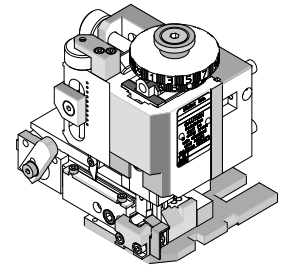


Order Number
63902-5000



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 0.015mm (.0006") for conductor crimp height and 0.063mm (.0025") for insulation height
- Independent adjustment rings allow users to quickly adjust the conductor or insulation crimp height without affecting each other
- This tool is IPC/WHMA-A-620 Class 2 compliant, as indicated below

SCOPE

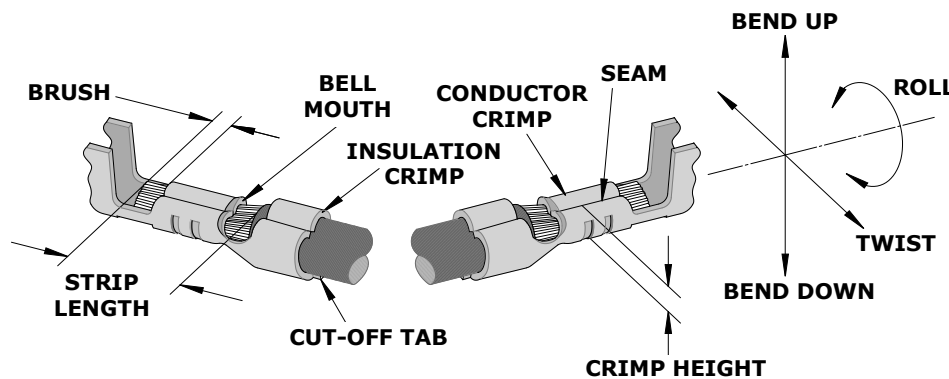
Products: 1.50mm (.059") Pitch CLIK-Mate Wire-to-Board Crimp Terminals, 24-28 AWG.

Terminal Series No.	Terminal Order No.	Wire Size		Insulation Diameter				Strip Length	
				IPC/WHMA-A-620 (1)		Terminal (2)			
		AWG	Stranding	mm	In.	mm	In.	mm	In.
502579	502579-0000 502579-1000	24-28	7 strands	0.90-1.20	.035-.047	0.78-1.28	.031-.050	1.50-1.90	.059-.075
213028	213028-1000 213028-3000 213028-7000	24-26	7 strands	0.90-1.20	.035-.047	0.78-1.28	.031-.050		

(1) To achieve optimum IPC/WHMA-A-620 insulation crimps, use this insulation OD range.
(2) Overall insulation OD specification for terminal.

CAUTION: Lubrication must be used to prevent gold-plated terminals from sticking in the conductor punch. Use 63801-7240 oiler or equivalent.

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.
502579 213028	0.10-0.40	.004-.016	0.10	.004	0.10-0.60	.004-.024

Terminal Series No.	Bend Up	Bend Down	Twist	Roll	Punch Width (Ref)				Seam
					Conductor		Insulation		
	Degree (Max)		Degree (Max)		mm	In.	mm	In.	
502579 213028	3	3	3	8	1.00	.039	1.10	.043	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				Pull Force Minimum	
		Crimp Height		Crimp Width (Ref)		N	Lb.
	AWG	mm	In.	mm	In.		
502579	24	0.60-0.65	.024-.026	1.00	.039	29.4	6.61
	26	0.59-0.64	.023-.025	1.00	.039	19.6	4.41
	†28	0.56-0.61	.022-.024	1.00	.039	9.8	2.20
213028	24	0.60-0.65	.024-.026	1.00	.039	29.4	6.61
	26	0.59-0.64	.023-.025	1.00	.039	19.6	4.41

† **Note:** To achieve optimum pull force, a conductor crimp height of 0.54-0.59mm is recommended for 28 AWG wire. This will allow a minimum Cpk value of 1.67. This lower crimp height range produces a mechanically sound crimp. However, electrical performance may vary.

Terminal Series No.	Wire Size	Insulation			
		Crimp Height (Max)		Crimp Width (Ref)	
	AWG	mm	In.	mm	In.
502579	24	1.65	.065	1.10	.043
	26	1.55	.061	1.10	.043
	28	1.45	.057	1.10	.043
213028	24	1.65	.065	1.10	.043
	26	1.55	.061	1.10	.043

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.

NOTES

1. Molex recommends that 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 the 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.

PARTS LIST

FineAdjust Applicator 63902-5000				
Item	Order No.	Engineering No.	Description	Quantity
Perishable Tooling				
	63902-5070	63902-5070	Tool Kit (All "Y" Items)	REF
1	63444-1007	63444-1007	Conductor Punch	1 Y
2	63445-1009	63445-1009	Conductor Anvil	1 Y
3	63446-1107	63446-1107	Insulation Punch	1 Y
4	63445-1106	63445-1106	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	63443-1720	63443-1720	Height Spacer	1
13	63443-2201	63443-2201	Coarse Spacer (1.00mm)	1
14	63443-2216	63443-2216	Coarse Spacer (16.00mm)	1
15	63443-2304	63443-2304	Fine Spacer (3.20mm)	1
16	63443-2805	63443-2805	Front Plunger Striker	1
17	63443-2904	63443-2904	Wire Hold Down Plunger	1
18	63443-6111	63443-6111	Rear Cover	1
19	63600-0021	63600-0021	Wire Hold Down Spring	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	—	—	M3 by 6 Long SHCS	2*
24	—	—	M3 by 6 Long FHCS	1*
25	—	—	M4 by 6 Long SHCS	2*
26	—	—	M4 by 12 Long BHCS	2*
27	—	—	M4 by 50 Long SHCS	2*
28	—	—	M5 by 12 Long SHCS	1*
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

