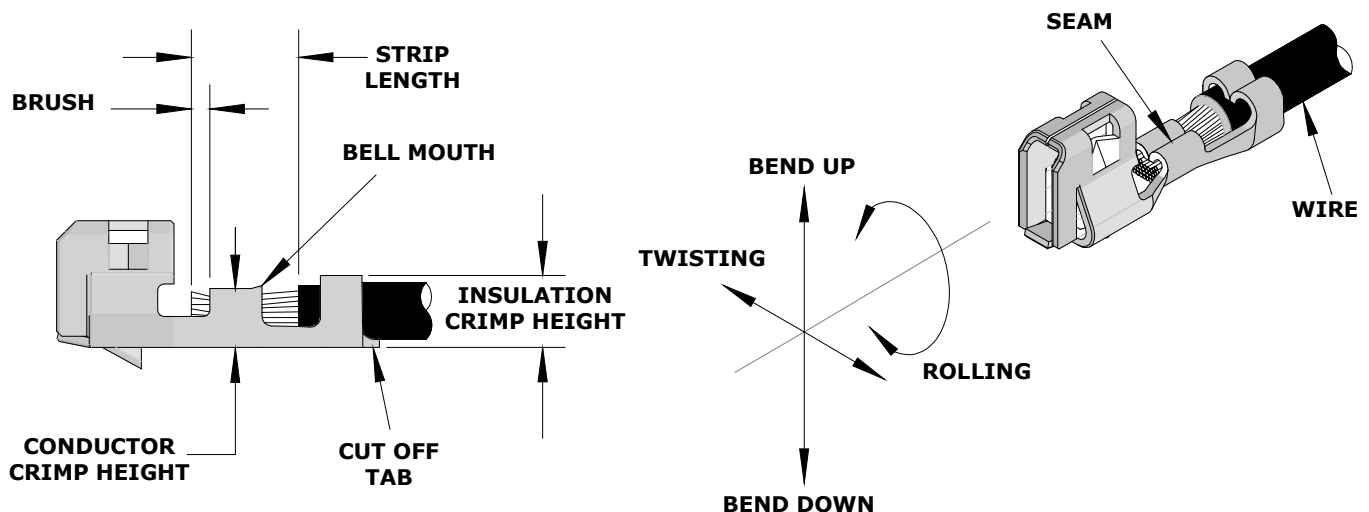
- Quick punch removal with the push of a button for fast and easy tooling change
- Applicator designed to industry-standard mounting and 135.80mm (5.346") shut height
- Quick setup time; plus, the crimp height, track and feed adjustments can be set without removing the applicator from the press
- Fine adjustment allows users to achieve target with little effort by adjusting in increments of 0.015mm (.0006") for conductor crimp height and 0.063mm (.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: 2.0 W/B Crimp Receptacle Terminals and SMEC Crimp Receptacle Terminal, 22-26 AWG and AVSS0.3 wires.

Terminal Series No.	Terminal Order No.	Wire Size		Insulation Diameter		Strip Length	
		AWG	mm ²	mm	In.	mm	In.
50372	50372-8000	22-26	—	0.95-1.40	.037-.055	1.30-1.80	.051-.071
56161	56161-8081	22-26	—	1.05-1.40	.041-.055	1.30-1.80	.051-.071
560085	560085-0101	22-26	—	0.95-1.40	.037-.055	1.30-1.80	.051-.071
		—	AVSS0.3	1.40	.055	1.30-1.80	.051-.071

DEFINITION OF TERMS



CRIMP SPECIFICATION

Terminal Series No.			Bell Mouth		Cut-Off Tab Maximum		Conductor Brush	
			mm	In.	mm	In.	mm	In.
50372	56161	560085	0.05-0.35	.002-.014	0.15	.006	0.00-0.50	.000-.020

