

- 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

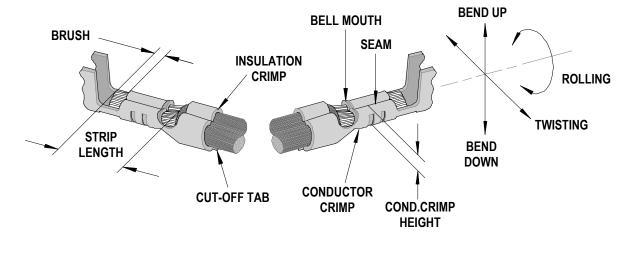
SCOPE

FEATURES

Products: 1.75mm (.069") Pitch Wire-to-Board Crimp Terminal, 24-28 AWG (0.08 and 0.20mm²).

Terminal Series No.	Terminal	Wire Size			Insulation	Strip Length			
	Order No.			IPC/WHM	A-A620+	Termir	al 🔶 🔶		
		AWG	mm²	mm	In.	mm	In.	mm	In.
	502057-1000	24-26	0.220.12	1.00-1.27	.039050	0.85-1.27	.033050	1.50-1.80	.059071
502057			0.20	1.00-1.27	.039050	0.85-1.27	.033050		
502057		28	0.079	1.00-1.27	.039050	0.85-1.27	.033050		
			0.08	1.00-1.27	.039050	0.85-1.27	.033050		
To achieve optimum IPC-A620 Class 2 insulation crimps, use this insulation OD range.									
Overall insulation OD specification for terminal.									

DEFINITION OF TERMS



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

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CRIMP SPECIFICATION

Terminal Series No.	Bell n	nouth	Cut-off Tab	o Maximum	Conductor Brush		
reminal Series NO.	mm	In.	mm	In.	mm	In.	
502057	0.10035	.004014	0.10	.004	0.10-0.50	.004020	

	Bend up Bend down		Twist	Roll	Punch Width mm (Ref)			(Ref)	Seam
Terminal Series No.	Degree		Degree		Conductor		Insulation		
					mm	In	mm	In	Seam shall not be open and
502057	3	2	3	5	1.00	.039	1.20	.047	no wire allowed out of the crimping area

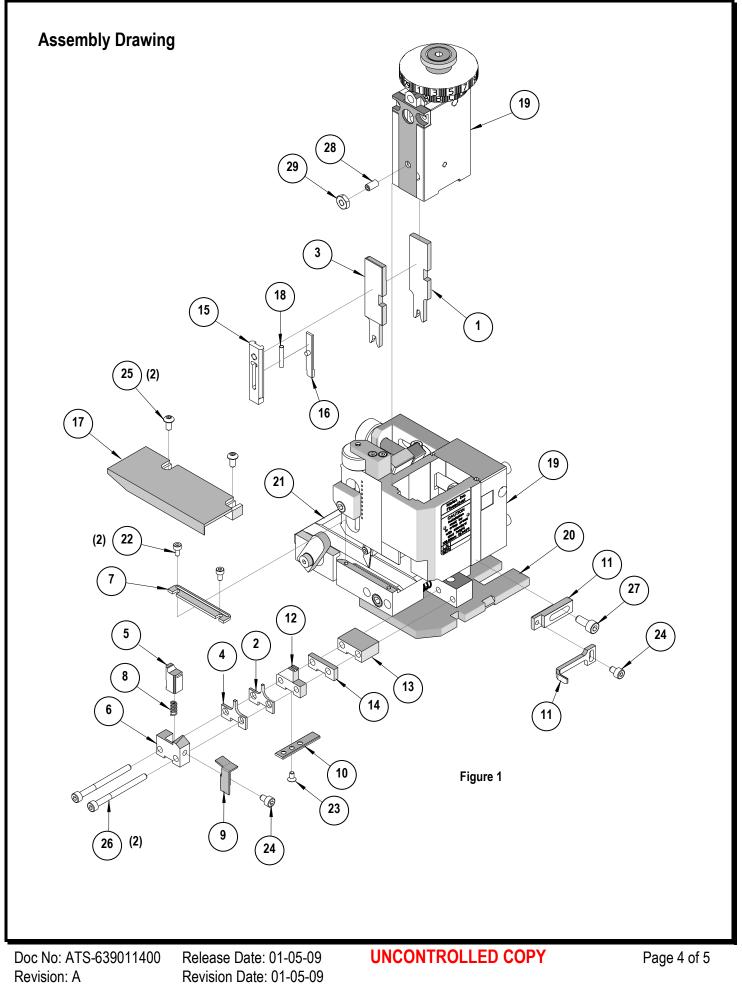
After crimping, the conductor profile should measure the following.

