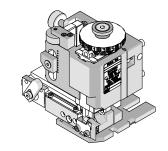
Order Number 63904-6500





Application Tooling Specification

FEATURES

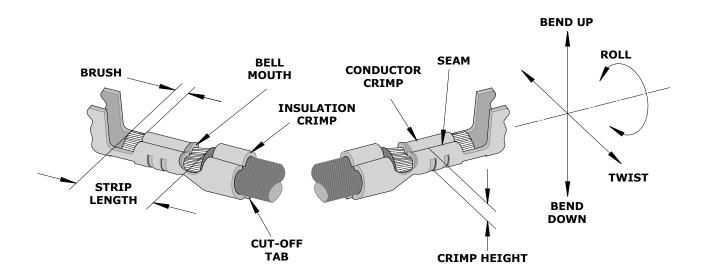
- Directly adapts to most automatic wire processing machines
- Quick punch removal with the push of a button for fast and easy tooling change
- Applicator designed to industry-standard mounting and 135.80mm (5.346") shut height
- Quick setup time; plus, the crimp height, track and feed adjustments can 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

SCOPE

Products: Low-Force Micro-Fit 3.0 Crimp Terminal, 20-24 AWG.

Terminal Series	Terminal Order No.		Wire Size		Insulation Diameter		Strip Length	
No.			AWG	mm²	mm	In.	mm	In.
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						

DEFINITION OF TERMS



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

Tauminal Carias No.	Bell N	1outh	Cut-Off Tab	Maximum	Conductor Brush	
Terminal Series No.	mm	In.	mm	In.	mm	In.
46235	0.05-0.40	.002016	0.25	.010	0.20-0.80	.008031

Γ.	Tarminal Carias	Bond IIn	Band Daven	Twist	Roll	Punch Width (Ref)					
	Terminal Series	вена ор	Bena Down	IWIST		Conductor		Insulation		Seam	
	No.	Degree		Degree		mm	In.	mm In.			
	46235	3	3	4	8	1.20	.047	1.90	.075	Seam shall not be open and no wire allowed out of the crimping area	

After crimping, the crimp profiles should measure the following:

	Wire Size			Condu	Pull Force Minimum			
Terminal Series No.			Crimp	Height	Crimp Wi	dth (Ref)	Puli Force Minimum	
	AWG	mm ²	mm	In.	mm	In.	N	Lb.
	20	0.50	0.76-0.81	.030032	1.25	.049	57.9	13.0
46235	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.
- 3. Oiler (63801-7240) required to crimp terminals to improve tooling life and also to minimize the crimp extrusions. See 63800-4900 FineAdjust manual.

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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 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.

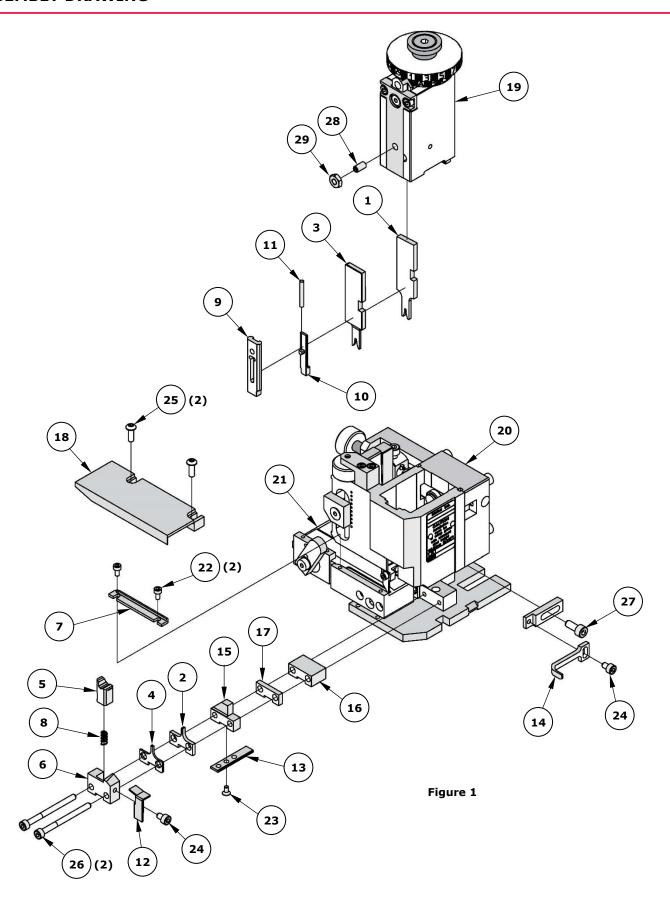
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PARTS LIST

