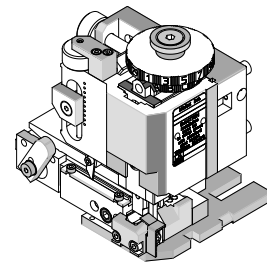


**Order Number
203702-3700**



Application Tooling Specification

FEATURES

- 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
- Directly adapts to most automatic wire processing machines

SCOPE

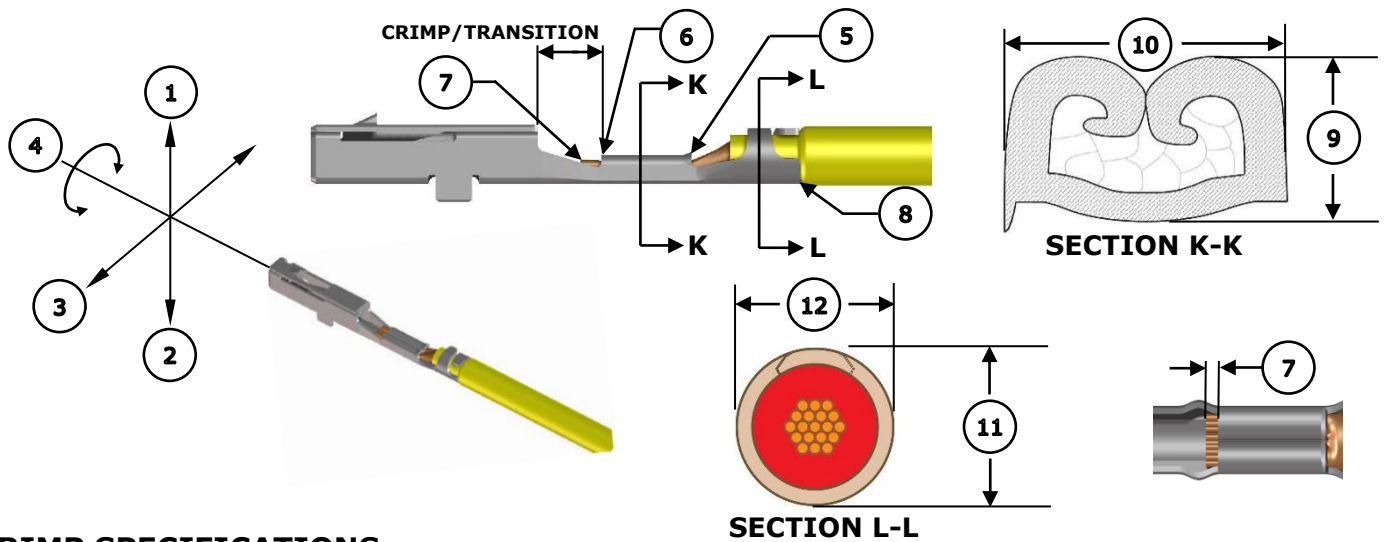
Products: Micro-Fit Plus, 20-24 AWG Wire.

| Terminal Series No. | Terminal Order No. | Wire Size AWG | Insulation Diameter | | | | Strip Length | |
|---------------------|---|------------------|---------------------|-----------|--------------|-----------|--------------|-----------|
| | | | IPC/WHMA-A-620 (1) | | Terminal (2) | | mm | In. |
| | | | mm | In. | mm | In. | | |
| 206460 | 206460-0021 206460-0022* 206460-0023* | 20-24 | 1.31-1.85 | .052-.073 | 0.90-1.85 | .035-.073 | 2.54-2.92 | .100-.115 |
| 215953 | 215953-0021 215953-0022* 215953-0023* | 20-24 | 1.31-1.85 | .052-.073 | 0.90-1.85 | .035-.073 | 2.54-2.92 | .100-.115 |

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

*Terminal oiler 63801-7240 recommended when crimping gold-plated terminals.