Terminal Series No.	Bend Up	Bend Down	Twist	Roll	Punch Width (Ref)				Seam
	Degree Max.	Degree Max.	mm	In.	Conductor		Insulation		
					mm	In.	mm	In.	
50372	4	3	3	4	1.20	.047	1.40	.055	Seam shall not be open and no wire allowed out of the crimping area
56161	2	1	3	4	1.20	.047	1.40	.055	
560085	4	3	3	4	1.20	.047	1.40	.055	

After crimping, the crimp profiles should measure the following:

Terminal Series No.	Wire Size		Conductor				Insulation				Pull Force Minimum	
			Crimp Height		Crimp Width (Ref)		Crimp Height Maximum (Ref)		Crimp Width (Ref)			
	AWG	mm ²	mm	In.	mm	In.	mm	In.	mm	In.	N	Lb.
50372	22	—	0.70-0.75	.027-.029	1.20	.047	1.30	.051	1.45	.057	39.2	8.8
	24	—	0.62-0.67	.024-.026	1.20	.047	1.10	.043	1.45	.057	29.4	6.6
	26	—	0.57-0.62	.022-.024	1.20	.047	1.00	.039	1.45	.057	19.6	4.4
56161	22	—	0.70-0.75	.027-.029	1.20	.047	1.30	.051	1.45	.057	39.2	8.8
	24	—	0.62-0.67	.024-.026	1.20	.047	1.10	.043	1.45	.057	29.4	6.6
	26	—	0.57-0.62	.022-.024	1.20	.047	1.00	.039	1.45	.057	19.6	4.4
560085	22	—	0.70-0.75	.027-.029	1.20	.047	1.35	.053	1.45	.057	39.2	8.8
	24	—	0.62-0.67	.024-.026	1.20	.047	1.35	.053	1.45	.057	29.4	6.6
	26	—	0.57-0.62	.022-.024	1.20	.047	1.35	.053	1.45	.057	19.6	4.4
	—	AVSS0.3	0.70-.075	.027-.029	1.20	.047	1.42	.056	1.45	.057	39.2	8.8

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 203702-1900				
Item	Order No.	Engineering No.	Description	Quantity
Perishable Tooling				
	203702-1970	203702-1970	Tool Kit (All "Y" Items)	REF
1	63457-1212	63457-1212	Conductor Punch	1 Y
2	63445-1212	63445-1212	Conductor Anvil	1 Y
3	63446-1406	63446-1406	Insulation Punch	1 Y
4	63445-1410	63445-1410	Insulation Anvil	1 Y
5	63443-0003	63443-0003	Cut-Off Plunger Front	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	Key	1
11	63443-0090	63443-0090	Wire Stop	1
12	63443-2305	63443-2305	Fine Spacer (3.25mm)	1
13	63443-1720	63443-1720	Height Spacer (19mm)	1
14	63443-2217	63443-2217	Coarse Spacer (17mm)	1
15	63443-2805	63443-2805	Front Plunger Striker	1
16	63443-6003	63443-6003	Rear Cover	1
Frame				
17	63800-4901	63800-4901	Top	1
18	63801-3281	63801-3281	Base	1
19	63801-4650	63801-4650	Track	1
Hardware				
20	—	—	M3 by 6 Long SHCS	2*
21	—	—	M3 by 6 Long FHCS	1*
22	—	—	M4 by 6 Long SHCS	1*
23	—	—	M4 by 12 Long BHCS	2*
24	—	—	M4 by 50 Long SHCS	2*
25	—	—	M5 by 12 Long SHCS	1*
26	—	—	#10-32 by 3/8" Long Flat Point SSS	1*
27	—	—	#10-32 Hex Jam Nut	1*
* Available from an industrial supply company.				

