FineAdjust Applicator	**molex®** **Application Tooling Specification Sheet**	
		Order No. 63903-3100
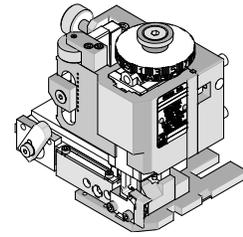
FEATURES THIS APPLICATOR IS FOR AUTOMATIC WIRE PROCESSOR USE ONLY.

- 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
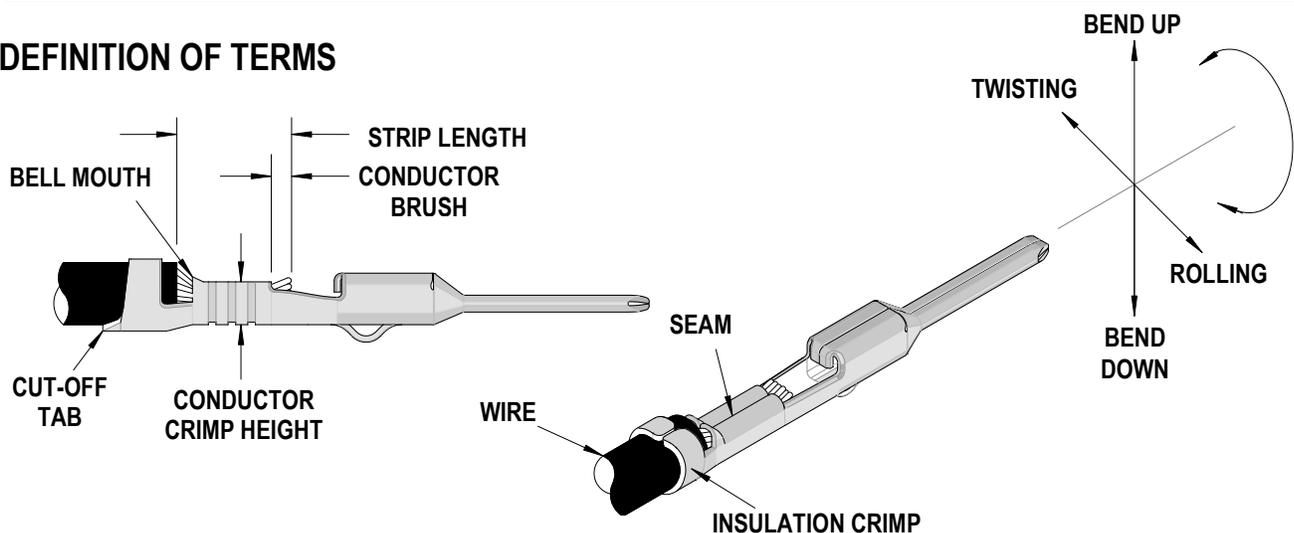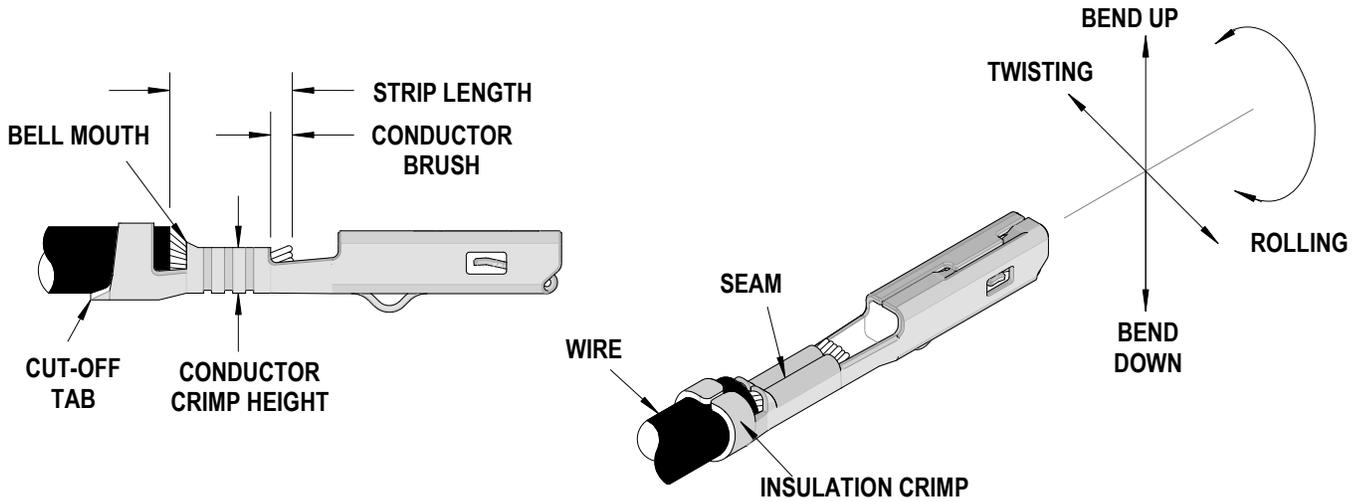- Directly adapts to most automatic wire processing machines

SCOPE
Products: SRC Male and Female Terminals for 2.50mm² FLRY-B and FLRYW-B wire.