DEFINITION OF TERMS



CRIMP SPECIFICATIONS

| Feature | Requirement | | | | | |
|----------------------------|---------------------------|------------------|-------------------------------|---------------|---|---------------|
| 1. Bend Up | 3° Max | | | | | |
| 2. Bend Down | 3° Max | | | | | |
| 3. Twist | 4° Max | | | | | |
| 4. Roll | 8° Max | | | | | |
| 5. Bell Mouth Rear | 0.05-0.35mm (.002-.014") | | | | | |
| 6. Bell Mouth Front | Not Applicable | | | | | |
| 7. Conductor Brush | 0.80mm (.031") | | | | | |
| 8. Cut-Off Tab | 0.20mm (.008") Max | | | | | |
| Conductor Crimp | Terminal Order No. | Wire Size | 9. Crimp Height | | 10. Crimp Width (Ref) | |
| | 206460 215953 | 20 AWG | 0.91-0.99mm | .036-.039 In. | 1.40-1.50mm | .055-.059 In. |
| | | 22 AWG | 0.84-0.91mm | .033-.036 In. | 1.40-1.50mm | .055-.059 In. |
| | | 24 AWG | 0.79-0.84mm | .031-.033 In. | 1.40-1.50mm | .055-.059 In. |
| Insulation Crimp | Terminal Order No. | Wire Size | 11. Crimp Height (Ref) | | 12. Crimp Width (Ref) | |
| | 206460 215953 | 20 AWG | 2.30mm | .090 In. | 1.80-2.05mm | .071-.081 In. |
| | | 22 AWG | 2.30mm | .090 In. | 1.80-2.05mm | .071-.081 In. |
| | | 24 AWG | 2.30mm | .090 In. | 1.80-2.05mm | .071-.081 In. |
| Pull Force | Terminal Order No. | Wire Size | Minimum Pull Force | | To be measured with no influence from the insulation crimp. | |
| | 206460 215953 | 20 AWG | 71.1 N | 16.0 lb. | | |
| | | 22 AWG | 44.4 N | 10.0 lb. | | |
| | | 24 AWG | 28.5 N | 6.4 lb. | | |

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. Terminal Oiler (63801-7240) will improve tooling life and minimize crimp extrusions. See 63800-4900 FineAdjust manual.

NOTES

General 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.

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.

PARTS LIST

| FineAdjust Applicator 203702-3700 | | | | |
|---|------------------|------------------------|------------------------------|-----------------|
| Item | Order No. | Engineering No. | Description | Quantity |
| Perishable Tooling | | | | |
| | 203702-3770 | 203702-3770 | Tool Kit (All "Y" Items) | Ref |
| 1 | 63446-1902 | 63446-1902 | Insulation Punch | 1 Y |
| 2 | 63444-1421 | 63444-1421 | Conductor Punch | 1 Y |
| 3 | 63445-1905 | 63445-1905 | Insulation Anvil | 1 Y |
| 4 | 63445-1451 | 63445-1451 | Conductor Anvil | 1 Y |
| 5 | 63443-0005 | 63443-0005 | Cut-Off Plunger | 1 Y |
| 6 | 63443-0012 | 63443-0012 | Front Plunger Retainer | 1 Y |
| Non-Perishable Components | | | | |
| 7 | 63443-0024 | 63443-0024 | Key | 1 |
| 8 | 01124-1067 | 4996-4 | Cut-Off Plunger Spring | 1 |
| 9 | 63443-0009 | 63443-0009 | Front Scrap Chute | 1 |
| 10 | 63443-0090 | 63443-0090 | Wire Stop Assembly | 1 |
| 11 | 200213-7552 | 200213-7552 | Anvil Mount | 1 |
| 12 | 63443-2806 | 63443-2806 | Front Plunger Striker | 1 |
| 13 | 63443-2905 | 63443-2905 | Wire Hold Down Plunger | 1 |
| 14 | 63600-0021 | 63600-0021 | Wire Hold Down Spring | 1 |
| 15 | 01118-4083 | 60707-8 | Terminal Guide | 1 |
| 16 | 63443-7137 | 63443-7137 | Nose Hold Down | 1 |
| 17 | 63443-0093 | 63443-0093 | Nose Hold Down Shank | 1 |
| 18 | 01117-0022 | 1736-21 | Hold Down Spring | 1 |
| 19 | 63443-6113 | 63443-6113 | Rear Track Cover | 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 x 6 SHCS | 2* |
| 24 | — | — | M3 x 6 FHCS | 1* |
| 25 | — | — | M3 x 10 SHCS | 1* |
| 26 | — | — | M4 x 6 SHCS | 2* |
| 27 | — | — | M4 x 12 BHCS | 2* |
| 28 | — | — | M4 x 50 SHCS | 2* |
| 29 | — | — | M5 x 12 SHCS | 1* |
| 30 | — | — | #10-32 x 3/8" Flat Point SSS | 1* |
| 31 | — | — | #10-32 Hex Jam Nut | 1* |
| *Fastener parts can be purchased through most industrial suppliers by using the description in the table above. | | | | |

