



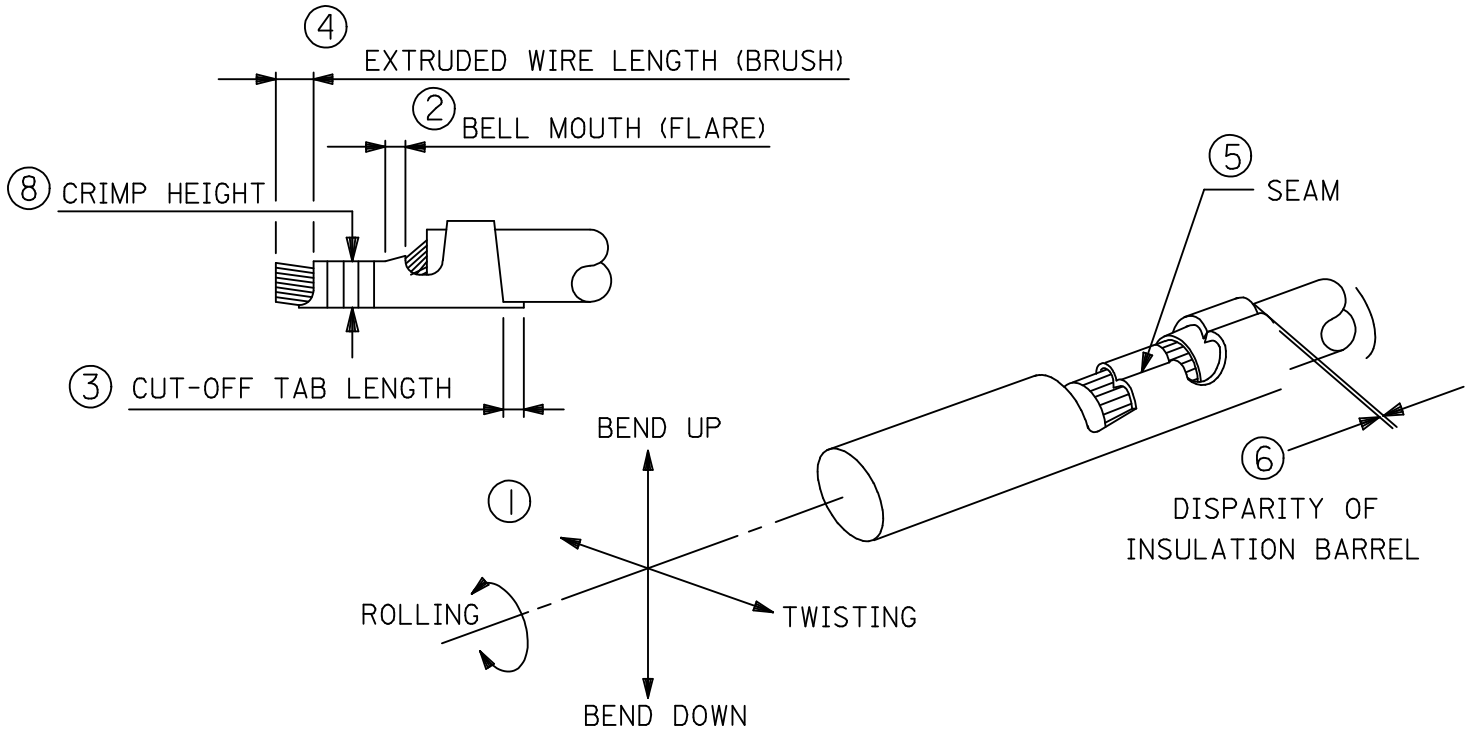
APPLICATION TOOLING FINEADJUST APPLICATOR SPECIFICATION SHEET

A. SCOPE

THIS STANDARD SPECIFIES THE DIMENSIONS AFTER CRIMPING OF THE TERMINALS UNDERMENTIONED.