Terminal Series No	Terminal Order No.		Wire Size		Insulation Diameter (2)		Strip Length	
			Wire Type	mm²	mm	In.	mm	In.
93642	93642-0001	Male (Tin)	FLRY-B FLRYW-B	2.50	2.70-3.00	.106-.118	4.70-5.00	.185-.197
	93642-1001	Male (Silver)						
	93642-2001	Male (Gold)						
93643	93643-0001	Female (Tin)	FLRY-B FLRYW-B	2.50	2.70-3.00	.106-.118	4.70-5.00	.185-.197
	93643-1001	Female (Silver)						
	93643-2001	Female (Gold)						

(1) Oiler (63801-7240) required to crimp all terminals. See 63800-4900 FineAdjust Manual. See *Tool Qualification Notes* on page 2.
(2) Using a wire Insulation diameter greater than 2.85mm will result with some skiving and scoring on the insulation crimp.

DEFINITION OF TERMS

BELL MOUTH
STRIP LENGTH
CONDUCTOR BRUSH
CUT-OFF TAB
CONDUCTOR CRIMP HEIGHT
WIRE
SEAM
INSULATION CRIMP
BEND UP
TWISTING
ROLLING
BEND DOWN

CRIMP SPECIFICATION

Terminal Series No.	Bell mouth		Cut-off Tab Max.		✳ Conductor Brush Max.	
	mm	In.	mm	In.	mm	In.
93642	0.30-0.70	.012-.028	0.40	.016	0.40	.016
93643	0.30-0.70	.012-.028	0.40	.016	0.40	.016

✳**THIS APPLICATOR IS INTENDED FOR AUTOMATIC WIRE PROCESSOR USE ONLY.**
It is very important that the brush length is consistently within specification for this sealed connector system to work properly.
This applicator should only be run in a properly setup automatic wire processor in order to consistently achieve the brush length.
Any attempt to use this applicator outside a properly setup automatic wire processor will likely not meet the brush specification and cause this sealed connector system to not work properly.

Terminal Series No.	Bend up	Bend down	Twist	Roll	Punch Width mm (Ref)				Seam Seam shall not be open and no wire allowed out of the crimping area
	Degree Max.		Degree Max.		Conductor		Insulation		
					mm	In.	mm	In.	
93642	3	3	3	3	2.50	.098	3.10	.122	
93643	3	3	3	3	2.50	.098	3.10	.122	

After crimping, the crimp profiles should measure the following:

| Terminal Series No.	Wire Size		Conductor				Insulation				Pull Force Minimum	
			Crimp Height		Crimp Width (Ref)		Crimp Height (Max.)		Crimp Width (Max.)			
	Wire Type	mm²	mm	In.	mm	In.	mm	In.	mm	In.	N	Lb.
93642	FLRY-B FLRYW-B	2.50	1.80-1.90	.071-.075	2.60	.102	3.20	.126	3.30	.130	210	47.3
93643	FLRY-B FLRYW-B	2.50	1.80-1.90	.071-.075	2.60	.102	3.20	.126	3.30	.130	210	47.3

▪ 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. Insulation Crimp Height can be adjusted accordingly to the wire insulation OD to meet A620 requirement.
4. Oiler (63801-7240) required to crimp terminals to improve tooling life and also to minimize the crimp extrusions. See 63800-4900 FineAdjust Manual.

PARTS LIST

Item	Order No	Engineering No.	Description	Quantity
FineAdjust Applicator 63903-3100				
Perishable Tooling				
	63903-3170	63903-3170	Tool Kit (All "Y" Items)	REF
1	63457-0111	63457-0111	Conductor Punch	1 Y
2	63455-0138	63455-0138	Conductor Anvil	1 Y
3	63454-0168	63454-0168	Insulation Punch-Full R	1 Y
4	63456-0117	63456-0117	Insulation Anvil	1 Y
5	63443-0030	63443-0030	Front Cut-Off Plunger	1 Y
6	63443-0038	63443-0038	Front Plunger Retainer	1 Y
Other Components				
7	11-17-0022	1739-21	Hold Down Spring	1
8	11-18-4094	60709A111	Feed Guide	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	63443-0093	63443-0093	Shank	1
13	63443-1720	63443-1720	19.00mm Height Spacer	1
14	63443-2201	63443-2201	1.00mm Coarse Spacer	1
15	63443-2212	63443-2212	12.00mm Coarse Spacer	1
16	63443-2314	63443-2314	3.70mm Fine Spacer	1
17	63443-2802	63443-2802	Front Plunger Striker	1
18	63443-2915	63443-2915	Wire Hold-Down Plunger	1
19	63443-6121	63443-6121	Rear Cover	1
20	63443-7127	63443-7127	Terminal Hold Down	1
21	63600-1057	63600-1057	Wire Hold-Down Spring	1
22	63700-0539	63700-0539	Cut-Off Plunger Spring	1
Frame				
23	63800-4901	63800-4901	Top	1
24	63801-3281	63801-3281	Base	1
25	63801-4650	63801-4650	Track	1
25A	63459-0001	63459-0001	Terminal Track With Relief Groove	1
Hardware				
26	N/A	N/A	M3 by 6 Long SHCS	2**
27	N/A	N/A	M3 by 6 Long FHCS	1**
28	N/A	N/A	M3 by 8 Long SHCS	1**
29	N/A	N/A	M4 by 6 Long SHCS	2**
30	N/A	N/A	M4 by 12 Long BHCS	2**
31	N/A	N/A	M4 by 50 Long SHCS	2**
32	N/A	N/A	M5 by 12 Long SHCS	1**
33	N/A	N/A	#10-32 by 3/8"Long Flat Point SSS	1**
34	N/A	N/A	#10-32 Hex Jam Nut	1**
35	N/A	N/A	2mm by 6 Long Roll Pin	1**
** Available from an industrial supply company such as MSC (1-800-645-7270).				

