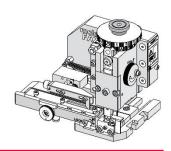
Order Number 63808-4800







FEATURES

- 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 0.025mm (.001") for insulation height
- Fine adjustment of the bend is achieved using the bend adjust dial
- 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: CTX50 Receptacle Terminal Unsealed, 0.22mm².

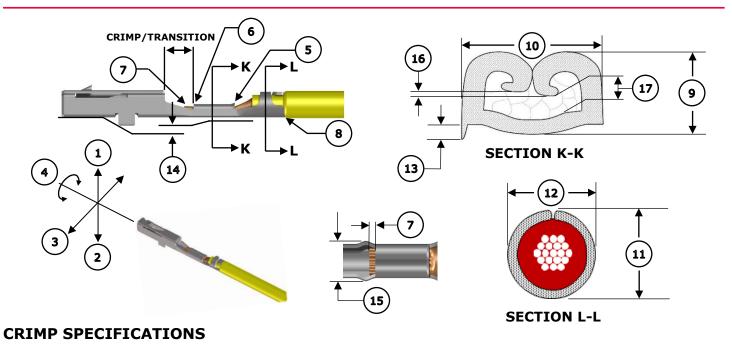
| Terminal Series No. | Terminal Order No. | Wire | | Insulation Diameter | | Strip Length (Ref) | |
|------------------------|---|-----------|---------|----------------------------|---------|--------------------|------|
| | | Wire Type | Size | mm | In. | mm | In. |
| 560023 | 560023-0421 560023-0521 560023-0621 | CHFUS | 0.22mm² | 0.95-1.20 | .037047 | 2.90 | .114 |

CAUTION: This applicator was designed for use in a wire processor only.

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Revision: D

DEFINITION OF TERMS



The following crimp specifications are based on document AS-560023-001 Rev. G:

| Feature | Requirement | | | | | | |
|---------------------------|--|---------------------|----------------------|--------------|---|-------------|--|
| 1. Bend Up | 1° Max | | | | | | |
| 2. Bend Down | 1º Max | | | | | | |
| 3. Twist | 2º Max | | | | | | |
| 4. Roll | Not Applicable | | | | | | |
| 5. Bell Mouth Rear | 0.40-0.60mm (.016024") | | | | | | |
| 6. Bell Mouth Front | Not Applicable | | | | | | |
| 7. Conductor Brush | 0.55mm (.022") Not to extend above conductor crimp | | | | | | |
| 8. Cut-Off Tab | 0.30mm (.012") Max, no burrs | | | | | | |
| Conductor Crimp | Wire Type | Wire Size | 9. Crimp Height | | 10. Crimp Width | | |
| | CHFUS | 0.22mm ² | 0.66-0.72mm | .026028 in. | 1.01-1.07mm | .040042 in. | |
| Insulation Crimp | Wire Type | Wire Size | 11. Crimp Height | | 12. Crimp Width | | |
| | CHFUS | 0.22mm² | 1.20-1.30mm | .047051 in. | 1.10-1.20mm | .043047 in. | |
| Pull Force | Wire Type | Wire Size | Minimum Force | | | | |
| T dil T di ce | CHFUS | 0.22mm² | 40 N | 9.0 lb. | To be measured with no influence from the insulation crimp. | | |
| 13. Conductor Anvil Flash | 0.10mm (.004") Max | | | | | | |
| 14. Insulation Grip Step | 0.00-0.05mm (.000002") | | | | | | |
| 15. Crimp Bulge | 1.07mm (.042") Max within crimp/transition area | | | | | | |
| Misc. | Wire Type | Wire Size | 16. Wing Dissymmetry | | 17. Space Between Wing Tips and Crimp Bottom | | |
| | CHFUS | 0.22mm ² | 0.20mm Max | .008 in. Max | No contact | | |

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NOTES

Applicator Notes

- This applicator is for automatic wire processor use only.
- This applicator does not include a cutting insert.
- Installing a cutting insert will cause jamming in this applicator.

Specification Notes

- 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 set up wire processor to consistently achieve the brush length.

