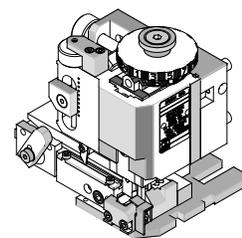




**FineAdjust
Applicator**

**Application Tooling
Specification Sheet**



Order No. 63903-5000

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

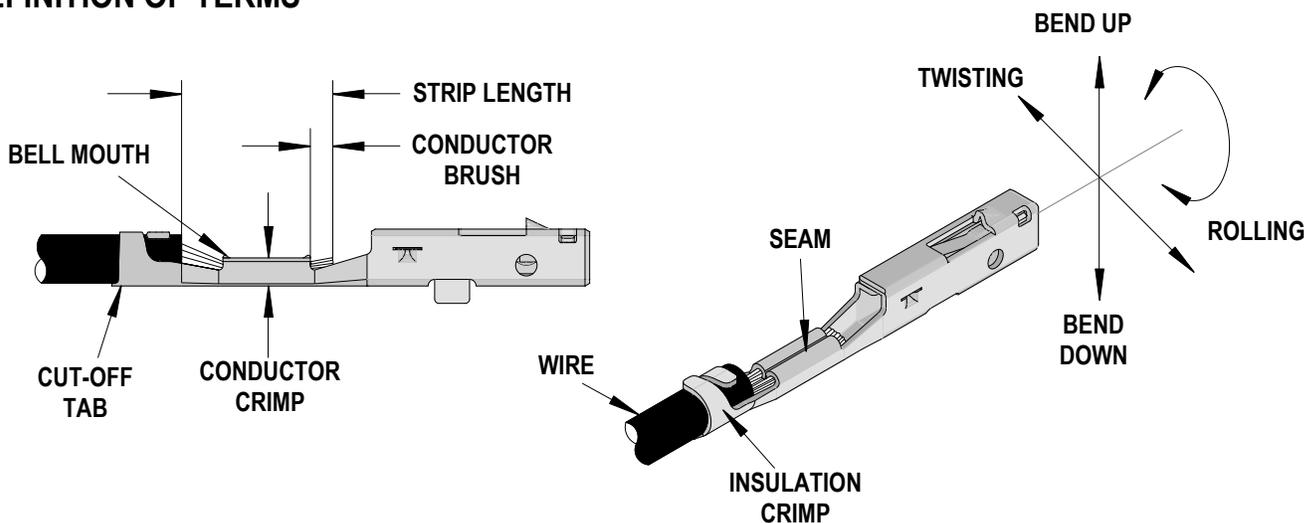
SCOPE

Products: CTX50 Receptacle Terminal Unsealed, 0.35mm².

Terminal Series No.	Terminal Order No.	Wire Size and Type		Insulation Diameter (1)		Strip Length	
		mm ²	Type	mm	In.	mm	In.
560023	560023-0448	0.35	FLR2XA3ZH	1.10-1.40	.043-.055	3.00-3.20	.118-.126

(1) To achieve optimum IPC-A620 insulation crimps, use this insulation OD range.
 (2) This Applicator must be used in an automatic wire processor to achieve correct brush specification.
 (3) Oiler (63801-7240) Required to crimp terminals. See 63800-4900 FineAdjust Manual.

DEFINITION OF TERMS



CRIMP SPECIFICATION

Terminal Series No.	Bell mouth (Wire Side)		Cut-off Tab Maximum		▶ Conductor Brush Maximum (2) See Product Chart	
	mm	In.	mm	In.	mm	In.
560023	0.65-0.75	.025-.030	0.30	.012	0.55	.022

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
	Degree		Degree		Conductor		Insulation		
					mm	In	mm	In	
560023	1	1	1	1	1.00	.039	1.33	.052	

After crimping, the crimp profiles should measure the following:

Terminal Series No.	Wire Size mm ²	Conductor				Pull Force Minimum	
		Crimp Height		Crimp Width (Ref.)		N	Lb.
		mm	In.	mm	In.		
560023	0.35	0.65-0.69	.025-.027	1.01-1.07	.040-.042	50.0	11.24

Terminal Series No.	Wire Size mm ²	Insulation Diameter		Insulation			
		mm	In.	Crimp Height		Crimp Width (Ref.)	
				Mm	In.	mm	In.
560023	0.35	1.10-1.40	.043-.055	1.48-1.58	.058-.062	1.30-1.40	.051-.055

