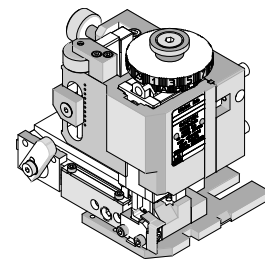


Order Number
203702-5000



Application Tooling Specification

FEATURES

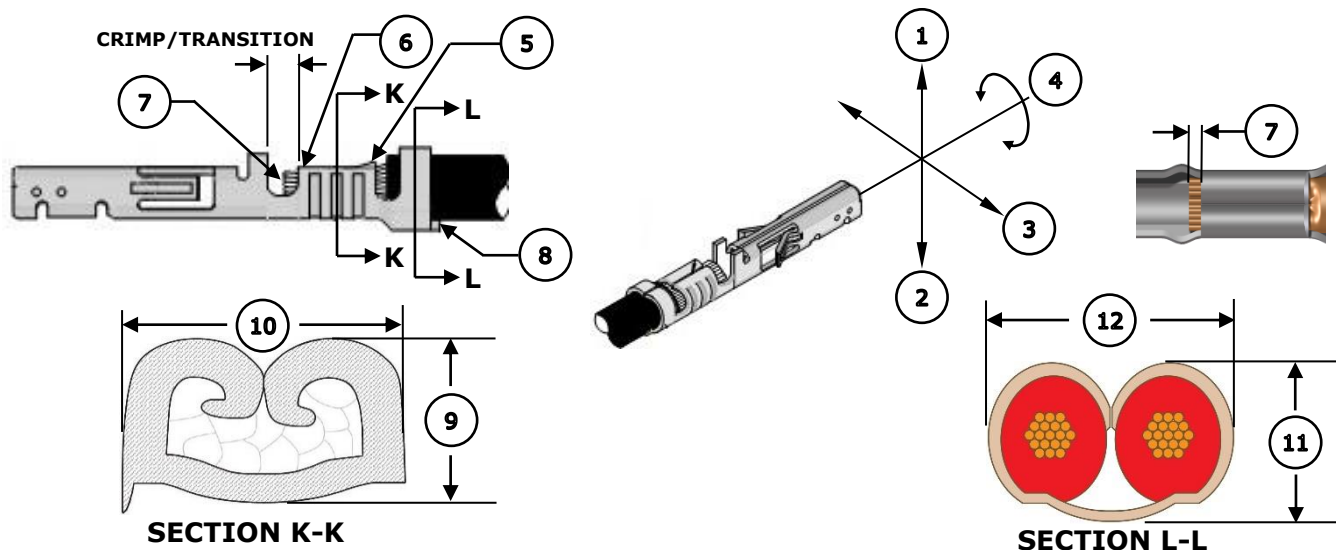
- Directly adapts to most automatic wire processing machines
- Quick punch removal with the push of a button for fast and easy tooling change
- Applicator designed to industry-standard mounting and 135.80mm (5.346”) shut height
- Quick setup plus the crimp height, track, and feed adjustments can be set 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: 12 AWG Mega-Fit Wire-to-Wire Male and Female Crimp Terminals, crimped to (2) 16 AWG Wires (UL1007 or UL1061).

Terminal Series No.	Terminal Order No.	Wire Size	Insulation Diameter		Strip Length	
		AWG	mm	In.	mm	In.
76823	76823-0343	2 x 16	1.90-2.40	.075-.094	5.00-6.00	.200-.240
105417	105417-0333					
105418	105418-0313					
	105418-1313					
172063	172063-0333					
	172063-1333					

DEFINITION OF TERMS



Note: The image above is a generic terminal representation. The actual terminals of the scope may look different.

CRIMP SPECIFICATION

Feature	Requirement					
1. Bend Up	3° Max					
2. Bend Down	3° Max					
3. Twist	4° Max					
4. Roll	8° Max					
5. Bell Mouth Rear	0.40-0.75mm (.015-.029")					
6. Bell Mouth Front	Not Applicable					
7. Conductor Brush	0.10-1.15mm (.004-.045")					
8. Cut-Off Tab	0.60mm (.024") Max					
Conductor Crimp	Terminal Order No.	Wire Size	9. Crimp Height		10. Crimp Width (Ref)	
	76823-0343 105417-0333 105418-0313 105418-1313 172063-0333 172063-1333	2x16 AWG	1.85-1.95mm	.073-.077 in.	3.25mm	.128 in.
	Terminal Order No.	Wire Size	11. Crimp Height (Ref)		12. Crimp Width (Ref)	
	76823-0343 105417-0333 105418-0313 105418-1313 172063-0333 172063-1333	2x16 AWG	3.20mm (UL1007) 2.80mm (UL1061)	.126 in (UL1007) .110 in (UL1061)	4.75mm	.187 in.
	Terminal Order No.	Wire Size	Minimum Pull Force			
76823-0343 105417-0333 105418-0313 105418-1313 172063-0333 172063-1333	2x16 AWG	89 N	20 lbs.	To be measured with no influence from the insulation crimp. Pull one wire only.		

Tool Qualification Notes

1. Pull force should be measured with no influence from the insulation crimp.
2. Pull force is based on pulling one wire, not both wires.
3. The above specifications are guidelines to an optimum crimp.
4. Wires must be arranged side-by-side for a proper insulation crimp.