ASSEMBLY DRAWING

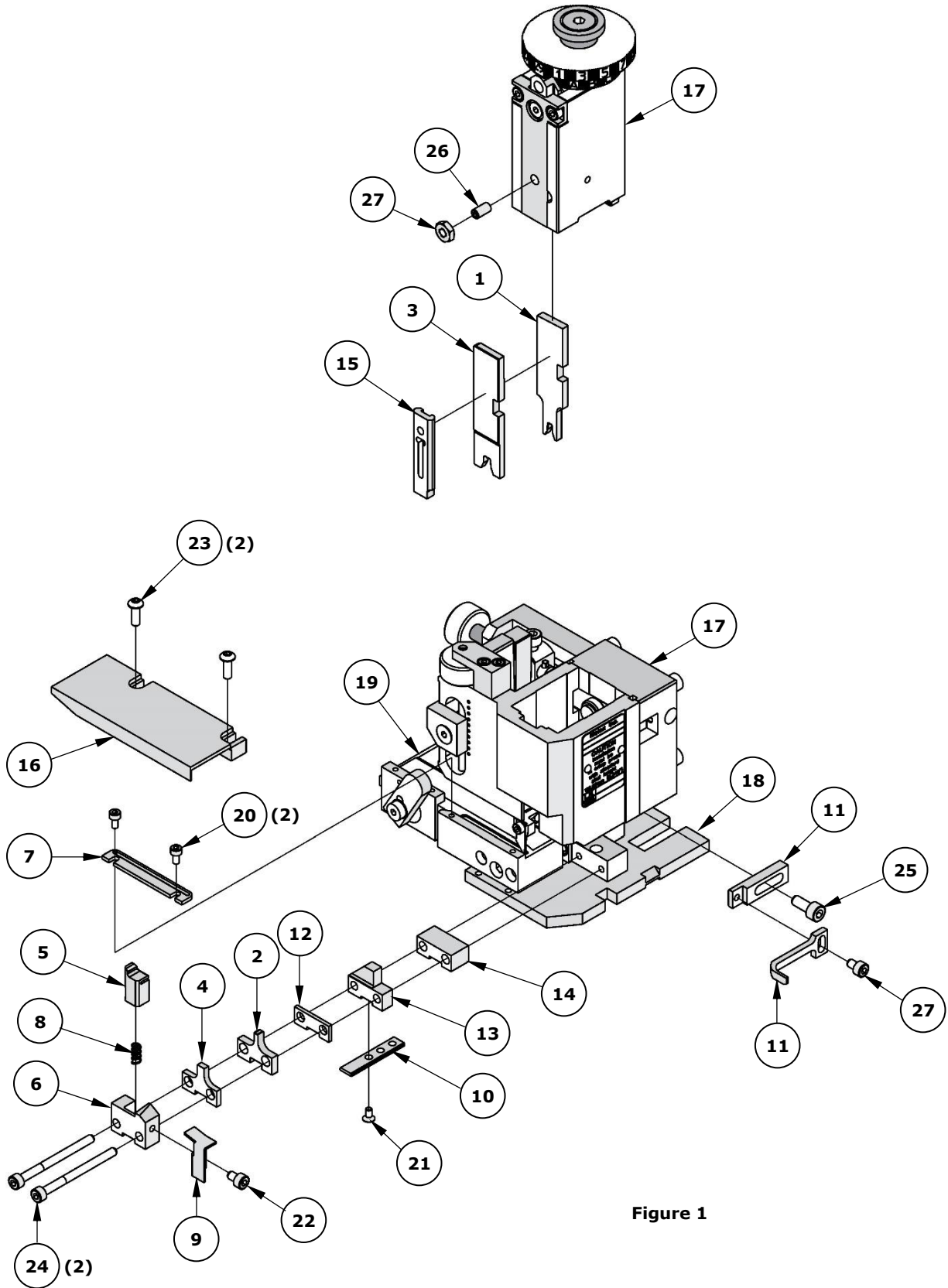


Figure 1

NOTES

General 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.

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 guards supplied with the press or wire-processing 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.

Application Tooling Support

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