ASSEMBLY DRAWING

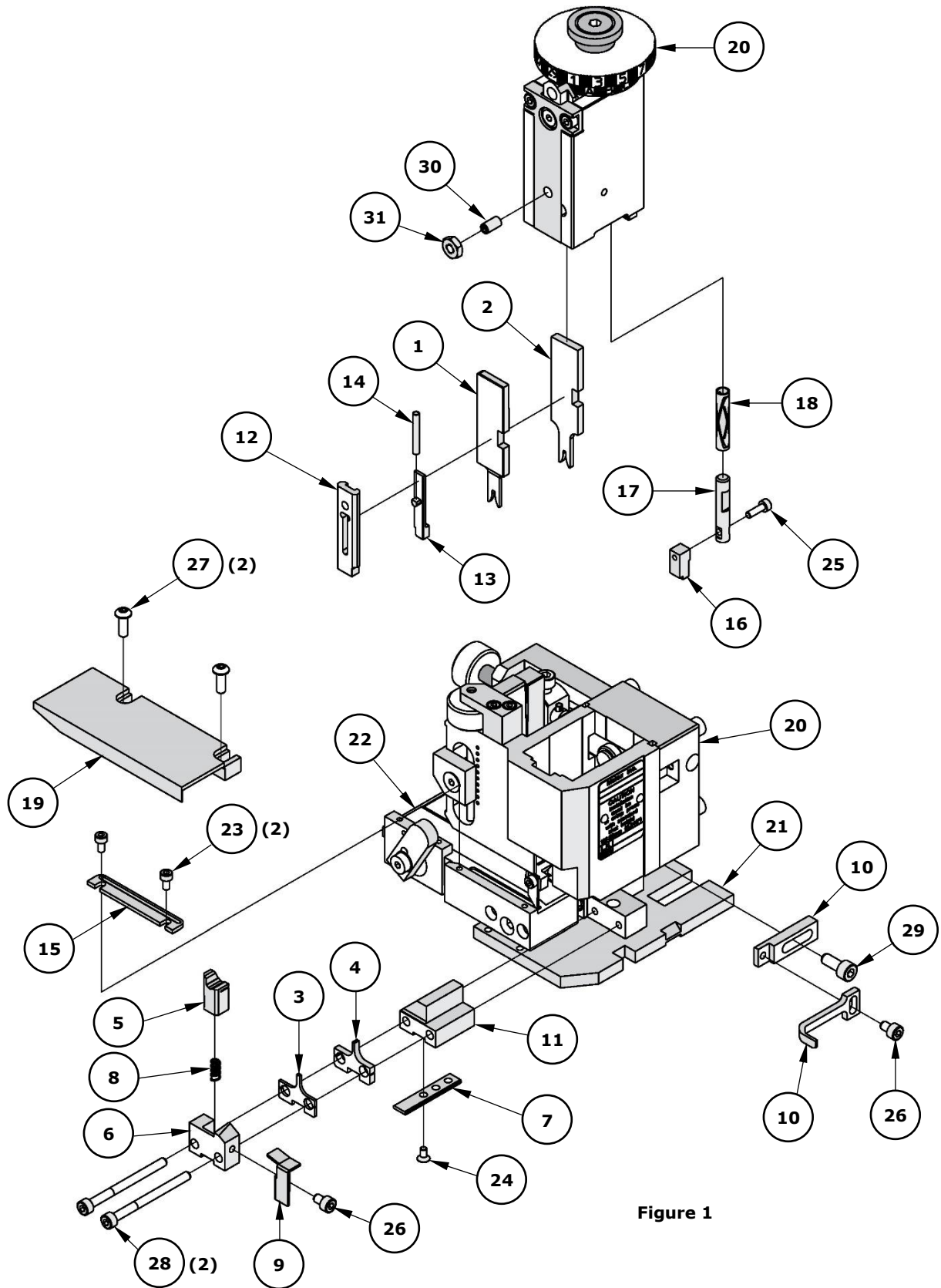


Figure 1

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.