Name	FineAdjust Applicator 63904-6500									
G3904-6570 G3904-6570 Tool Kit (All "Y" Items) REF	Item	Order No.	Engineering No.	Description	Quantity					
1 63457-0037 63457-0037 Conductor Punch 1 Y 2 63455-1207 63455-1207 Conductor Anvil 1 Y 3 63454-1906 63454-1905 Insulation Punch 1 Y 4 63445-1905 63445-1905 Insulation Anvil 1 Y 5 63443-0002 63443-0012 Plunger Retainer Front 1 Y 6 63443-0012 63443-0012 Plunger Retainer Front 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 63443-2802 63443-2802 Plunger Striker 1 10 63443-2904 Wire Hold-Down Plunger 1 11 63600-0021 63600-0021 Hold-Down Spring 1 12 63443-0099 63443-0099 Front Scrap Chute 1 13 63443-0090 63443-1719 Height Spacer (18.90mm) 1 16 63443-2215										
2 63455-1207 63455-1207 Conductor Anvil 1 Y 3 63454-1906 63454-1906 Insulation Punch 1 Y 4 63445-1905 63445-1905 Insulation Anvil 1 Y 5 63443-0002 63443-0002 Cut-Off Plunger Front 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 63443-2802 63443-2802 Plunger Striker 1 10 63443-2904 Wire Hold-Down Plunger 1 11 63600-0021 63600-0021 Hold-Down Spring 1 12 63443-2094 Wire Hold-Down Spring 1 13 63443-0009 63443-0009 Front Scrap Chute 1 14 63443-0024 Key 1 15 63443-215 63443-215 Coarse Spacer (18.90mm) 1 16 63443-219 63443-215 Coarse Spacer (15.00mm) 1<		63904-6570	63904-6570	Tool Kit (All "Y" Items)	REF					
3 63454-1906 63454-1905 Insulation Punch 1 Y 4 63445-1905 63443-0002 Cut-Off Plunger Front 1 Y 5 63443-0012 63443-0012 Plunger Retainer Front 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 63443-2802 Ay96-4 Cut-Off Plunger Spring 1 10 63443-2904 G3443-2802 Plunger Striker 1 11 63600-0021 63600-0021 Hold-Down Punger 1 12 63443-2904 Wire Hold-Down Spring 1 12 63443-0090 63443-0090 Front Scrap Chute 1 13 63443-0024 63443-0090 Wire Stop 1 14 63443-0024 63443-0090 Wire Stop 1 15 63443-1719 63443-215 Coarse Spacer (15.00mm) 1 16 63443-2318 Fine Spacer	1	63457-0037	63457-0037	Conductor Punch	1 Y					
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13 63443-0024 63443-0090 Key 1 14 63443-0090 63443-0090 Wire Stop 1 15 63443-1719 63443-1719 Height Spacer (18.90mm) 1 16 63443-2215 Coarse Spacer (15.00mm) 1 17 63443-2318 63443-2318 Fine Spacer (3.90mm) 1 18 63443-6109 Rear Cover 1 Frame 19 63800-4901 63800-4901 Top 1 20 63801-3281 63801-3281 Base 1 21 63801-4650 63801-4650 Track 1 Hardware 22 — — M3 by 6 Long SHCS 2* 23 — — M4 by 6 Long SHCS 2* 24 — — M4 by 50 Long SHCS 2* 25 — — M4 by 50 Long SHCS 2* 26 — — M5 by 12 Long SHCS 1* 27 <	11	63600-0021	63600-0021	Hold-Down Spring	1					
14 63443-0090 63443-0090 Wire Stop 1 15 63443-1719 Height Spacer (18.90mm) 1 16 63443-2215 Coarse Spacer (15.00mm) 1 17 63443-2318 63443-2318 Fine Spacer (3.90mm) 1 18 63443-6109 Rear Cover 1 Frame 19 63800-4901 Top 1 20 63801-3281 63801-3281 Base 1 21 63801-4650 63801-4650 Track 1 Hardware 22 — — M3 by 6 Long SHCS 2* 23 — — M4 by 6 Long SHCS 2* 24 — — M4 by 12 Long BHCS 2* 25 — — M4 by 50 Long SHCS 2* 26 — — M5 by 12 Long SHCS 1* 27 — — M5 by 12 Long Flat Point SSS 1* 28 — — #10-32	12	63443-0009	63443-0009	Front Scrap Chute	1					
