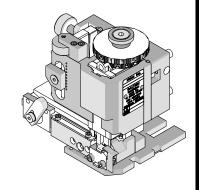


FineAdjust Applicator Applicator Tooling Specification Sheet Order No. 63901-6500



FEATURES

- 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
- Directly adapts to most automatic wire processing machines

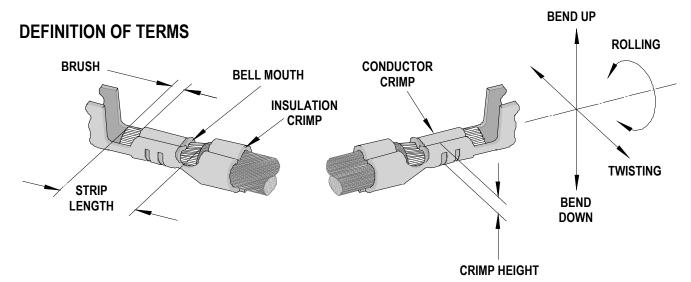
SCOPE

Products: HDX™ Crimp Receptacle Terminal, Female, 0.635mm (.025"), AWG 20-24 (0.22-0.60mm²).

Terminal	Terminal	Wire Size			Insulation	Strip Length			
Series No.	Order No.			IPC/WHM	A-A620+	Termin	nal ++	Strip Length	
Selles No.		AWG	mm²	mm	ln.	mm	ln.	mm	ln.
		0.22 R1	0.22	1.15-1.25	.045049	1.15-1.25	.045049		.142173
		0.35 R1 R3	0.34	1.25-1.40	.049055	1.25-1.40	.049055	3.60-4.40	
98587	98587-0014	0.35 D3	0.34	1.20-1.35	.047053	1.20-1.35	.047053		
30301		0.50 R1 R3	0.478	1.45-1.60	.057063	1.45-1.60	.057063		
		0.50 D3	0.478	1.40-1.50	.055059	1.40-1.50	.055059		
		0.60 R1 R3	0.59	1.75-1.90	.069075	1.75-1.90	.069075		
	98588-0014	0.22 R1	0.22	1.15-1.25	.045049	1.15-1.25	.045049	3.60-4.40	.142173
		0.35 R1 R3	0.34	1.25-1.40	.049055	1.25-1.40	.049055		
98588		0.35 D3	0.34	1.20-1.35	.047053	1.20-1.35	.047053		
90000		0.50 R1 R3	0.478	1.45-1.60	.057063	1.45-1.60	.057063		
		0.50 D3	0.478	1.40-1.50	.055059	1.40-1.50	.055059		
		0.60 R1 R3	0.59	1.75-1.90	.069075	1.75-1.90	.069075		
◆ To achieve optimum IPC-A620 insulation crimps, use this insulation OD range.									

♦ Overall insulation OD specification for terminal.

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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 m	outh	Cut-off Tab	Maximum	Conductor Brush Minimum		
Terminal Series No.	mm	ln.	mm	ln.	mm	ln.	
98587	*	*	0.25	.010	0.10	.004	
98588	*	*	0.25	.010	0.10	.004	

Terminal Series No.	Bend up Bend down Degree		I IWIST KOII ———			Punch Width (Ref) onductor Insulation			Seam Seam shall not be
					mm	ln	mm	In	Seam shall not be open and no wire allowed
98587	*	*	3	3	1.50	.059	2.30	20 I 000 I '	out of the crimping area
98588	*	*	3	3	1.50	.059	2.30	.090	out of the chiliping area

^{*}Specifications not available

After crimping, the crimp profiles should measure the following:

			Conductor				Insulation					Pull Force	
Terminal Series No.	Wire Size		Crimp Height		Crimp Width (Ref)		Crimp Height		Crimp Width (Ref.)		Minimum		
	AWG	mm ²	mm	ln.	mm	ln.	mm	ln.	mm	ln.	N	Lb.	
	0.22 R1	0.22	0.98-1.04	.039041	1.40-1.60	.055063	1.46-1.66	.057065	2.10-2.30	.082090	50.0	11.24	
	0.35 R1 R3	0.34	1.02-1.08	.040042	1.40-1.60	.055063	1.50-1.70	.059067	2.10-2.30	.082090	60.0	13.49	
98587	0.35 D3	0.34	1.02-1.08	.040042	1.40-1.60	.055063	1.35-1.55	.053061	2.10-2.30	.082090	60.0	13.49	
30301	0.50 R1 R3	0.478	1.04-1.10	.041043	1.40-1.60	.055063	1.90-2.00	.075078	2.20-2.40	.087094	80.0	17.98	
	0.50 D3	0.478	1.04-1.10	.041043	1.40-1.60	.055063	1.45-1.65	.057065	2.20-2.40	.087094	80.0	17.98	
	0.60 R1 R3	0.59	1.11-1.17	.044046	1.40-1.60	.055063	1.90-2.00	.075078	2.25-2.35	.089093	100.0	22.48	
	0.22 R1	0.22	0.98-1.04	.039041	1.40-1.60	.055063	1.46-1.66	.057065	2.10-2.30	.082090	50.0	11.24	
	0.35 R1 R3	0.34	1.02-1.08	.040042	1.40-1.60	.055063	1.50-1.70	.059067	2.10-2.30	.082090	60.0	13.49	
98588	0.35 D3	0.34	1.02-1.08	.040042	1.40-1.60	.055063	1.35-1.55	.053061	2.10-2.30	.082090	60.0	13.49	
90000	0.50 R1 R3	0.478	1.04-1.10	.041043	1.40-1.60	.055063	1.90-2.00	.075078	2.20-2.40	.087094	80.0	17.98	
	0.50 D3	0.478	1.04-1.10	.041043	1.40-1.60	.055063	1.45-1.65	.057065	2.20-2.40	.087094	80.0	17.98	
	0.60 R1 R3	0.59	1.11-1.17	.044046	1.40-1.60	.055063	1.90-2.00	.075078	2.25-2.35	.089093	100.0	22.48	

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Fine A	djust Applicator for HDX™ Crimp Receptacle Terminals
•	Tool Qualification Notes:
1. 2.	

