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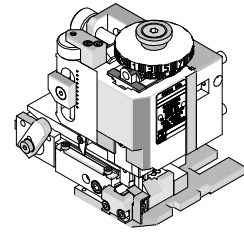
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Fine Adjust Applicator for 2.5 Floating Plug Terminals

**FineAdjust
Applicator**

molex

**Application Tooling
Specification Sheet**



Order No. 63902-6100

FEATURES

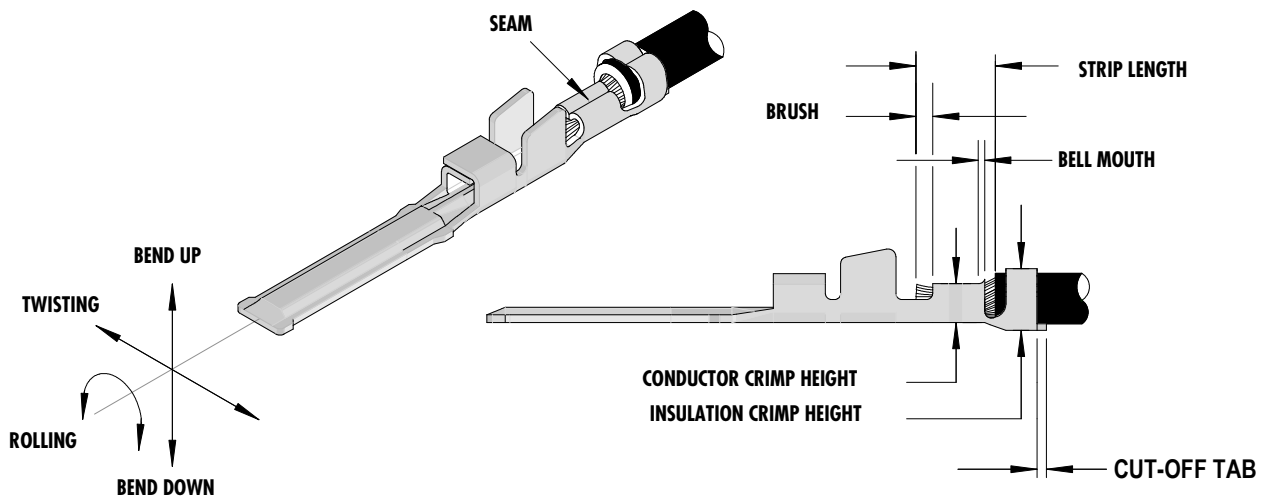
- Directly adapts to most automatic wire processing machines
- Quick punch removal with the push of a button for fast and easy tooling change
- Applicator designed to industry standard mounting and shut height 135.80mm (5.346")
- Quick set-up time; plus the crimp height, track and feed adjustments can 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: 2.5 Floating Plug Terminals, 22 AWG (UL1007) wires.

Terminal Series No.	Terminal Order No.	Wire Size and Type			Insulation Diameter		Strip Length	
		AWG	mm ²	Type	mm	In.	mm	In.
503371	503371-0000	22	0.30	UL1007	1.40-1.70	.055-.067	2.40-2.80	.094-.110

DEFINITION OF TERMS



Fine Adjust Applicator for 2.5 Floating Plug Terminals

CRIMP SPECIFICATION

Terminal Series No.	Bell mouth		Cut-off Tab Maximum		Conductor Brush	
	mm	In.	mm	In.	mm	In.
503371	0.30-0.65	.012-.025	0.20	.008	0.10-0.50	.004-.020

Terminal Series No.	Bend up	Bend down	Twist	Roll	Punch Width (Ref)				Seam Seam shall not be open and no wire allowed out of the crimping area
					Conductor		Insulation		
	Degree (Max)		Degree (Max)		mm	In	mm	In	
503371	3	3	3	5	1.40	.055	1.80	.071	

After crimping, the conductor profile should measure the following.

Terminal Series No.	Wire Size		Conductor Crimp Height		Conductor Crimp Width (Ref)		Pull Force Minimum	
	AWG	mm ²	mm	In.	mm	In.	N	Lb.
503371	22	0.30	0.88-0.93	.035-.037	1.40	.055	34.3	7.7

Terminal Series No.	Wire Size		Insulation Crimp Height (Ref)		Insulation Crimp Width (Ref)	
	AWG	mm ²	mm	In.	mm	In.
503371	22	0.30	2.20	.087	1.80	.071

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.