General 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 FA2 manual (TM-638080200).
- 6. Molex recommends crimping standard copper wire only.
- 7. Lubrication must be used when crimping gold and select gold terminals to prevent terminals from sticking in the conductor punch. Use 63801-7240 oiler or equivalent.

WARNINGS

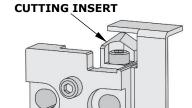
CAUTION: This applicator must be installed in a press with a standard shut height of 135.80mm (5.346"). Tooling damage could result at a lower setting.

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.

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Revision: D Revision Date: 08-12-20



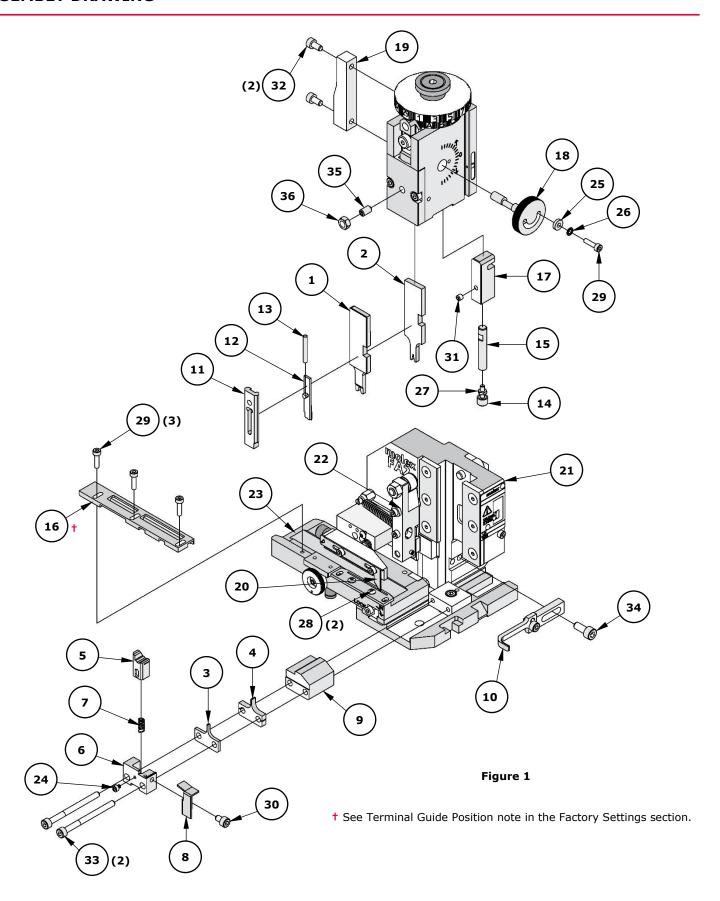
PARTS LIST

| Non-Perishable Components | FA2 Applicator 63808-4800 | | | | | | | | |
|---|---------------------------|------------|------------|--------------------------------|----------|--|--|--|--|
| 63808-4870 63808-4870 Tool Kit (All "Y" Items) Ref | Item | Order No. | | | Quantity | | | | |
| 1 63454-0170 63457-0056 63457-0056 1 Y 2 63457-0056 63457-0056 Conductor Punch 1 Y 3 63456-1101 63455-1005 Conductor Anvil 1 Y 4 63455-1005 63455-1005 Conductor Anvil 1 Y 5 63443-0136 63443-0136 Cut-Off Plunger 1 Y Non-Perishable Components 6 63443-0118 63443-0118 Front Plunger Retainer 1 Y 7 11-24-1067 4996-4 Cut-Off Plunger Spring 1 8 63443-0117 63443-0117 Front Scrap Chute 1 9 63443-7519 63443-7519 Anvil Mount 1 10 63443-2802 63443-2802 Front Plunger Striker 1 11 63443-2802 63443-2921 Wire Hold Down Plunger 1 12 63443-2921 63403-2921 Wire Hold Down Spring 1 13 63600-5776 63600-5776 Nose Hold Down Shank 1 16 | | | | | | | | | |
| 2 63457-0056 63457-0056 Conductor Punch 1 Y 3 63456-1101 G3456-1101 Insulation Anvil 1 Y 4 63455-1005 63455-1005 Conductor Anvil 1 Y 5 63443-0136 Cut-Off Plunger 1 Y Non-Perishable Components 6 63443-0118 63443-0118 Front Plunger Retainer 1 Y 7 11-24-1067 4996-4 Cut-Off Plunger Spring 1 8 63443-0117 63443-0117 Front Scrap Chute 1 9 63443-7519 63443-7519 Anvil Mount 1 10 63443-2802 Front Plunger Striker 1 11 63443-2802 Front Plunger Striker 1 12 63443-2802 Front Plunger Striker 1 13 63600-0021 63403-2921 Wire Hold Down Plunger 1 14 63600-5776 63600-5776 Nose Hold Down Spring 1 15 63600-5775 63600-5775 Nose Hold Down Block | | 63808-4870 | 63808-4870 | Tool Kit (All "Y" Items) | Ref | | | | |