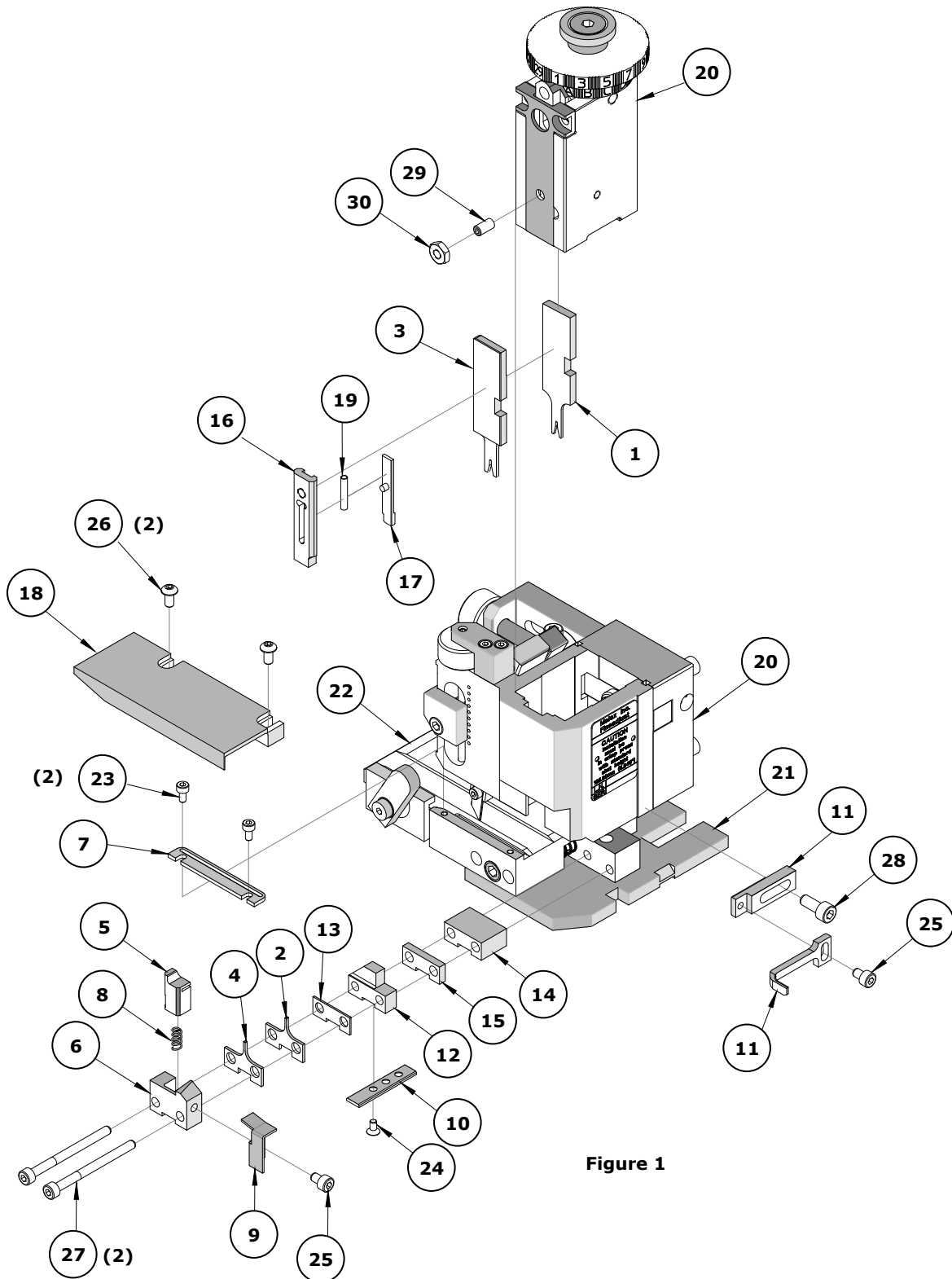


Figure 1

Application Tooling Support

Phone: (402) 458-TOOL (8665)

E-Mail: applicationtooling@molex.com

Website: www.molex.com/applicationtooling

Molex is a registered trademark of Molex, LLC in the United States of America and may be registered in other countries; all other trademarks listed herein belong to their respective owners.

X-ON Electronics

Largest Supplier of Electrical and Electronic Components

Click to view similar products for [Bench Top Tools](#) category:

Click to view products by [Molex](#) manufacturer:

Other Similar products are found below :

[6-1372442-6](#) [63801-4462](#) [63801-4561](#) [63801-7269](#) [679527-1](#) [691667-1](#) [7-21000-9](#) [768539-1](#) [854130-1](#) [854946-2](#) [856203-1](#) [904449-1](#) [9-22280-9](#) [986096-2](#) [992438-3](#) [1-21000-3](#) [1-21000-1](#) [1-25022-4](#) [1302263353](#) [1302263355](#) [1302261057](#) [1302261101](#) [1302261206](#) [1302261560](#) [1302263123](#) [1302264036](#) [1424264-1](#) [1424267-1](#) [1428211-1](#) [1428287-1](#) [1-455755-6](#) [1752744-1](#) [18023-9](#) [189763-1](#) [1901726-1](#) [2079747-1](#) [21001-2](#) [2119083-1](#) [2119085-1](#) [2119371-1](#) [2161930-1](#) [2217088-2](#) [2217347-1](#) [22281-9](#) [22374-7](#) [284565-000](#) [F1 Handle Spring](#) [19228-0213](#) [2030790-2](#) [2063796-1](#)