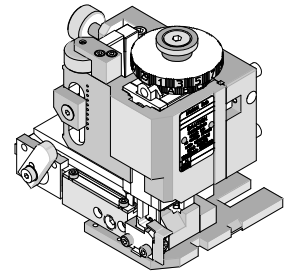


**Order Number
63904-6500**



Application Tooling Specification

FEATURES

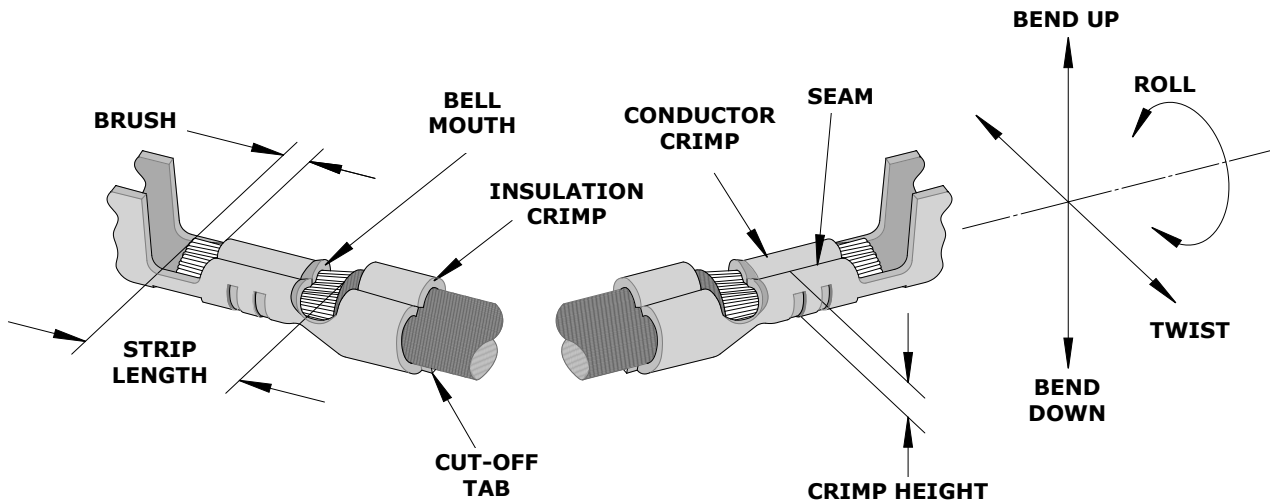
- Directly adapts to most automatic wire processing machines
- Quick punch removal with the push of a button for fast and easy tooling change
- Applicator designed to industry-standard mounting and 135.80mm (5.346") shut height
- Quick setup time; plus, the crimp height, track and feed adjustments can 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 No.	Terminal Order No.		Wire Size		Insulation Diameter		Strip Length	
			AWG	mm ²	mm	In.	mm	In.
46235	46235-0001	46235-0002	20-24	0.50-0.20	1.30-1.85	.051-.073	2.54-2.92	.100-.115
	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.

CRIMP SPECIFICATION

Terminal Series No.	Bell Mouth		Cut-Off Tab Maximum		Conductor Brush	
	mm	In.	mm	In.	mm	In.
46235	0.05-0.40	.002-.016	0.25	.010	0.20-0.80	.008-.031

Terminal Series No.	Bend Up	Bend Down	Twist	Roll	Punch Width (Ref)				Seam
	Degree	Degree	Degree	Degree	Conductor		Insulation		
					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:

Terminal Series No.	Wire Size		Conductor				Pull Force Minimum	
	AWG	mm ²	Crimp Height		Crimp Width (Ref)		N	Lb.
			mm	In.	mm	In.		
46235	20	0.50	0.76-0.81	.030-.032	1.25	.049	57.9	13.0
	22	0.35	0.71-0.76	.028-.030	1.25	.049	35.6	8.0
	24	0.20	0.66-0.71	.026-.028	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.

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.

PARTS LIST

FineAdjust Applicator 63904-6500				
Item	Order No.	Engineering No.	Description	Quantity
Perishable Tooling				
	63904-6570	63904-6570	Tool Kit (All "Y" Items)	REF
1	63457-0037	63457-0037	Conductor Punch	1 Y
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
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	63443-2904	Wire Hold-Down Plunger	1
11	63600-0021	63600-0021	Hold-Down Spring	1
12	63443-0009	63443-0009	Front Scrap Chute	1
13	63443-0024	63443-0024	Key	1
14	63443-0090	63443-0090	Wire Stop	1
15	63443-1719	63443-1719	Height Spacer (18.90mm)	1
16	63443-2215	63443-2215	Coarse Spacer (15.00mm)	1
17	63443-2318	63443-2318	Fine Spacer (3.90mm)	1
18	63443-6109	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	—	—	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*

* Available from an industrial supply company.

