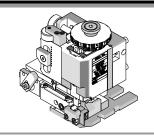




Application Tooling Specification Sheet



Order No. 63868-8000

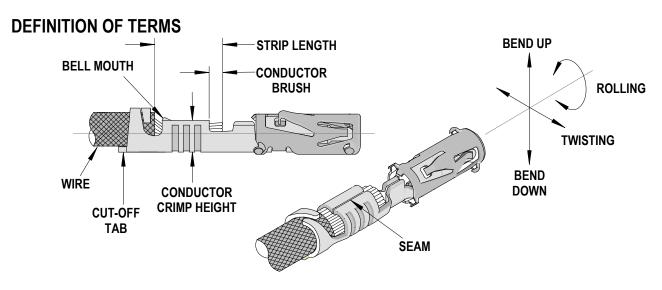
FEATURES

- 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 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

SCOPE

Products: 1.50mm (.059") CP Crimp Terminal for CMC connector, 0.50-1.00mm².

Terminal Series No.	Terminal Order No.	Wire Size		Insulation	Insulation	Strip Length		
Terminal Series No.	Terminal Order No.	AWG	mm²	Type	mm	ln.	mm	ln.
			1.00	ID and IR	1.75-2.00	.069079	4.50	.177
98915	98915-1029 98915-1319		0.75	D	1.65-1.80	.065071	4.50	.177
			0.60	IR	1.75-1.90	.069075	4.50	.177
			0.50	D	1.35-1.50	.053059	4.50	.177
64323	64323-1029 64323-1319		1.00	ID and IR	1.75-2.00	.069079	4.50	.177
			0.75	ID	1.65-1.80	.065071	4.50	.177
			0.60	IR	1.75-1.90	.069075	4.50	.177
			0.50	D	1.35-1.50	.053059	4.50	.177



Doc No: ATS-638688000 Release Date: 02-23-07 Revision: D Revision Date: 04-05-11

CRIMP SPECIFICATION

Terminal Series No.	Bell n	nouth	Cut-off Tak	Maximum	Conductor Brush		
	mm	ln.	mm	ln.	mm	ln.	
98915	0.00-0.30	.000012	0.30	.012	0.20-0.80	.008031	
64323	0.00-0.30	.000012	0.30	.012	0.20-0.80	.008031	

	Bend up Bend down		Twist Roll		Punch Width (Ref)				Seam
Terminal Series No.					Conductor		Insulation		
	Degree Maximum		Degree Maximum		mm	ln	mm	ln	Seam shall not be open
98915	2	2	2	2	2.00	.079	2.50	.098	and no wire allowed out
64323	2	2	2	2	2.00	.079	2.50	.098	of the crimping area

After crimping, the conductor profile should measure the following.

Terminal Series No.	Wire Size		Conductor C	rimp Height	Insulation Crim	p Height (Ref.)	Pull Force Minimum	
Terminal Series No.	AWG	mm ² mm		ln.	mm	ln.	N	Lb.
98915		1.00	1.27-1.37	.050054	2.55-2.70	.100106	115.0	25.90
		0.75	1.20-1.30	.047051	2.35-2.50	.093098	90.0	20.25
		0.60	1.15-1.25	.045049	2.35-2.50	.093098	80.0	18.00
		0.50	1.10-1.20	.043047	2.20-2.35	.087093	70.0	15.75
64323		1.00	1.27-1.37	.050054	2.55-2.70	.100106	115.0	25.90
		0.75	1.20-1.30	.047051	2.35-2.50	.093098	90.0	20.25
		0.60	1.15-1.25	.045049	2.35-2.50	.093098	80.0	18.00
		0.50	1.10-1.20	.043047	2.20-2.35	.087093	70.0	15.75

* Tool Qualification Notes:

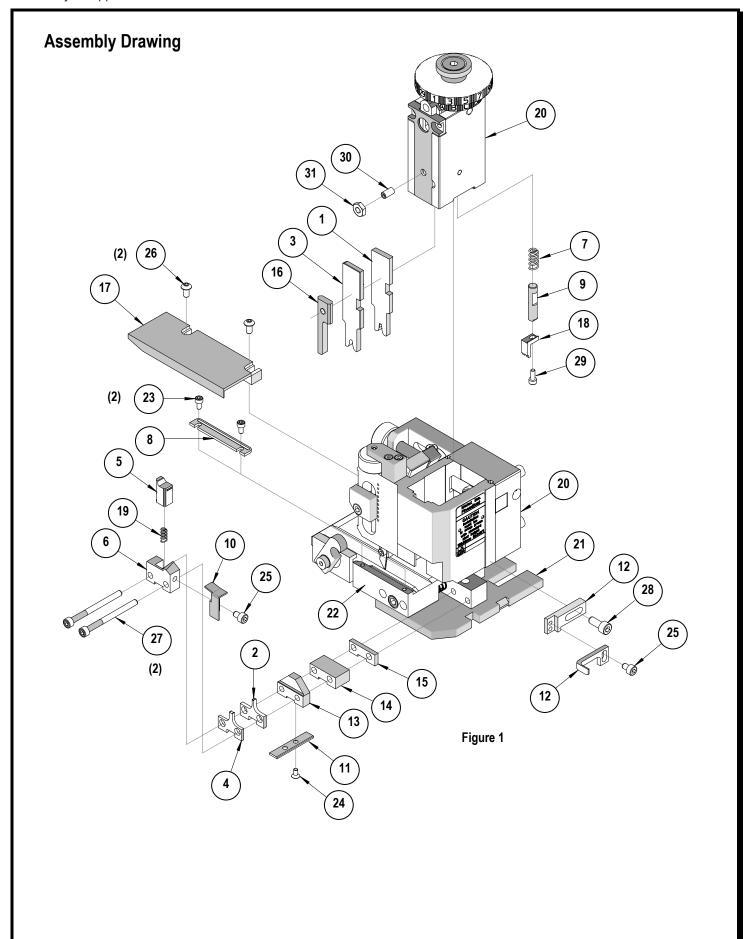
- 1. Pull Force should be measured with no influence from the insulation crimp.
- 2. The above specifications are guidelines to an optimum crimp.