| 3 63456-1101 Insulation Anvil 1 Y 4 63455-1005 63455-1005 Conductor Anvil 1 Y 5 63443-0136 Cut-Off Plunger 1 Y Non-Perishable Components 6 63443-0118 Front Plunger Retainer 1 Y 7 11-24-1067 4996-4 Cut-Off Plunger Spring 1 8 63443-0117 63443-0117 Front Scrap Chute 1 9 63443-7519 63443-7519 Anvil Mount 1 10 63443-2802 Front Plunger Striker 1 11 63443-2802 63443-2802 Front Plunger Striker 1 12 63443-2802 Front Plunger Striker 1 13 63600-0021 63443-2921 Wire Hold Down Spring 1 14 63600-5776 63600-5776 Nose Hold Down Spring 1 15 63600-5775 63600-5775 Nose Hold Down Block 1 16 63443-4701 Terminal Guide 1+ 17 | 1 | 63454-0170 | 63454-0170 | Insulation Punch | 1 Y | | | | |
| 4 63455-1005 63443-0136 Conductor Anvil 1 Y 5 63443-0136 63443-0136 Cut-Off Plunger 1 Y Non-Perishable Components 6 63443-0118 63443-0118 Front Plunger Retainer 1 Y 7 11-24-1067 4996-4 Cut-Off Plunger Spring 1 8 63443-0117 63443-0117 Front Scrap Chute 1 9 63443-7519 63443-0117 Front Scrap Chute 1 10 63443-090 G3443-090 Wire Stop 1 11 63443-2802 63443-2802 Front Plunger Striker 1 12 63443-2921 G3443-2921 Wire Hold Down Plunger 1 13 63600-0021 63600-0021 Wire Hold Down Spring 1 14 63600-5776 63600-5776 Nose Hold Down Shank 1 15 63600-5775 63600-5776 Nose Hold Down Block 1 16 6343-4701 63443-4701 Terminal Guide 1+ 17 </td <td>2</td> <td>63457-0056</td> <td>63457-0056</td> <td>Conductor Punch</td> <td>1 Y</td> | 2 | 63457-0056 | 63457-0056 | Conductor Punch | 1 Y | | | | |
| 5 63443-0136 63443-0136 Cut-Off Plunger 1 Y Non-Perishable Components 6 63443-0118 63443-0118 Front Plunger Retainer 1 Y 7 11-24-1067 4996-4 Cut-Off Plunger Spring 1 8 63443-0117 Front Scrap Chute 1 9 63443-0117 Front Scrap Chute 1 10 63443-0990 63443-0990 Wire Stop 1 11 63443-2802 63443-2802 Front Plunger Striker 1 12 63443-2921 63443-2921 Wire Hold Down Plunger 1 13 63600-0021 63600-0021 Wire Hold Down Spring 1 14 63600-5776 63600-5776 Nose Hold Down Shank 1 15 63600-5775 63600-5775 Nose Hold Down Block 1 16 63443-4701 63443-4701 Terminal Guide 1† 17 63443-4409 63443-4409 Feed Cam 1 19 63443-4409 63808-029 | 3 | 63456-1101 | 63456-1101 | Insulation Anvil | 1 Y | | | | |
| Non-Perishable Components | 4 | 63455-1005 | 63455-1005 | Conductor Anvil | 1 Y | | | | |
