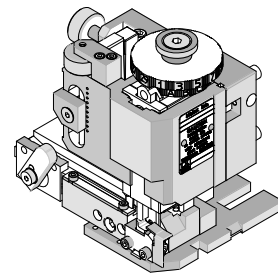


**Order Number  
203702-3100**



**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, as indicated below
- Directly adapts to most automatic wire processing machines

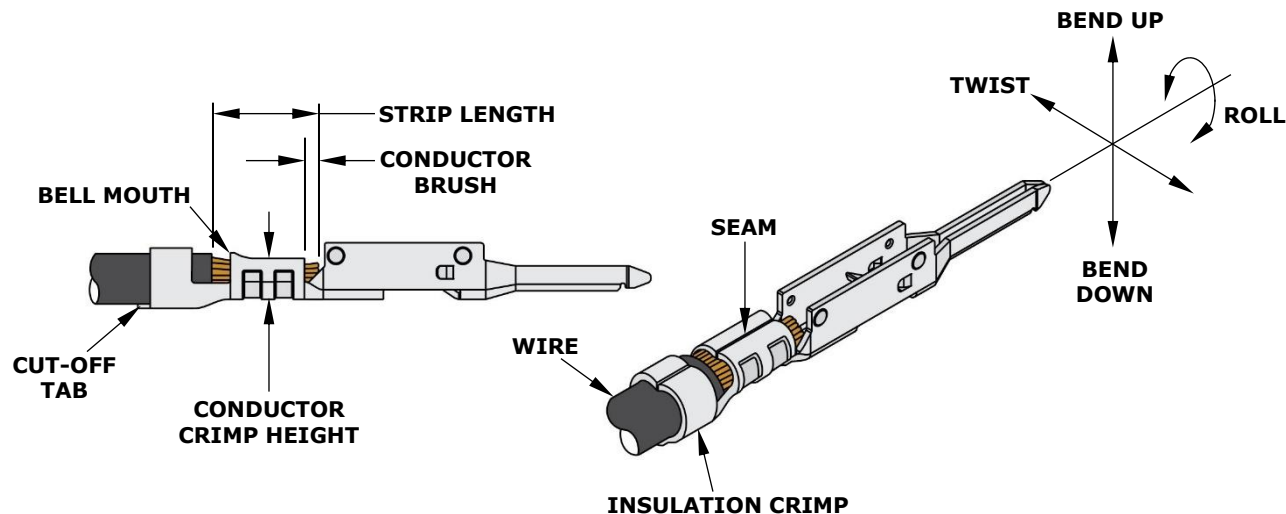
**SCOPE**

**Products:** Nano-Fit Wire-to-Wire Plug Terminals, 24-26 AWG, UL1061 Wire.

Terminal Series No.	Terminal Order No.	Wire		Insulation Diameter				Strip Length	
				IPC/WHMA-A-620 (1)		Terminal (2)			
		AWG	Type	mm	In.	mm	In.	mm	In.
201447	201447-1200 201447-1300 201447-1400 201447-1600	24	UL1061	1.00-1.20	.039-.047	1.00-1.15	.039-.045	2.50-3.50	.100-.140
	26	UL1061	1.00-1.15	.039-.045					

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

**DEFINITION OF TERMS**



**CRIMP SPECIFICATION**

Terminal Series No.	Bell Mouth		Cut-Off Tab Maximum		Conductor Brush	
	mm	In.	mm	In.	mm	In.
201447	0.15-0.30	.006-.012	0.17	.007	0.25-1.00	.010-.039

Terminal Series No.	Bend Up	Bend Down	Twist	Roll	Punch Width mm (Ref)				Seam
					Conductor		Insulation		
	Degree (Max)		Degree (Max)		mm	In.	mm	In.	
201447	3	3	4	8	1.10	.043	1.40	.055	Seam shall not be open and no wire allowed out of the crimping area

After crimping, the conductor profile should measure the following:

Terminal Series No.	Wire Size	Conductor				Pull Force Minimum	
		Crimp Height		Crimp Width (Ref)		N	Lb.
	AWG	mm	In.	mm	In.		
201447	24	0.70-0.75	.028-.030	1.20	.079	22.3	5.01
	26	0.65-0.70	.026-.028	1.20	.079	13.4	3.01

Terminal Series No.	Wire		Insulation			
	AWG	Type	Crimp Height (Ref)		Crimp Width (Ref)	
			mm	In.	mm	In.
201447	24	UL1061	1.60	.063	1.50	.059
	26	UL1061	1.50	.059	1.50	.059