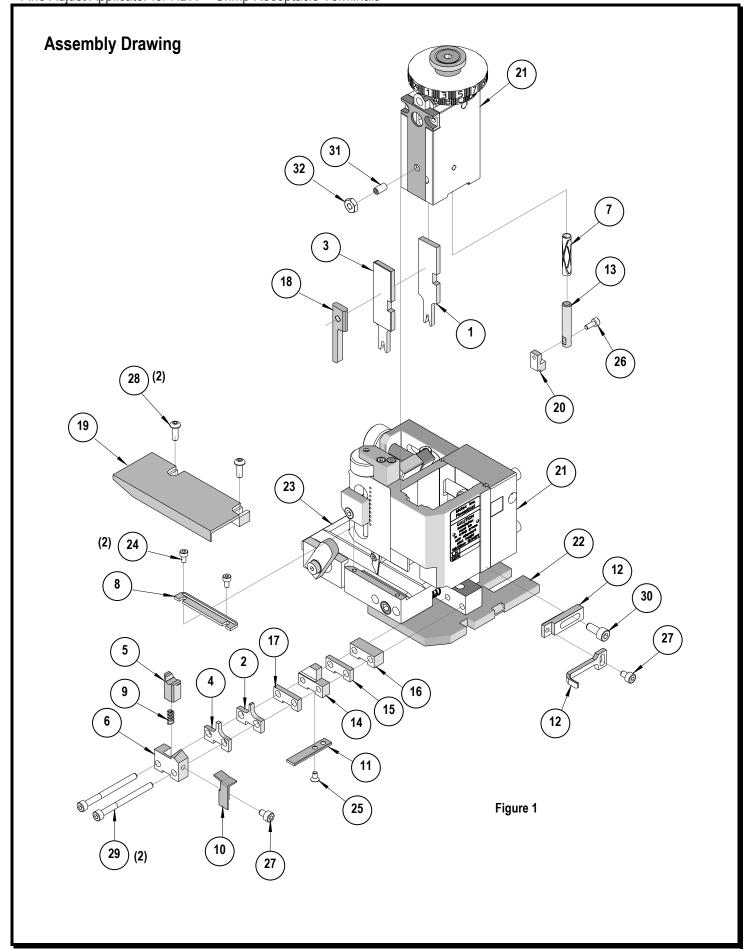
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PARTS LIST

FineAdjust Applicator 63901-6500									
Item									
		Perish	nable Tooling						
	63901-6570	63901-6570	Tool Kit (All "Y" Items)	REF					
1	63457-0062	63457-0062	Conductor Punch	1 Y					
2	63455-0086	63455-0086	Conductor Anvil	1 Y					
3	63454-1105	63454-1105	Insulation Punch	1 Y					
4	63456-0065	63456-0065	Insulation Anvil	1 Y					
5	63443-0005	63443-0005	Cut-Off Plunger	1 Y					
6	63443-0012	63443-0012	Front Plunger Retainer	1 Y					
Other Components									
7	11-17-0022	1739-21	Hold Down Spring	1					
8	11-18-4083	60707-8	Feed Guide	1					
9	11-24-1067	4996-4	Cut-off Plunger Spring	1					
10	63443-0009	63443-0009	Scrap Chute	1					
11	63443-0024	63443-0024	Key	1					
12	63443-0090	63443-0090	Wire Stop	1					
13	63443-0093	63443-0093	Shank	1					
14	63443-1720	63443-1720	19.00mm Spacer	1					
15	63443-2204	63443-2204	4.00mm Spacer	1					
16	63443-2210	63443-2210	10.00mm Spacer	1					
17	63443-2311	63443-2311	3.55mm Spacer	1					
18	63443-3101	63443-3101	Front Plunger Striker	1					
19	63443-6112	63443-6112	Rear Cover	1					
20	63443-7106	63443-7106	Terminal Hold Down	1					
			Frame						
21	63800-4901	63800-4901	Тор	1					
22	63801-3281	63801-3281	Base	1					
23	63801-4650	63801-4650	Track	1					
		Н	ardware						
24	N/A	N/A	M3 by 6 Long SHCS	2**					
25	N/A	N/A	M3 by 6 Long FHCS	1**					
26	N/A	N/A	M3 by 8 Long SHCS	1**					
27	N/A	N/A	M4 by 6 Long SHCS	2**					
28	N/A	N/A	M4 by 12 Long BHCS	2**					
29	N/A	N/A	M4 by 50 Long SHCS	2**					
30	N/A	N/A	M5 by 12 Long SHCS	1**					
31	N/A	N/A	#10-32 by 3/8"Long Flat Point SSS	1**					
32	N/A	N/A	#10-32 Hex Jam Nut	1**					
*	* Available fron	n an industrial supply	y company such as MSC (1-800-645-7	'270).					

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NOTES

- 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 135.80 mm (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.

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