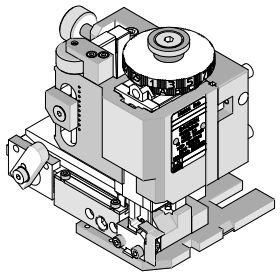
Order Number
63904-7600

molex®

Application Tooling Specification



FEATURES

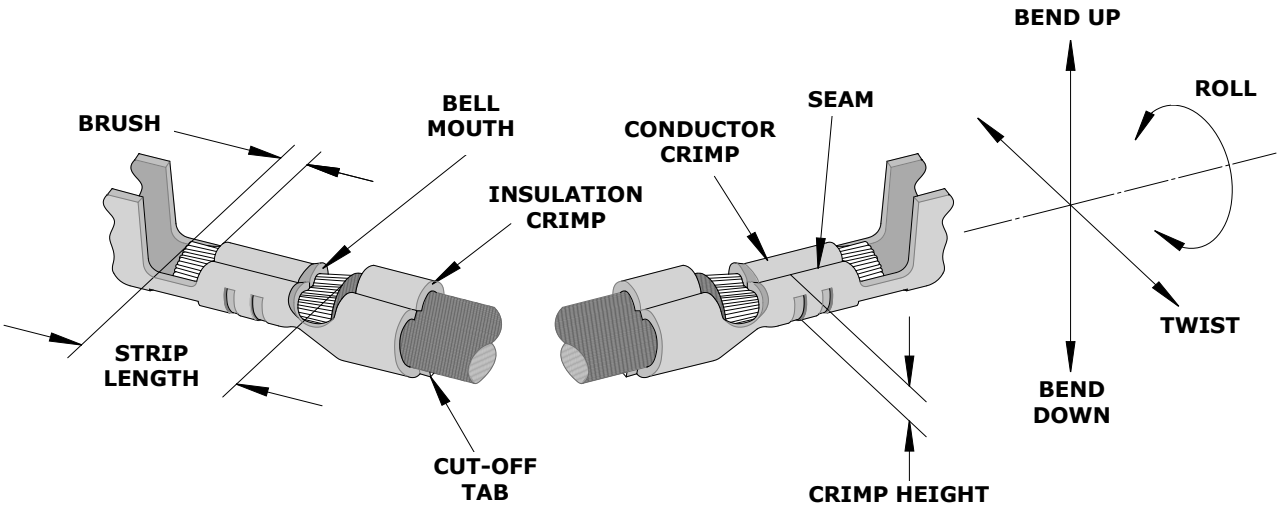
- Directly adapts to most automatic wire processing machines
- Quick punch removal with the push of a button for fast and easy tooling change
- Applicator designed to industry-standard mounting and 135.80mm (5.346") shut height
- Quick setup time; plus, the crimp height, track and feed adjustments can 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: L1NK 250 Female Crimp Terminal, 22-24 AWG, UL1007 Wire.

Terminal Series No.	Terminal Order No.	Wire Size		Insulation Diameter		Strip Length	
		AWG	mm²	mm	In.	mm	In.
46626	46626-1305	22-24	0.35-0.20	1.40-1.70	.055-.067	2.00-2.60	.079-.102

DEFINITION OF TERMS



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 Mouth		Cut-Off Tab Maximum		Conductor Brush	
	mm	In.	mm	In.	mm	In.
46626	0.10-0.40	.004-.016	0.30	.012	0.10-0.70	.004-.028

Terminal Series No.	Bend Up	Bend Down	Twist	Roll	Punch Width (Ref)				Seam
	Degree (Max)		Degree (Max)		Conductor		Insulation		
					mm	In.	mm	In.	
46626	3	3	4	8	1.40	.055	1.90	.075	Seam shall not be open and no wire allowed out of the crimping area

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.
46626	22	0.35	0.77-0.85	.030-.033	1.40	.055	35.6	8.0
	24	0.20	0.62-0.72	.024-.028	1.40	.055	22.3	5.0

Terminal Series No.	Wire Size		Insulation Crimp Height (Max)		Insulation Crimp Width (Max)	
	AWG	mm^2	mm	In.	mm	In.
46626	22	0.35	1.65-1.75	.065-.069	2.00	.079
	24	0.20	1.60-1.75	.063-.069	2.00	.079

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 63904-7600				
Item	**Order No.**	**Engineering No.**	**Description**	**Quantity**
Perishable Tooling				
	63904-7670	63904-7670	Tool Kit (All "Y" Items)	REF
1	63444-1413	63444-1413	Conductor Punch	1 Y
2	63445-1435	63445-1435	Conductor Anvil	1 Y
3	63446-1913	63446-1913	Insulation Punch	1 Y
4	63445-1924	63445-1924	Insulation Anvil	1 Y
5	63443-0002	63443-0002	Front 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	11-40-4039	8302-5	Plunger Striker	1
11	63443-0009	63443-0009	Front Scrap Chute	1
12	63443-0024	63443-0024	Key	1
13	63443-0093	63443-0093	Hold Down Shank	1
14	63443-2211	63443-2211	Coarse Spacer	1
15	63443-6111	63443-6111	Rear Cover	1
16	63700-0992	63700-0992	Compression Spring	1
17	63443-7315	63443-7315	Terminal Hold Down Plunger	1
18	63443-7316	63443-7316	Terminal Hold Down Retainer	1
19	63443-7317	63443-7317	Terminal Hold Down Retainer Plate	1
20	200213-0900	200213-0900	Terminal Hold Down	1
Frame				
21	63800-4901	63800-4901	Top	1
22	63801-3281	63801-3281	Base	1
23	63801-4650	63801-4650	Track	1
Hardware				
24	—	—	M3 by 6 Long SHCS	3*
25	—	—	M3 by 6 Long FHCS	1*
26	—	—	M4 by 6 Long SHCS	1*
27	—	—	M4 by 12 Long BHCS	2*
28	—	—	M4 by 50 Long SHCS	2*
29	—	—	#10-32 by 3/8"Long Flat Point SSS	1*
30	—	—	#10-32 Hex Jam Nut	1*
* Available from an industrial supply company.				