**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.

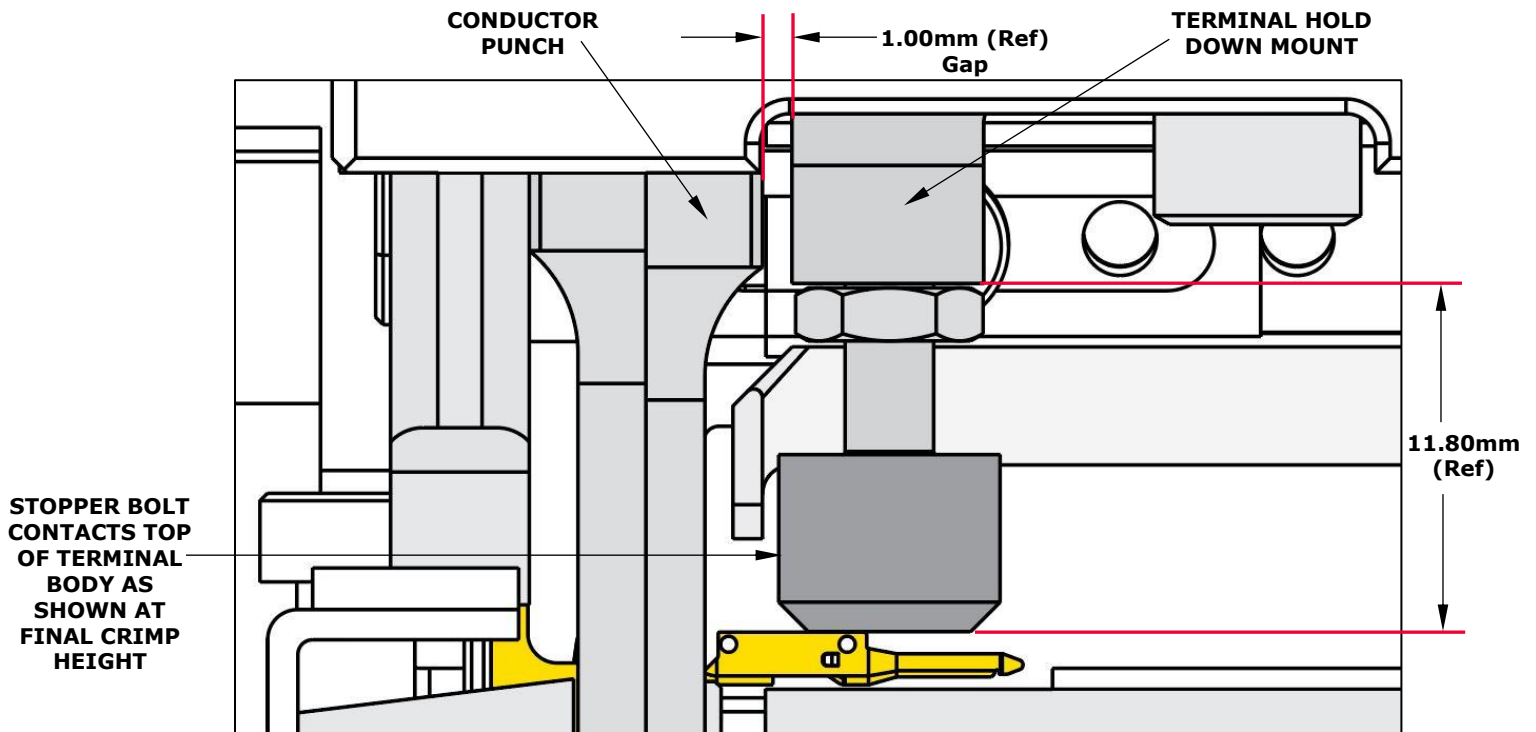
## NOTES

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.

## FACTORY SETTINGS

### Terminal Hold Down Position

This applicator ships with the following factory settings:



## 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**

<b>FineAdjust Applicator 203702-3100</b>				
<b>Item</b>	<b>Order No.</b>	<b>Engineering No.</b>	<b>Description</b>	<b>Quantity</b>
<b>Perishable Tooling</b>				
	203702-3170	203702-3170	Tool Kit (All "Y" Items)	REF
1	63457-0107	63457-0107	Conductor Punch	1 Y
2	200217-1103	200217-1103	Conductor Anvil	1 Y
3	63454-0157	63454-0157	Insulation Punch	1 Y
4	63456-0102	63456-0102	Insulation Anvil	1 Y
5	63443-0002	63443-0002	Front Cut-Off Plunger	1 Y
6	63443-0012	63443-0012	Front Plunger Retainer	1 Y
<b>Other Components</b>				
7	11-18-4083	60707-8	Feed Guide	1
8	11-24-1067	11-24-1067	Cut-Off Plunger Spring	1
9	63443-0009	63443-0009	Scrap Chute	1
10	63443-0024	63443-0024	Key	1
11	63443-0090	63443-0090	Wire Stop	1
12	200213-7513	200213-7513	Anvil Mount	1
13	63443-2801	63443-2801	Front Plunger Striker	1
14	63443-2907	63443-2907	Wire Hold-Down Plunger	1
15	63600-0021	63600-0021	Compression Spring	1
16	63443-6108	63443-6108	Rear Cover	1
17	63443-7406	63443-7406	Terminal Hold Down Mount	1
18	63600-5776	63600-5776	Stopper Bolt	1
19	63820-7820	63820-7820	Feed Cam: Special	1
<b>Frame</b>				
20	63800-4901	63800-4901	Top	1
21	63801-3281	63801-3281	Base	1
22	63801-4650	63801-4650	Track	1
<b>Hardware</b>				
23	—	—	M3 by 6 Long SHCS	2*
24	—	—	M3 by 6 Long FHCS	1*
25	—	—	M4 by 6 Long SHCS	1*
26	—	—	M4 by 10 Long SHCS	1*
27	—	—	M4 by 12 Long BHCS	2*
28	—	—	M4 by 45 Long SHCS	2*
29	—	—	M5 by 12 Long SHCS	1*
30	—	—	#10-32 by 3/8" Long Flat Point SSS	1*
31	—	—	#10-32 Hex Jam Nut	1*