TERMINAL SERIES	WIRE SIZE	INSULATION DIAMETER		STRIP LENGTH	
	AWG	ENGLISH	(METRIC)	ENGLISH	(METRIC)
83000-9502	28 -	.020 - .039	(0.50 - 1.00)	.051 - .063	(1.30 - 1.60)
83000-9503	28 -	.020 - .039	(0.50 - 1.00)	.051 - .063	(1.30 - 1.60)
83000-9502	26 -	.035 - .040	(0.89 - 1.02)	.051 - .063	(1.30 - 1.60)
83000-9503	26 -	.035 - .040	(0.89 - 1.02)	.051 - .063	(1.30 - 1.60)
	-	-	-	-	-
	-	-	-	-	-
	-	-	-	-	-

B. DEFINITION (TERMS)



MFG. SH. REV.	D	L.T.R.	UAT2006-1384 6/21/2006 EPB 26AWG. SPEC. WAS .56-.61 MM.	REVISIONS	DIMENSIONS SHOWN (METRIC) INCH	▽ =	▼ =	REVISE ONLY ON CAD SYSTEM														
					UNLESS OTHERWISE SPECIFIED TOLERANCES: ANGULAR ± 1/2°	TITLE		SPECIFICATION SHEET FINEADJUST APPLICATOR														
					<table border="1" style="margin: auto;"> <thead> <tr> <th></th> <th>INCH</th> <th>METRIC</th> </tr> </thead> <tbody> <tr> <td>3 PLACE</td> <td>± ---</td> <td>---</td> </tr> <tr> <td>2 PLACE</td> <td>± ---</td> <td>± 0.13</td> </tr> <tr> <td>1 PLACE</td> <td>---</td> <td>± 0.25</td> </tr> </tbody> </table>		INCH	METRIC	3 PLACE	± ---	---	2 PLACE	± ---	± 0.13	1 PLACE	---	± 0.25	MOLEX INCORPORATED LISLE, ILL. 60532 U.S.A.		SHEET NO. 1 of 4	DATE 98/03/03	
	INCH	METRIC																				
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					DRAFT WHERE APPLICABLE MUST REMAIN WITHIN DIMENSIONS	PART NO. 638207800	DRWG. NO. 638207800															
					DRWG. BY: KDP APP'D. BY: S.W.	CHK'D. BY: KDP SCALE: --:--	FILE NAME 638207800 S80		THIS DRAWING CONTAINS INFORMATION THAT IS PROPRIETARY TO MOLEX INC. AND SHOULD NOT BE USED WITHOUT WRITTEN PERMISSION.													
							DIV. AT	SIZE A														

A

B

C

D

C. SPECIFICATION

NO. OF FIG.	ITEM	REQUIREMENT
1	BEND UP	3°
	BEND DOWN	3°
	TWISTING	4°
	ROLLING	8°
2	BELL MOUTH (FLARE)	0-0.10 MAX.
3	CUT-OFF TAB LENGTH	0.15 MAX.
4	EXTRUDED WIRE LENGTH (BRUSH)	0 - 0.45 MAX.
5	SEAM	SEAM SHALL NOT BE OPENED AND NO WIRE ALLOWED OUT OF THE CRIMPING AREA.
6	DISPARITY OF INSULATION BARREL	0.2 MAX.

D. CONDITIONS

AFTER CRIMPING , THE CRIMPED CONDUCTOR AREA SHOULD BE AS FOLLOWS.