ASSEMBLY DRAWING

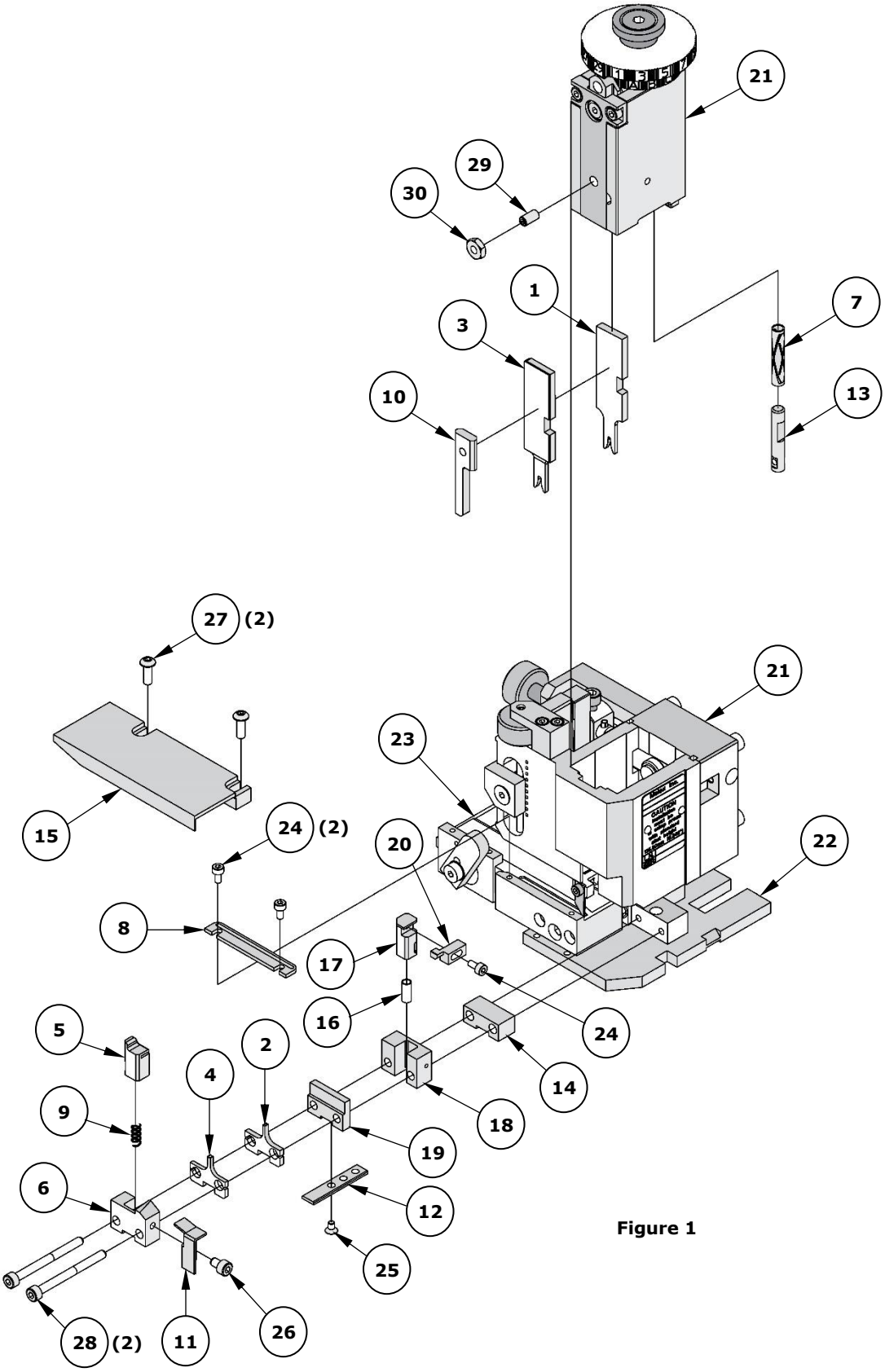


Figure 1

NOTES

1. Molex recommends that an extra perishable tooling kit be maintained at your facility.
2. Verify tooling alignment by hand 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 the work area.
4. Wear safety glasses at all times.
5. For recommended maintenance, refer to the FineAdjust manual.

WARNINGS

CAUTION: This applicator must be installed in a press with a standard shut height of 135.80mm (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 tooling crimp specifications are valid only when used with Molex terminals and tooling manufactured by Molex and sold by Molex or authorized distributors (“Molex Tooling”). When using tooling other than Molex Tooling with Molex-specific connector systems listed in our ATS documents, the Molex Tooling qualification does not apply, and the responsibility for full qualification of the connector system is that of the customer. Molex accepts no liability for connector performance or tooling support where tooling other than Molex Tooling is used or where Molex Tooling is modified.

Application Tooling Support

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