▶ 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 63903-5000				
Item	Order No	Engineering No.	Description	Quantity
Perishable Tooling				
	63903-5070	63903-5070	Tool Kit (All "Y" Items)	REF
1	63457-1002	63457-1002	Conductor Punch	1 Y
2	63455-1001	63455-1001	Conductor Anvil	1 Y
3	63454-1301	63454-1301	Insulation Punch	1 Y
4	63456-1301	63456-1301	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	63443-2806	63443-2806	Front Plunger Striker	1
15	63443-2908	63443-2908	Wire Hold-Down Plunger	1
16	63443-6001	63443-6001	Rear Cover	1
17	63600-0021	63600-0021	Striker Plunger Spring	1
18	63901-4804	63901-4804	Terminal Hold Down	1
19	63903-5005	63903-5005	19.00mm Height Spacer	1
Frame				
20	63800-4901	63800-4901	Top	1
21	63801-3281	63801-3281	Base	1
22	63801-4650	63801-4650	Track	1
Hardware				
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	M3 by 8 Long SHCS	1**
26	N/A	N/A	M4 by 6 Long SHCS	2**
27	N/A	N/A	M4 by 12 Long BHCS	2**
28	N/A	N/A	M4 by 50 Long SHCS	2**
29	N/A	N/A	M5 by 12 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).				

Assembly Drawing

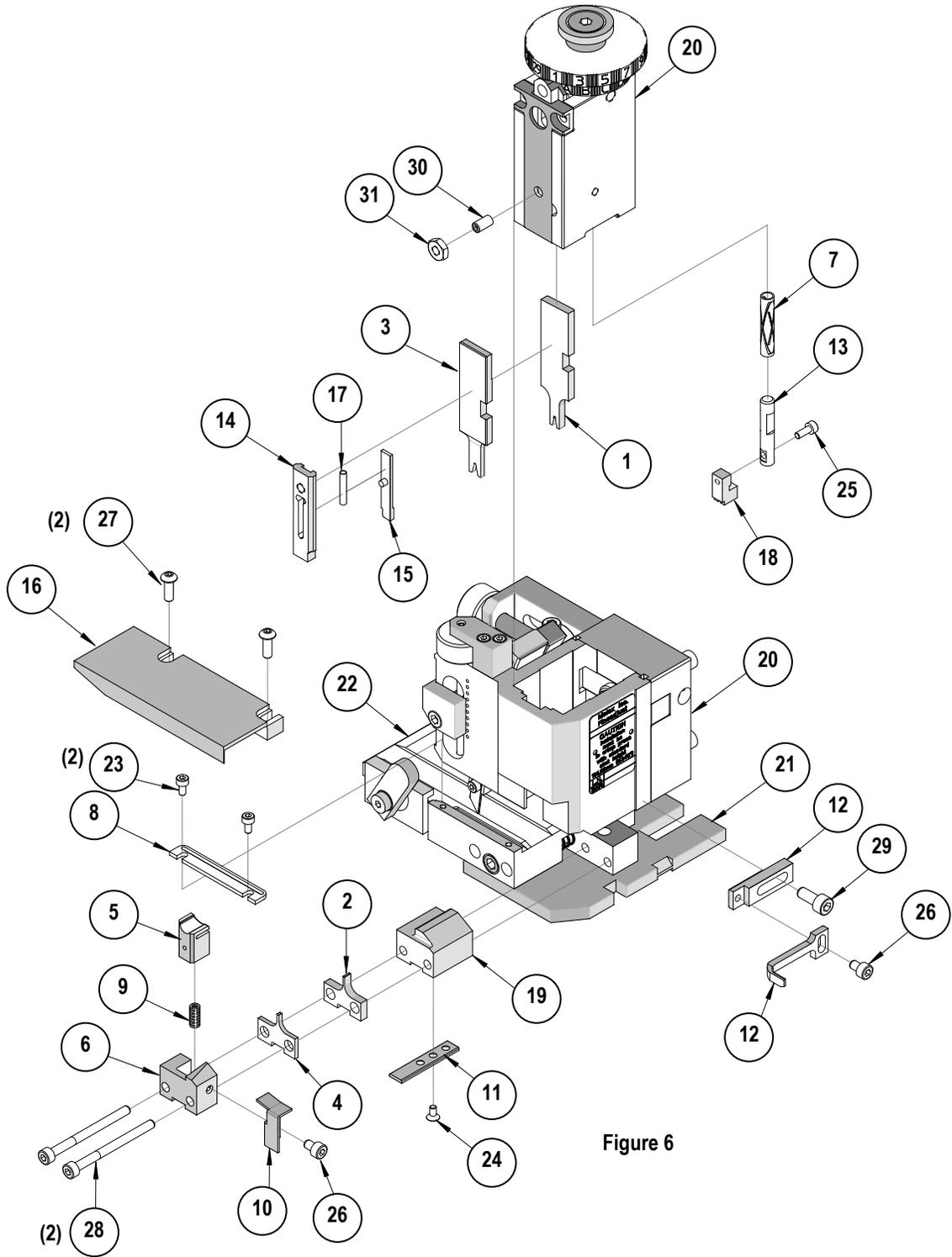


Figure 6

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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