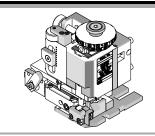




Application Tooling Specification Sheet



Order No. 63862-9000

FEATURES

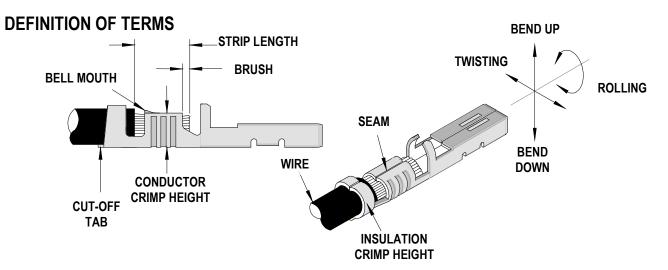
- Quick punch removal with the push of a button for fast and easy tooling change
- Applicator designed to industry standard mounting and shut height 135.80mm (5.346")
- Quick setup time; plus, the crimp height, track and feed adjustments can be set without removing the applicator from the press
- Fine adjustment allows users to achieve target with little effort by adjusting in increments of 0.15mm (.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

Products: Male and Female Crimp Terminals, 20-22AWG.

	Terminal Order No.				Insulation Di				
Terminal Series No.			Wire Size	IPC/WHM	A-A620 (1)	Terminal (2) Maximum		Strip Length	
			AWG	mm	ln.	mm	ln.	mm	ln.
35745	35745-0110		20-22	2.40-2.55	.094100	2.60	.102	4.00-4.80	.157189
35746	35746-0110	35746-0111	20-22	2.40-2.55	.094100	2.60	.102	4.00-4.80	.157189
35747	35747-0110		20-22	2.40-2.55	.094100	2.60	.102	4.00-4.80	.157189
35748	35748-0110	35748-0111	20-22	2.40-2.55	.094100	2.60	.102	4.00-4.80	.157189

- (1) To achieve optimum IPC-A620 insulation crimps, use this insulation OD range.
- (2) Overall insulation OD specification for terminal.



The above terminal drawing is a generic terminal representation. It is not an image of a terminal listed in the scope.

UNCONTROLLED COPY Doc No: ATS-638629000 Release Date: 10-27-99 Page 1 of 5 Revision Date: 04-25-17

Revision: D

CRIMP SPECIFICATION

Terminal Series No.	Bell Mouth		Cut-Off Tal	Maximum	Conductor Brush		
Terminal Series No.	mm	ln.	mm	ln.	mm	ln.	
35745	0.30-0.80	.012031	0.50	.020	0.30-1.20	.012047	
35746	0.30-0.80	.012031	0.50	.020	0.30-1.20	.012047	
35747	0.30-0.80	.012031	0.50	.020	0.30-1.20	.012047	
35748	0.30-0.80	.012031	0.50	.020	0.30-1.20	.012047	

	Bend Up	Bend Down	Twist	Roll	Punch Width (Ref)			ef)	
Terminal Series No.	Della Op	Bella Dowli			Conductor		Insulation		Seam
	Degree		Degree		mm	ln.	mm	ln.	
35745	3	3	3	5	1.80	.070	3.00	.118	Coom aball not be onen
35746	3	3	3	5	1.80	.070	3.00	.118	Seam shall not be open and no wire allowed out
35747	3	3	3	5	1.80	.070	3.00	.118	of the crimping area
35748	3	3	3	5	1.80	.070	3.00	.118	or the chiliphing area

After crimping, the conductor profile should measure the following:

Terminal	Wire Size		Pull Force				
Series No.	Wile Size	Crimp	Height	Crimp	Minimum		
Series No.	AWG	mm	ln.	mm	ln.	N	Lb.
25745	20	1.08-1.18	.043046	1.70-1.90	.067070	58.8	13.2
35745	22	1.00-1.10	.039043	1.70-1.90	.067070	39.2	8.8
35746	20	1.08-1.18	.043046	1.70-1.90	.067070	58.8	13.2
33740	22	1.00-1.10	.039043	1.70-1.90	.067070	39.2	8.8
35747	20	1.08-1.18	.043046	1.70-1.90	.067070	58.8	13.2
	22	1.00-1.10	.039043	1.70-1.90	.067070	39.2	8.8
35748	20	1.08-1.18	.043046	1.70-1.90	.067070	58.8	13.2
	22	1.00-1.10	.039043	1.70-1.90	.067070	39.2	8.8

Terminal	Wire Size	Insulation						
Series No.	Wile Size	Crimp	Height	Crimp Width				
Series No.	AWG	mm In.		mm	ln.			
35745	20	2.95-3.15	.116124	3.00-3.20	.118126			
33743	22	2.75-2.95	.108116	3.00-3.20	.118126			
35746	20	2.95-3.15	.116124	3.00-3.20	.118126			
33740	22	2.75-2.95	.108116	3.00-3.20	.118126			
35747	20	2.95-3.15	.116124	3.00-3.20	.118126			
33141	22	2.75-2.95	.108116	3.00-3.20	.118126			
35748	20	2.95-3.15	.116124	3.00-3.20	.118126			
33740	22	2.75-2.95	.108116	3.00-3.20	.118126			

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.
- 3. Oiler (63801-7240) required to crimp terminals to improve tooling life and also to minimize the crimp extrusions. See 63800-4900 FineAdjust manual.