ASSEMBLY DRAWING

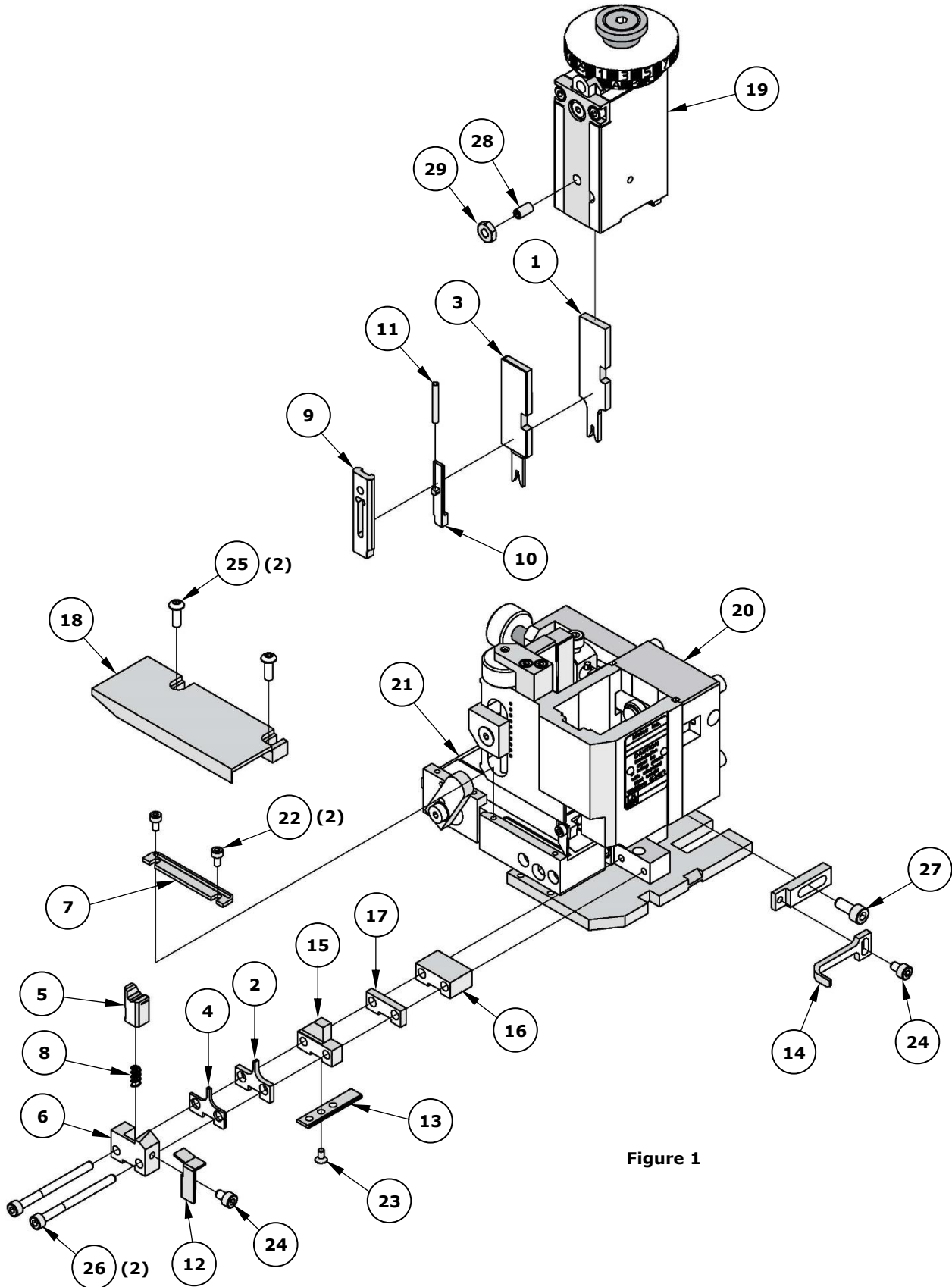


Figure 1

Application Tooling Support

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