Terminal Series No.	Wire Size			luctor Height		ation Height	Pull Force Minimum	
	AWG	mm ²	mm	In.	mm	In.	N	Lb.
	24	0.22	0.60-0.65	.024026	1.55	.061	29.4	6.6
		0.02	0.60-0.65	.024026	1.60	.063	29.4	6.6
502057	26	0.12	0.59-0.64	.023025	1.50	.059	19.6	4.4
	28	0.079	0.56-0.61	.022024	1.40	.055	9.8	2.2
		0.08	0.56-0.61	.022024	1.40	.055	9.8	2.2

Pull Force should be measured with no influence from the insulation crimp. The above specifications are guidelines to an optimum crimp.

PARTS LIST

FineAdjust Applicator 63901-1400									
ltem	Order No								
Perishable Tooling									
	63901-1470	63901-1470	Tool Kit (All "Y" Items)	REF					
1	63444-1007	63444-1007	Conductor Punch	1 Y					
2	63445-1012	63445-1012	Conductor Anvil	1 Y					
3	63446-1217	63446-1217	Insulation Punch	1 Y					
4	63445-1235	63445-1235	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 (REF 011450)									
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	63443-1714	63443-1714	18.40mm Height Spacer	1					
13	63443-2217	63443-2217	17.00mm Coarse Spacer	1					
14	63443-2306	63443-2306	3.30mm Fine Spacer	1					
15	63443-2801	63443-2801	Front Plunger Striker	1					
16	63443-2906	63443-2906	Wire Hold Down Plunger	1					
17	63443-6110	63443-6110	Rear Cover	1					
18	63600-0021	63600-0021	Wire Hold Down Spring	1					
	•		Frame						
19	63800-4901	63800-4901	Тор	1					
20	63801-3281	63801-3281	Base	1					
21	63801-4650	63801-4650	Track	1					
		Н	ardware						
22	N/A	N/A	M3 by 6 Long SHCS	2**					
23	N/A	N/A	M3 by 6 Long FHCS	1**					
24	N/A	N/A	M4 by 6 Long SHCS	2**					
25	N/A	N/A	M4 by 12 Long BHCS	2**					
26	N/A	N/A	M4 by 50 Long SHCS	2**					
27	N/A	N/A	M5 by 12 Long SHCS	1**					
28	N/A	N/A	#10-32 by 3/8"Long Flat Point SSS	1**					
29	N/A	N/A	#10-32 Hex Jam Nut	1**					
** Available from an industrial supply company such as MSC (1-800-645-7270).									



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 135.8 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 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.

Americas Headquarters Lisle, Illinois 60532 U.S.A. 1-800-78MOLEX amerinfo@molex.com

Far East North Headquarters Yamato, Kanagawa, Japan 81-462-65-2324 feninfo@molex.com Far East South Headquarters Jurong, Singapore 65-6-268-6868 fesinfo@molex.com European Headquarters Munich, Germany 49-89-413092-0 eurinfo@molex.com **Corporate Headquarters** 2222 Wellington Ct. Lisle, IL 60532 U.S.A. 630-969-4550 Fax: 630-969-1352

Visit our Web site at http://www.molex.com

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