TERMINAL SERIES	WIRE AWG	CRIMP HEIGHT		CRIMP WIDTH (REF.)		PULL FORCE MINIMUM	
		ENGLISH	(METRIC)	ENGLISH	(METRIC)	LBS.	(N)
83000-9502	28	.016 - .018	(0.41 - 0.46)	.031	(0.80)	2.20	(9.8)
	ⓓ26	.021-.023	(0.54-0.58)			3.00	(13.4)
		-	(-)				()
		-	(-)				()
83000-9503	28	.016 - .018	(0.41 - 0.46)	.031	(0.80)	2.20	(9.8)
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		-	(-)				()
		-	(-)				()
		-	(-)		()		()
		-	(-)		()		()
		-	(-)		()		()
		-	(-)		()		()

E. NOTES

1. WE RECOMMEND AN EXTRA SET OF PERISHABLE TOOLING BE MAINTAINED IN YOUR FACTORY.
2. VERIFY TOOLING ALIGNMENT BY MANUALLY CYCLING THE PRESS AND DIE BEFORE CRIMPING UNDERPOWER. CHECK THAT ALL SCREWS ARE TIGHT.
3. SLUGS, TERMINALS, DIRT AND OIL SHOULD BE KEPT CLEAR OF WORK AREA.
4. TO USE THE ABOVE SETTINGS, YOUR PRESS SHOULD HAVE A SHUT HEIGHT OF 135.8 MM. CRIMP HEIGHT MAY STILL VARY DEPENDING ON STYLE AND WIRE TYPE. SHIMMING COULD BE NECESSARY TO ACHIEVE CRIMP HEIGHTS.
5. TO PREVENT INJURY - NEVER OPERATE THIS TOOL WITHOUT THE GUARDING SUPPLIED WITH THE PRESS IN PLACE.

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DRAFT WHERE APPLICABLE MUST REMAIN WITHIN DIMENSIONS				MOLEX INCORPORATED LISLE, ILL. 60532 U.S.A.		SHEET NO. 2 of 4	DATE 98/03/04												
				PART NO. 638207800		DRWG. NO. 638207800													
		DRWG. BY KDP APP'D. BY S.W.		CHK'D. BY KDP SCALE --:--		FILE NAME 638207800 S81		THIS DRAWING CONTAINS INFORMATION THAT IS PROPRIETARY TO MOLEX INC. AND SHOULD NOT BE USED WITHOUT WRITTEN PERMISSION.	DIV. AT	SIZE A									

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D

F. BILL OF MATERIAL

TOOLING INFORMATION

ITEM	ORDER NO.	SIZE	ENG. NO.	DESCRIPTION	REQ'D
1	638207801	B	63820-7801	Conductor Punch	1
2	634450821	B	63445-0821	Combination Anvil	1
3	638207803	B	63820-7803	Insulation Punch	1
5	634430003	B	63443-0003	Cut-Off Plunger	1
6	634430012	B	63443-0012	Front Plunger Retainer	1
70	638207870		63820-7870	ToolKit(All Above Items)	0