PARTS LIST

FineAdjust Applicator 203702-5000				
Item	Order No.	Engineering No.	Description	Quantity
Perishable Tooling				
	203702-5070	203702-5070	Tool Kit (All "Y" Items)	REF
1	63457-3201	63457-3201	Conductor Punch	1 Y
2	63455-3231	63455-3231	Conductor Anvil	1 Y
3	200220-4701	200220-4701	Insulation Punch	1 Y
4	200221-4701	200221-4701	Insulation Anvil	1 Y
5	63443-0002	63443-0002	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	Front 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	200213-7528	200213-7528	Anvil Mount	1
15	63443-3160	63443-3160	Front Plunger Striker	1
16	63443-6123	63443-6123	Rear Cover	1
17	63443-7136	63443-7136	Terminal Hold Down	1
Frame				
18	63800-4901	63800-4901	Top	1
19	63801-3281	63801-3281	Base	1
20	63801-4650	63801-4650	Track	1
Hardware				
21	—	—	M3 by 6 Long SHCS	2*
22	—	—	M3 by 6 Long FHCS	1*
23	—	—	M3 by 8 Long SHCS	1*
24	—	—	M4 by 6 Long SHCS	2*
25	—	—	M4 by 12 Long BHCS	2*
26	—	—	M4 by 50 Long SHCS	2*
27	—	—	M5 by 12 Long SHCS	1*
28	—	—	M5 by 10 Long Flat Point SSS	1*
29	—	—	M5 Hex Jam Nut	1*

* Available from an industrial supply company.

ASSEMBLY DRAWING

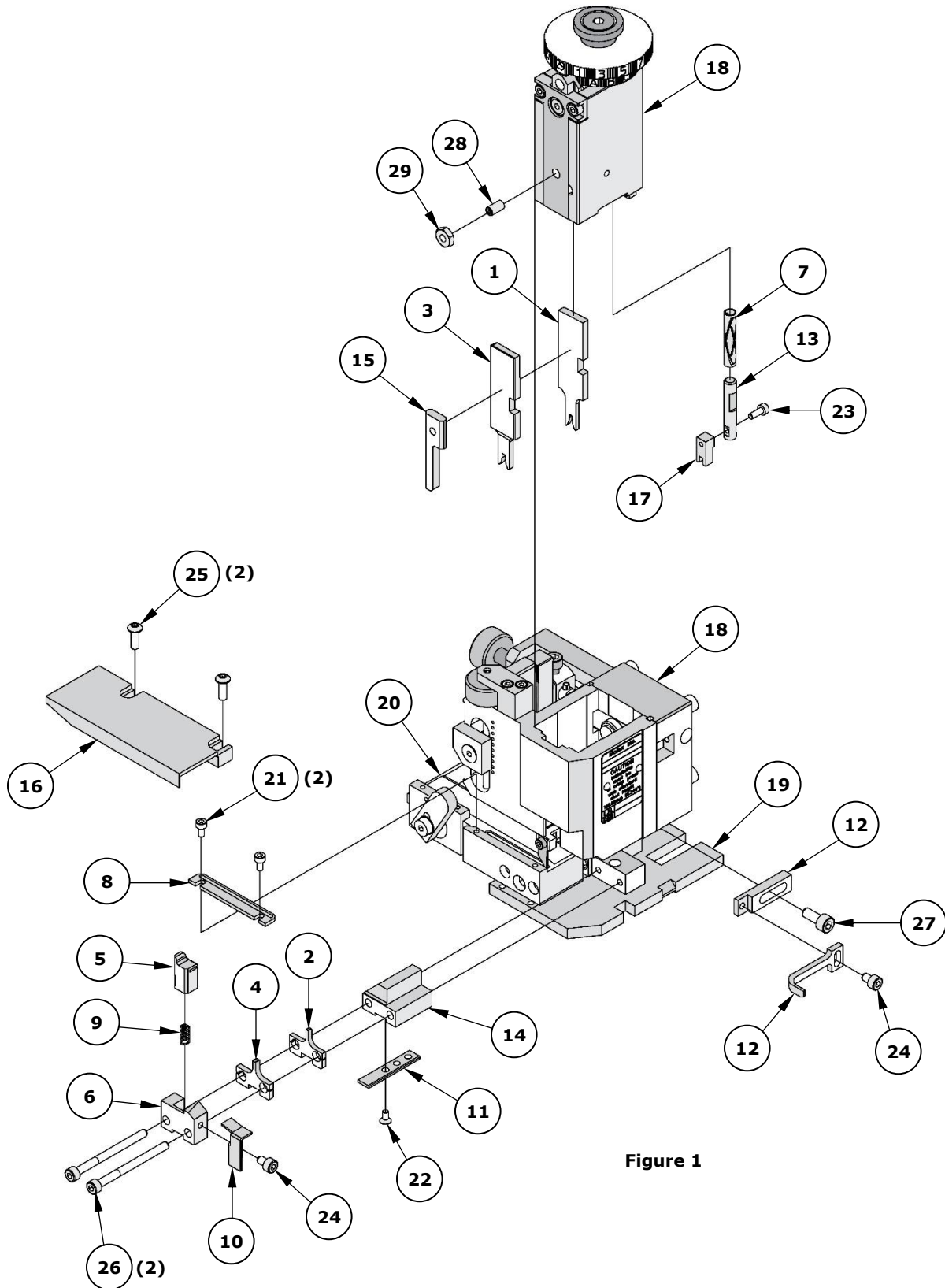


Figure 1

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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