Fine Adjust Applicator for 2.5 Floating Plug Terminals

PARTS LIST

FineAdjust Applicator 63902-6100				
Item	Order No	Engineering No.	Description	Quantity
Perishable Tooling				
	63902-6170	63902-6170	Tool Kit (All "Y" Items)	REF
1	63444-1407	63444-1407	Conductor Punch	1 Y
2	63455-0121	63455-0121	Conductor Anvil	1 Y
3	63446-1810	63446-1810	Insulation Punch	1 Y
4	63445-1819	63445-1819	Insulation Anvil	1 Y
5	63443-0005	63443-0005	Front Cut-Off Plunger	1 Y
6	63443-0012	63443-0012	Front Plunger Retainer	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	63443-0009	63443-0009	Front Scrap Chute	1
10	63443-0024	63443-0024	Key	1
11	63443-0090	63443-0090	Wire Stop	1
12	63443-1719	63443-1719	18.90mm Height Spacer	1
13	63443-2216	63443-2216	16.00mm Spacer	1
14	63443-2311	63443-2311	3.55mm Spacer	1
15	63443-2802	63443-2802	Front Plunger Striker	1
16	63443-2907	63443-2907	Striker Plunger	1
17	63443-6111	63443-6111	Rear Cover	1
18	63600-0021	63600-0021	Striker Plunger Spring	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	N/A	N/A	M3 by 6 Long SHCS	2**
23	N/A	N/A	M3 by 6 Long FHCS	1**
24	N/A	N/A	M4 by 6 Long SHCS	2**
25	N/A	N/A	M4 by 12 Long BHCS	2**
26	N/A	N/A	M4 by 50 Long SHCS	2**
27	N/A	N/A	M5 by 12 Lg SHCS	1**
28	N/A	N/A	#10-32 by 3/8" Long Flat Point SSS	1**
29	N/A	N/A	#10-32 Hex Jam Nut	1**
** Available from an industrial supply company such as MSC (1-800-645-7270).				

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Assembly Drawing

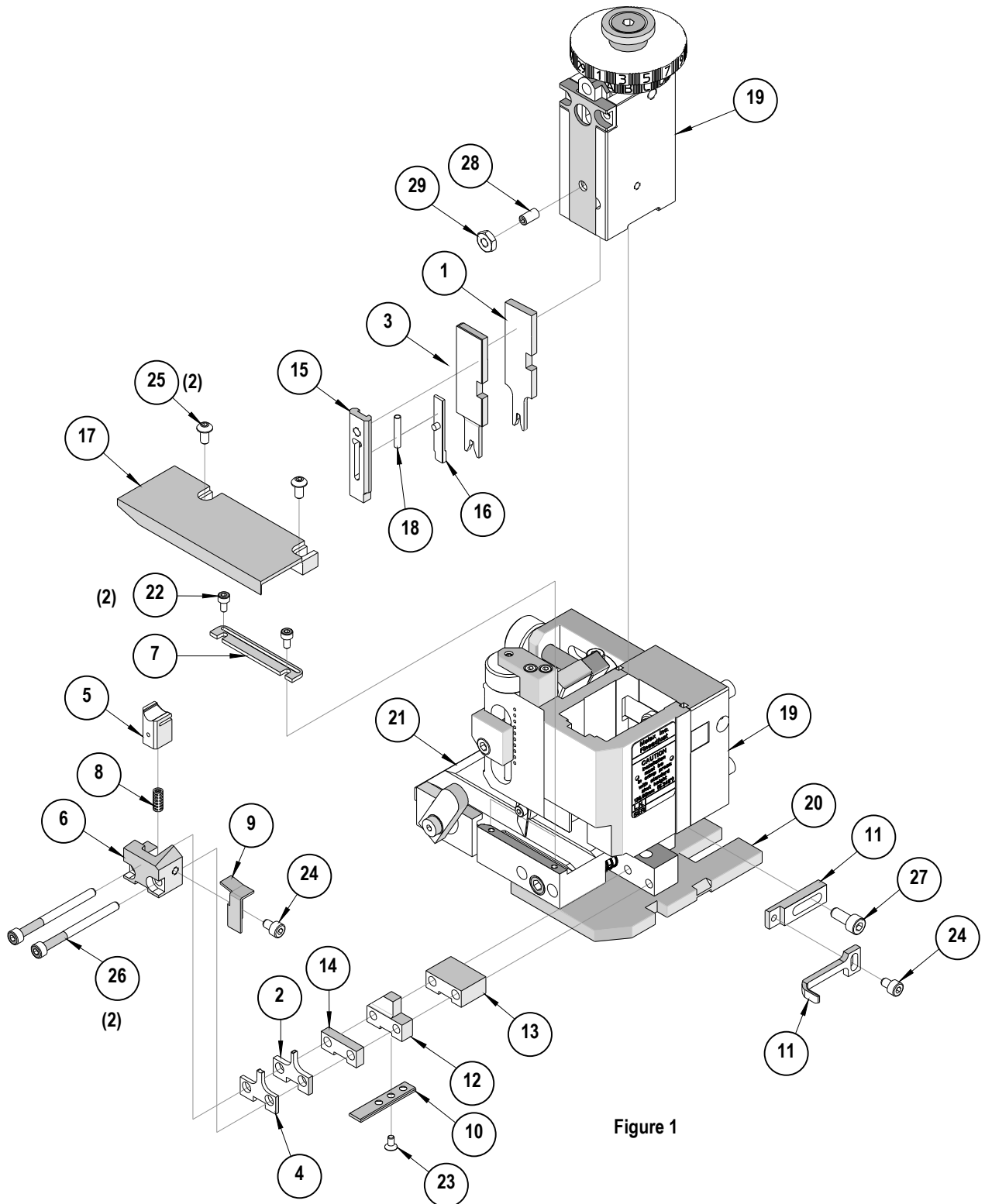


Figure 1

Fine Adjust Applicator for 2.5 Floating Plug Terminals

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 135.8mm (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.

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