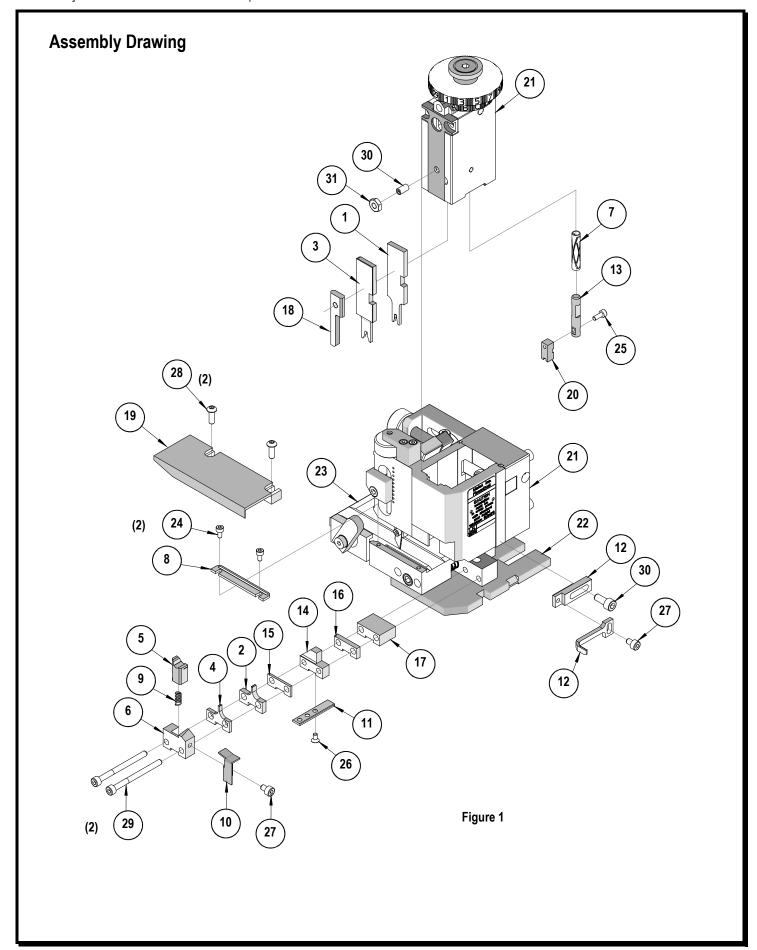
Doc No: ATS-638629000 Release Date: 10-27-99 **UNCONTROLLED COPY** Page 2 of 5 Revision: D Revision Date: 04-25-17

PARTS LIST

FineAdjust Applicator 63862-9000									
Item	Order No. Engineering No. Description								
Perishable Tooling									
	63862-9070	63862-9070	Tool Kit (All "Y" Items)	REF					
1	63444-1836	63444-1836	Conductor Punch	1 Y					
2	63455-1803	63455-1803	Conductor Anvil	1 Y					
3	63446-3028	63446-3028	Insulation Punch	1 Y					
4	63456-0069	63456-0069	Insulation Anvil	1 Y					
5	63443-0005	63443-0005	Cut-Off Plunger	1 Y					
6	63443-0012	63443-0012	Front Plunger Retainer	1 Y					
			Components						
7	11-17-0022	1739-21	Terminal Hold Down Spring	1					
8	11-18-4083	60707-8	Front Cover	1					
9	11-24-1067	4996-4	Cut-off Plunger Spring	1					
10	63443-0009	63443-0009	Scrap Chute Front	1					
11	63443-0024	63443-0024	Lower Tooling Key	1					
12	63443-0090	63443-0090	Wire Stop	1					
13	63443-0093	63443-0093	Terminal Hold Down Shank	1					
14	63443-1719	63443-1719	Height Spacer (18.90mm)	1					
15	63443-2202	63443-2202	Spacer (2.00mm)	1					
16	63443-2316	63443-2316	Coarse Spacer (3.80mm)	1					
17	63443-2212	63443-2212	Spacer (12.00mm)	1					
18	63443-3160	63443-3160	Front Plunger Striker	1					
19	63443-6119	63443-6119	Rear Cover	1					
20	63443-7131	63443-7131	Terminal Hold Down	1					
			Frame						
21	63800-4901	63800-4901	Тор	1					
22	63801-3281	63801-3281	Base	1					
23	63801-4650	63801-4650	Track	1					
		ŀ	lardware	L					
24	N/A	N/A	M3 by 6 Long SHCS	2**					
25	N/A	N/A	M3 by 6 Long FHCS	1**					
26	N/A	N/A	M3 by 8 Long SHCS	1**					
27	N/A	N/A	M4 by 6 Long SHCS	2**					
28	N/A	N/A	M4 by 12 Long BHCS	2**					
29	N/A	N/A	M4 by 50 Long SHCS	2**					
30	N/A	N/A	M5 by 12 Long SHCS	1**					
31	N/A	N/A	#10-32 by 3/8" Long Flat Point SSS	1**					
32	N/A	N/A	#10-32 Hex Jam Nut	1**					
*	** Available from an industrial supply company such as MSC (1-800-645-7270).								

Doc No: ATS-638629000 Release Date: 10-27-99 **UNCONTROLLED COPY** Page 3 of 5

Revision: D Revision Date: 04-25-17



Doc No: ATS-638629000 Revision: D Release Date: 10-27-99 Revision Date: 04-25-17

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 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 wireprocessing 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.

Application Tooling Support

Phone: +1-402-458-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.

UNCONTROLLED COPY Doc No: ATS-638629000 Release Date: 10-27-99 Page 5 of 5 Revision Date: 04-25-17

Revision: D