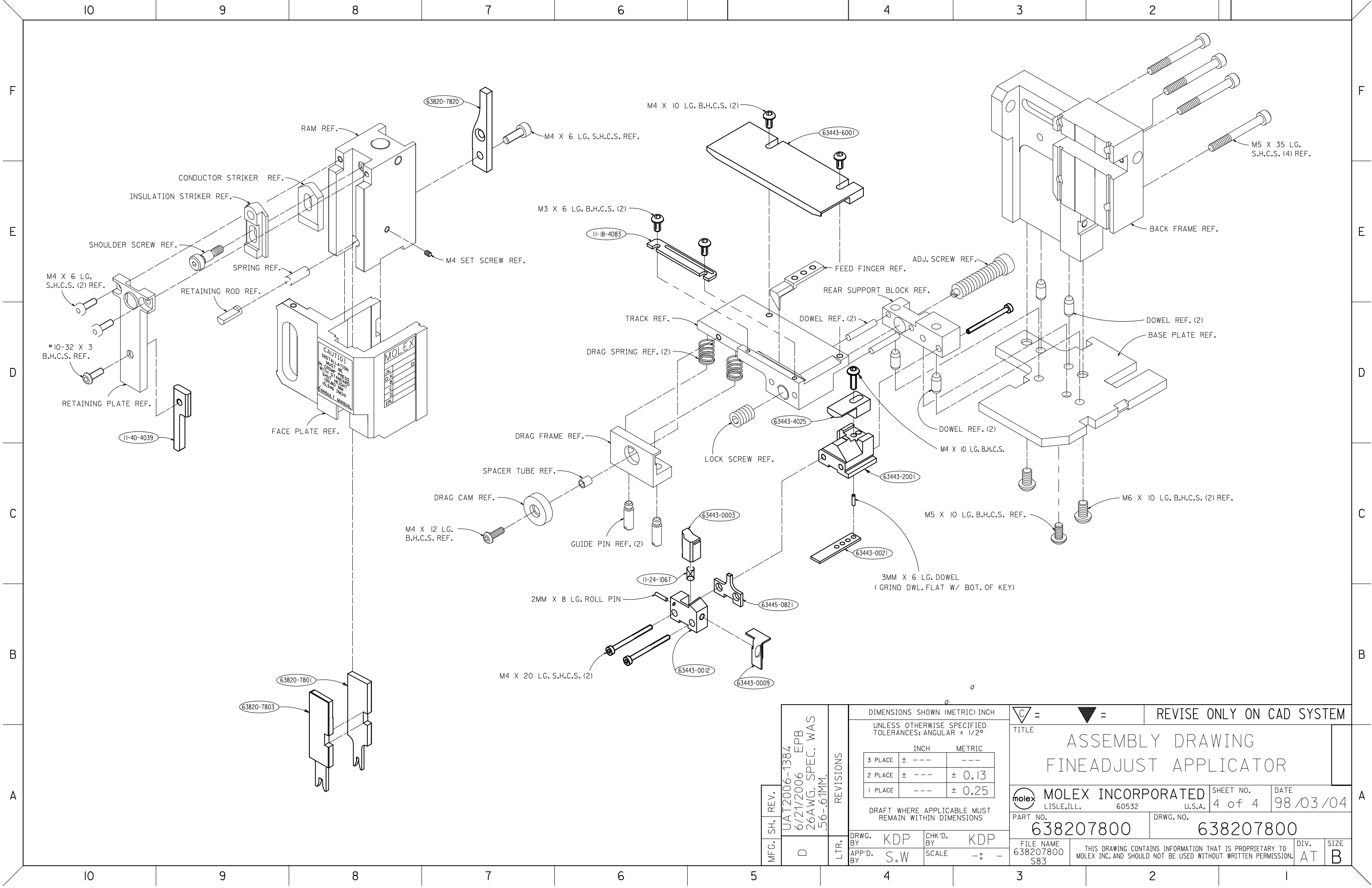
APPLICATOR ASSEMBLY - PARTS LIST

ITEM	ORDER NO.	SIZE	ENG. NO.	DESCRIPTION	REQ'D
10	11-40-4039	B	8302-5	Front Striker	1
11	634430021	B	63443-0021	LOWER TOOLING KEY	1
12	11-24-1067	B	4996-4	Cut-Off Plunger Spring	1
13	11-18-4083	B	60707-8	Front Cover	1
14	634436001	B	63443-6001	Rear Cover	1
15	634432001	B	634432001	ANVIL MOUNT	1
16	634434025	B	634434025	Wire Stop	1
18	634430009	B	63443-0009	SCRAP CHUTE	1

FRAME ASSEMBLY - PARTS LIST

ITEM	ORDER NO.	SIZE	ENG. NO.	DESCRIPTION	REQ'D
19	638000300	-	63800-0300	FINEADJUST FRAME	1
20	638207820	B	63820-7820	FEED CAM-SPECIAL	1

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MFG. SH. REV.
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 26AWG. SPEC. WAS
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MOLEX INCORPORATED LISLE, ILL. 60532 U.S.A.		SHEET NO. 4 of 4	DATE 98/03/04
PART NO. 638207800		DRWG. NO. 638207800	
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DIV. AT	SIZE B		

REVISIONS

LTR.	BY	CHK'D. BY	SCALE
	KDP	KDP	---
	S.W		---

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