\* Available from an industrial supply company.

**ASSEMBLY DRAWING**

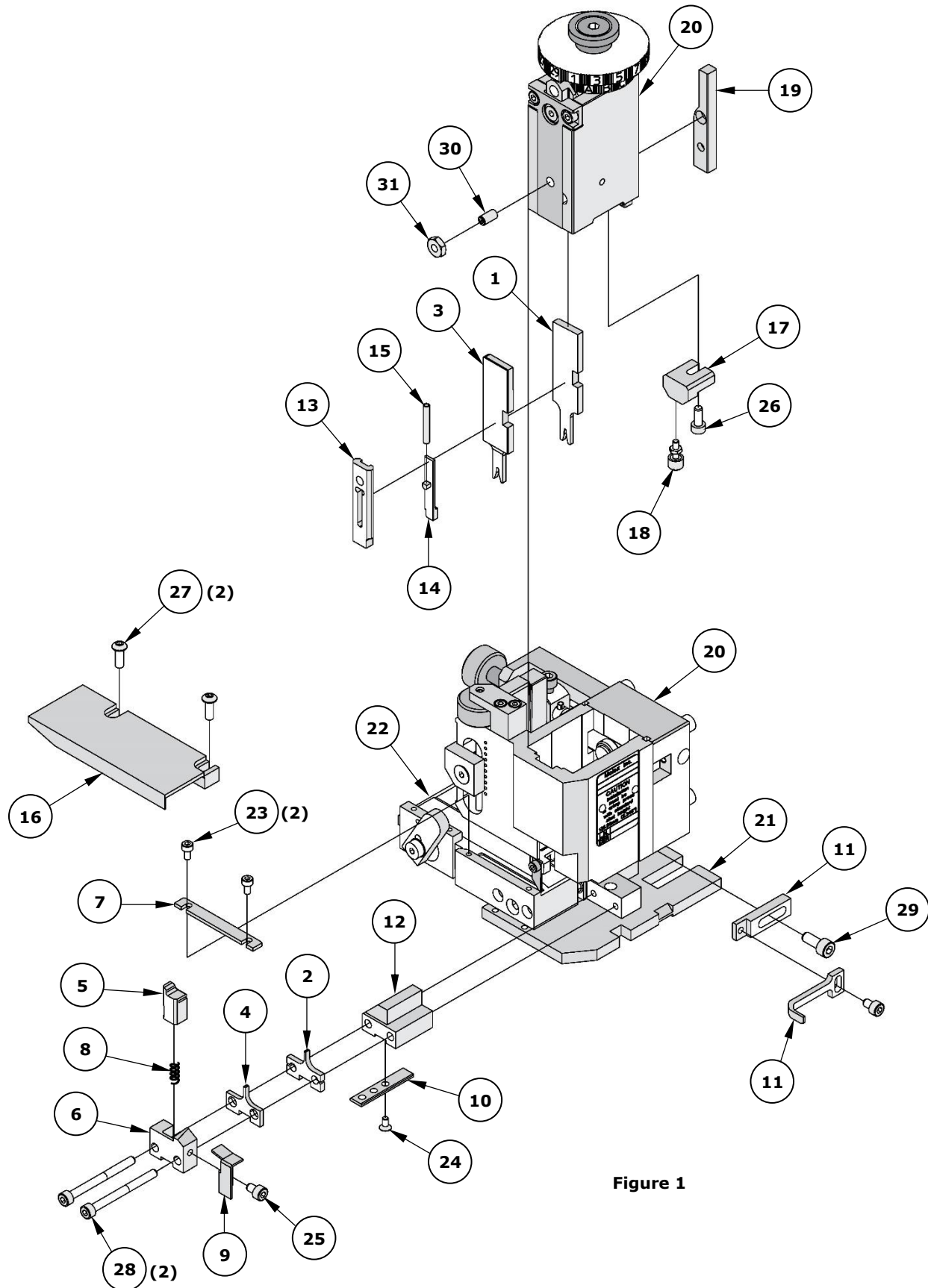


Figure 1

**Application Tooling Support**

**Phone:** (402) 458-TOOL (8665)

**E-Mail:** [applicationtooling@molex.com](mailto:applicationtooling@molex.com)

**Website:** [www.molex.com/applicationtooling](http://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.