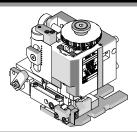


Application Tooling Specification Sheet



Order No. 63866-1000

BEND UP

FEATURES

FineAdjust Applicator

- 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 0.15mm (.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

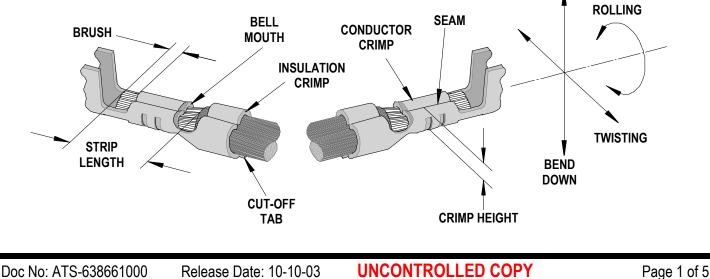
Revision: C

Insulation Diameter Terminal Terminal Wire Size Strip Length IPC/WHMA-A620 (1) Terminal (2) Series No. Order No. AWG mm² In. mm mm In. mm In. 47634-1000 18 0.83 2.00-2.40 .079-.095 2.00-2.40 .079-.095 2.50-3.50 .098-.138 47634 47634-1001 20 0.52 1.65-1.95 .065-.077 1.55-1.95 .061-.077 2.50-3.50 .098-.138 47634-1002 1.65-1.80 .065-.071 1.40-1.80 22 0.32 .055-.071 2.50-3.50 .098-.138 2.00-2.40 .079-.095 2.00-2.40 .079-.095 2.50-3.50 18 0.83 .098-.138 67581-0010 20 1.65-1.95 .065-.077 1.55-1.95 67581 67581-0011 0.52 .061-.077 2.50-3.50 .098-.138 67581-0012 22 0.32 1.65-1.80 .065-.071 1.40-1.80 .055-.071 2.50-3.50 .098-.138 (1) To achieve optimum IPC-A620 Class 2 insulation crimps. For smaller wire diameter use Applicator order no. 63902-3500. (2) Overall insulation OD specification for terminal.

Products: 1.27mm (.050") Pitch SATA Crimp Power Terminal, 18-22 AWG.

Revision Date: 10-19-10





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 n	nouth	Cut-off Tab	o Maximum	Conductor Brush		
Terminal Series No.	mm	In.	mm	ln.	mm	In.	
47634	0.20-0.50	.008020	0.30	.012	0.00-1.00	.000039	
67581	0.20-0.50	.008020	0.30	.012	0.00-1.00	.000039	

Terminal	Bend up Bend down		Twist	Roll	Punch Width (Ref)			Seam	
Series No.	Degree		Degree		Conductor		Insulation		
Series No.					mm	In	mm	In	Seam shall not be open
47634	8	3	4	8	1.60	.063	2.50	.098	and no wire allowed out of the crimping area
67581	8	3	4	8	1.60	.063	2.50	.098	or the chiliping area

After crimping, the conductor profile should measure the following.