Doc No: ATS-638688000 Release Date: 02-23-07 **UNCONTROLLED COPY** Page 2 of 5 Revision: D Revision Date: 04-05-11

PARTS LIST

	FineAdjust Applicator 63868-8000							
Item	Order No	Engineering No.	Description	Quantity				
	Perishable Tooling							
	63868-8070	63868-8070	Tool Kit (All "Y" Items)	REF				
1	63457-0033	63457-0033	Conductor Punch	1 Y				
2	63455-0038	63455-0038	Conductor Anvil	1 Y				
3	63454-0058	63454-0058	Insulation Punch	1 Y				
4	63456-0038	63456-0038	Insulation Anvil	1 Y				
5	63443-0035	63443-0035	Cut-Off Plunger	1 Y				
6	63443-0036	63443-0036	Front Plunger Retainer	1 Y				
			Components					
7	11-17-0022	1739-21	Hold Down Spring	1				
8	11-18-4083	60707-8	Feed Guide	1				
9	11-24-1149	4996-37	Shank	1				
10	63443-0009	63443-0009	Scrape Chute	1				
11	63443-0024	63443-0024	Key	1				
12	63443-0090	63443-0090	Wire Stop	1				
13	63443-1715	63443-1715	Height Spacer	1				
14	63443-2214	63443-2214	Course Spacer (14.0mm)	1				
15	63443-2307	63443-2307	Fine Spacer (3.35mm)	1				
16	63443-3160	63443-3160	Front Plunger Striker	1				
17	63443-6121	63443-6121	Rear Cover	1				
18	63443-7002	63443-7002	Terminal Hold Down	1				
19	63700-0539	63700-0539	Cut-off Plunger Spring	1				
	Frame							
20	63800-4901	63800-4901	Тор	1				
21	63801-3281	63801-3281	Base	1				
22	63801-4650	63801-4650	Track	1				
			ardware					
23	N/A	N/A	M3 by 6 Long SHCS	2**				
24	N/A	N/A	M3 by 6 Long FHCS	1**				
25	N/A	N/A	M4 by 6 Long SHCS	2**				
26	N/A	N/A	M4 by 12 Long BHCS	2**				
27	N/A	N/A	M4 by 50 Long SHCS	2**				
28	N/A	N/A	M5 by 12 Long SHCS	1**				
29	N/A	N/A	#5-40 by 3/8"Long SHCS	1**				
30	N/A	N/A	#10-32 by 3/8"Long Flat Point SSS	1**				
31	N/A	N/A	#10-32 Hex Jam Nut	1**				
,	** Available from an industrial supply company such as MSC (1-800-645-7270).							

UNCONTROLLED COPY Page 3 of 5 Doc No: ATS-638688000 Release Date: 02-23-07 Revision: D Revision Date: 04-05-11



Doc No: ATS-638688000 Revision: D Release Date: 02-23-07 Revision Date: 04-05-11

Optional Applicator Parts:

The following parts are *not included* with this Applicator and may be purchased separately.

63901-6106 Cut-Off Plunger Retainer

For wire processing applications:

It is recommended for fully automatic, high speed operations, where the press and the applicator are mounted to a wire processing machine.

Applicator down time for scrap clean-up may be reduced.

This cut-off plunger retainer leaves the scrap terminal carrier intact.

Not recommended for bench operation, where a continuous scrap strip can tangle or build up inside of the safety guards resulting in jams or tooling damage.



- 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.

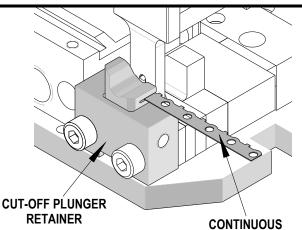
CAUTION: This applicator should only be used in a press with a shut height of 135.8mm (5.346"). Tooling damage could result at a lower setting.

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.

http://www.molex.com

Doc No: ATS-638688000 Release Date: 02-23-07 **UNCONTROLLED COPY**Revision: D Revision Date: 04-05-11



CONTINUOUS
CARRIER STRIP

Page 5 of 5