Assembly Drawing

Figure 1
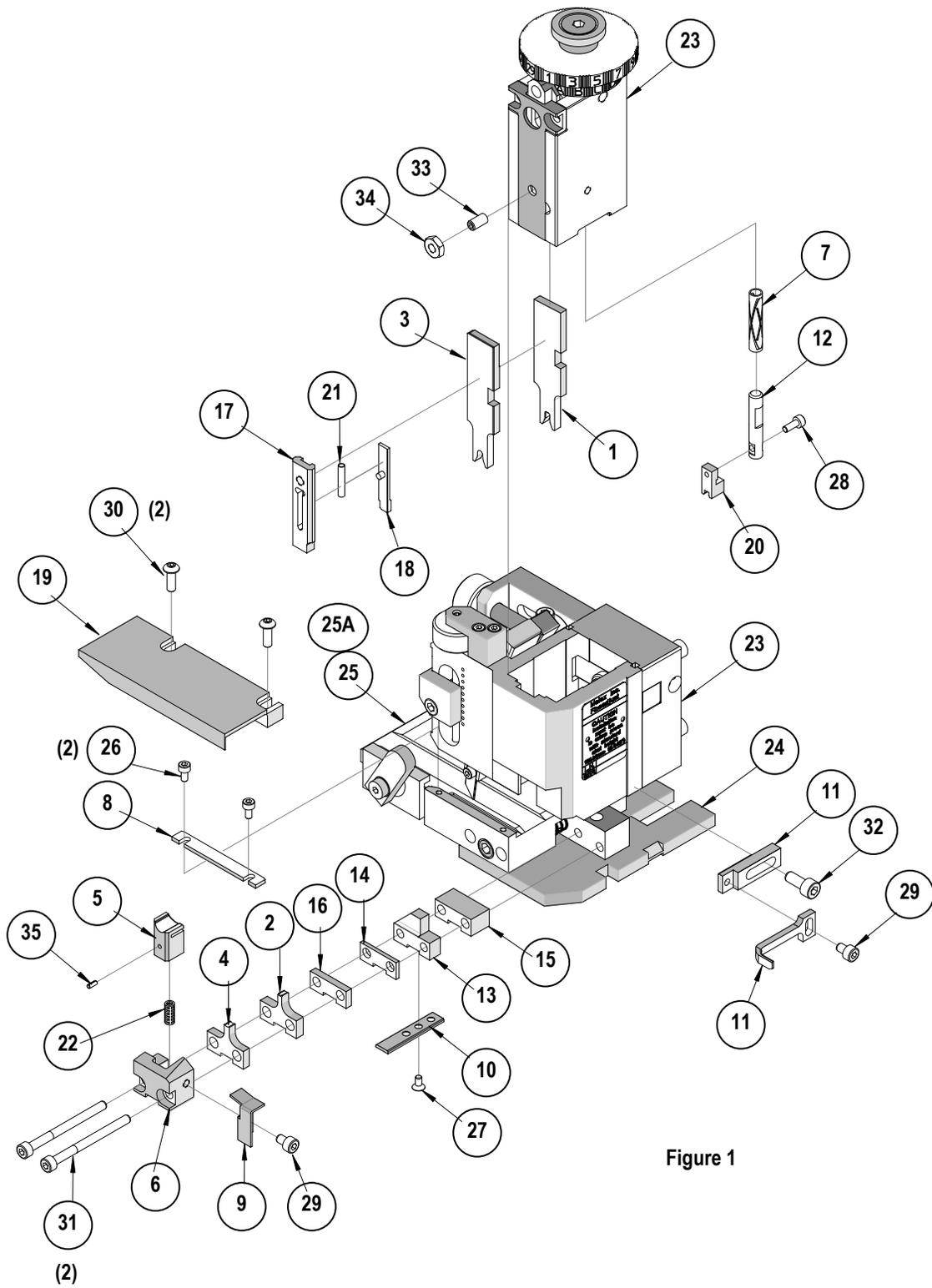
NOTES

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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