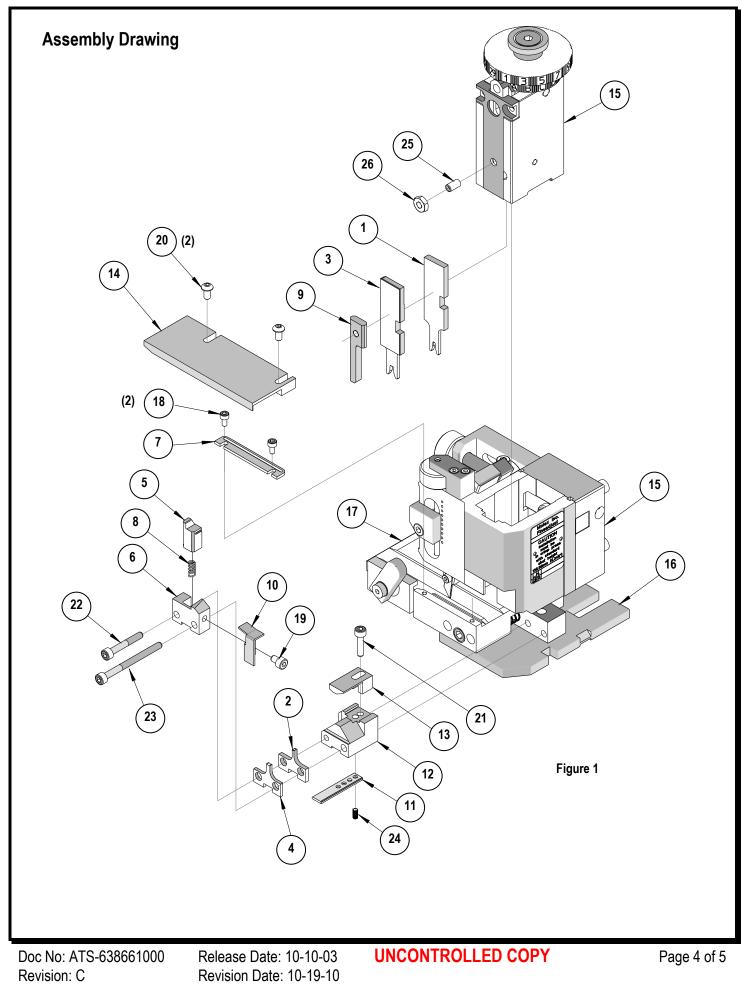
Terminal Series No.	Wire Size			uctor Height	Insul Crimp	Pull Force Minimum		
	AWG	mm ²	mm	ln.	mm	ln.	Ν	Lb.
	18	0.83	1.15-1.25	.045049	2.25-2.55	.088100	88.2	19.82
47634	20	0.52	1.10-1.20	.043047			58.8	13.21
	22	0.32	1.05-1.15	.041045			39.2	8.80
	18	0.83	1.15-1.25	.045049	2.25-2.55	.088100	88.2	19.82
67581	20	0.52	1.10-1.20	.043047			58.8	13.21
	22	0.32	1.05-1.15	.041045			39.2	8.80

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.

PARTS LIST

FineAdjust Applicator 63866-1000									
ltem	Order No.	Engineering No.	Description	Quantity					
Perishable Tooling									
	63866-1070	63866-1070	Tool Kit (All "Y" Items)	REF					
1	63444-1604	63444-1604	Conductor Punch	1 Y					
2	63445-1641	63445-1641	Conductor Anvil	1 Y					
3	63446-2502	63446-2502	Insulation Punch	1 Y					
4	63445-2511	63445-2511	Insulation Anvil	1 Y					
5	63443-0003	63443-0003	Cut-Off Plunger	1 Y					
6	63443-0012	63443-0012	Front Plunger Retainer	1 Y					
Other Components									
7	11-18-4083	60707-8	Front Cover	1					
8	11-24-1067	4996-4	Cut-off Plunger Spring	2					
9	11-40-4039	8302-5	Front Plunger Striker	1					
10	63443-0009	63443-0009	Scrape Chute	1					
11	63443-0021	63443-0021	Lower Tooling Key	1					
12	63443-2409	63443-2409	Anvil Mount	1					
13	63443-4018	63443-4018	Wire Stop	1					
14	63443-6004	63443-6004	Rear Cover	1					
			Frame						
15	63800-4901	63800-4901	Тор	1					
16	63801-3281	63801-3281	Base	1					
17	63801-4650	63801-4650	Track	1					
		Н	lardware						
18	N/A	N/A	M3 by 6 Long SHCS	2**					
19	N/A	N/A	M4 by 6 Long SHCS	1**					
20	N/A	N/A	M4 by 12 Long BHCS	2**					
21	N/A	N/A	M4 by 16 Lg SHCS	1**					
22	N/A	N/A	M4 by 20 Long SHCS	1**					
23	N/A	N/A	M4 by 50 Long SHCS	1**					
24	N/A	N/A	3MM by 6 Long Roll Pin	1**					
25	N/A	N/A	#10-32 by 3/8"Long Flat Point SSS	1**					
26	N/A	N/A	#10-32 Hex Jam Nut	1**					
** Available from an industrial supply company such as MSC (1-800-645-7270).									



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 135.8 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.

http://www.molex.com