15 63443-1719 63443-1719 Height Spacer (18.90mm) 1 16 63443-2215 Coarse Spacer (15.00mm) 1 17 63443-2318 Fine Spacer (3.90mm) 1 18 63443-6109 Rear Cover 1 Frame 19 63800-4901 63800-4901 Top 1 20 63801-3281 63801-3281 Base 1 21 63801-4650 Track 1 Hardware 22 — — M3 by 6 Long SHCS 2* 23 — — M4 by 6 Long SHCS 2* 24 — — M4 by 12 Long BHCS 2* 25 — — M4 by 50 Long SHCS 2* 26 — — M5 by 12 Long SHCS 1* 27 — — M5 by 12 Long SHCS 1* 28 — — #10-32 by 3/8"Long Flat Point SSS 1* 29 — — #10-32 Hex	13	63443-0024	63443-0024	Key	1					
16 63443-2215 63443-2215 Coarse Spacer (15.00mm) 1 17 63443-2318 63443-2318 Fine Spacer (3.90mm) 1 18 63443-6109 Rear Cover 1 Frame 19 63800-4901 63800-4901 Top 1 20 63801-3281 63801-3281 Base 1 21 63801-4650 Track 1 Hardware 22 — — M3 by 6 Long SHCS 2* 23 — — M4 by 6 Long SHCS 2* 24 — — M4 by 12 Long BHCS 2* 25 — — M4 by 50 Long SHCS 2* 26 — — M5 by 12 Long SHCS 1* 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*	14	63443-0090	63443-0090	Wire Stop	1					
17 63443-2318 63443-2318 Fine Spacer (3.90mm) 1 Frame Frame 19 63800-4901 G3800-4901 Top 1 20 63801-3281 63801-3281 Base 1 21 63801-4650 63801-4650 Track 1 Hardware 22 — — M3 by 6 Long SHCS 2* 23 — — M4 by 6 Long SHCS 2* 24 — — M4 by 6 Long SHCS 2* 25 — — M4 by 12 Long BHCS 2* 26 — — M5 by 12 Long SHCS 1* 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*	15	63443-1719	63443-1719	Height Spacer (18.90mm)	1					
18 63443-6109 Rear Cover 1 Frame 19 63800-4901 63800-4901 Top 1 20 63801-3281 Base 1 21 63801-4650 63801-4650 Track 1 Hardware 22 — — M3 by 6 Long SHCS 2* 23 — — M4 by 6 Long SHCS 1* 24 — — M4 by 6 Long SHCS 2* 25 — — M4 by 12 Long BHCS 2* 26 — — M5 by 12 Long SHCS 1* 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*	16	63443-2215	63443-2215	Coarse Spacer (15.00mm)	1					
Frame 19 63800-4901 63800-4901 Top 1 20 63801-3281 63801-3281 Base 1 21 63801-4650 63801-4650 Track 1 Hardware 22 — — M3 by 6 Long SHCS 2* 23 — — M4 by 6 Long SHCS 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*		63443-2318	63443-2318	Fine Spacer (3.90mm)	1					
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21 63801-4650 Track 1 Hardware 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*	19		63800-4901	Тор						
Hardware 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*					1					
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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*			H							
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*	22	_	_	M3 by 6 Long SHCS						
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*		_	_	M3 by 6 Long FHCS						
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*		_	_	M4 by 6 Long SHCS						
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*			_							
28 — #10-32 by 3/8"Long Flat Point SSS 1* 29 — #10-32 Hex Jam Nut 1*		_	_							
29 – #10-32 Hex Jam Nut 1*					_					
		_	_							
* Available from an industrial supply company.	29				1*					
			* Available from an	industrial supply company.						

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ASSEMBLY DRAWING



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Revision: D

FineAdjust Applicator for Low-Force Micro-Fit 3.0 Crimp Terminal

Application Tooling Support

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E-Mail: applicationtooling@molex.com
Website: www.molex.com/applicationtooling

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