| 6 63443-0118 63443-0118 Front Plunger Retainer 1 Y 7 11-24-1067 4996-4 Cut-Off Plunger Spring 1 8 63443-0117 63443-0117 Front Scrap Chute 1 9 63443-7519 63443-7519 Anvil Mount 1 10 63443-0090 63443-0090 Wire Stop 1 11 63443-2802 Front Plunger Striker 1 12 63443-2921 63443-2921 Wire Hold Down Plunger 1 13 63600-0021 63600-0021 Wire Hold Down Spring 1 14 63600-5776 63600-5776 Nose Hold Down Spring 1 15 63600-5775 63600-5775 Nose Hold Down Shank 1 16 63443-4701 63443-4701 Terminal Guide 1† 17 63443-7403 Hold Down Block 1 18 63808-0229 Bend Adjust Dial 1 19 63443-4409 63443-4409 Feed Cam 1 20 63808 | 5 | 63443-0136 | 63443-0136 | Cut-Off Plunger | 1 Y | | | | |
| 7 11-24-1067 4996-4 Cut-Off Plunger Spring 1 8 63443-0117 63443-0117 Front Scrap Chute 1 9 63443-7519 63443-7519 Anvil Mount 1 10 63443-0090 G3443-2802 Front Plunger Striker 1 11 63443-2802 63443-2921 Wire Hold Down Plunger 1 12 63443-2921 G3600-0021 Wire Hold Down Plunger 1 13 63600-0021 63600-5776 Mose Hold Down Spring 1 14 63600-5776 63600-5775 Nose Hold Down Shank 1 15 63600-5775 63600-5775 Nose Hold Down Shank 1 16 63443-4701 Terminal Guide 1† 17 63443-4701 Terminal Guide 1† 18 63808-0229 Bend Adjust Dial 1 19 63443-4409 Feed Cam 1 20 63808-0249 Feed Pawl 1 21 63808-0299 Applicator Core 1< | | | | | | | | | |
| 8 63443-0117 63443-0117 Front Scrap Chute 1 9 63443-7519 63443-7519 Anvil Mount 1 10 63443-0090 Wire Stop 1 11 63443-2802 63443-2802 Front Plunger Striker 1 12 63443-2921 G3443-2921 Wire Hold Down Plunger 1 13 63600-0021 63600-0021 Wire Hold Down Spring 1 14 63600-5776 63600-5776 Nose Hold Down 1 15 63600-5775 63600-5775 Nose Hold Down Shank 1 16 63443-4701 Terminal Guide 1+ 17 63443-4701 G3443-4701 Terminal Guide 1+ 17 63443-4703 Hold Down Block 1 18 63808-0229 Bend Adjust Dial 1 19 63443-4409 Feed Cam 1 20 63808-0249 Feed Pawl 1 21 63808-0249 Applicator Core 1 22 | 6 | 63443-0118 | 63443-0118 | Front Plunger Retainer | 1 Y | | | | |
| 9 63443-7519 63443-0090 Mire Stop 1 10 63443-0090 63443-0090 Wire Stop 1 11 63443-2802 63443-2802 Front Plunger Striker 1 12 63443-2921 Gand Down Plunger 1 13 63600-0021 63600-0021 Wire Hold Down Spring 1 14 63600-5776 63600-5776 Nose Hold Down 1 15 63600-5775 63600-5775 Nose Hold Down Shank 1 16 63443-4701 Gand Down Block 1 17 63443-4703 Hold Down Block 1 18 63808-0229 Gand Adjust Dial 1 19 63443-4409 Feed Cam 1 20 63808-0249 Feed Pawl 1 21 63808-0249 Feed Pawl 1 22 63808-0200 Applicator Core 1 23 63808-0197 Mechanical Feed Assembly 1 23 63808-0191 Gand Feed Cam | 7 | 11-24-1067 | 4996-4 | Cut-Off Plunger Spring | 1 | | | | |
| 10 63443-0090 63443-0090 Wire Stop 1 11 63443-2802 63443-2802 Front Plunger Striker 1 12 63443-2921 Wire Hold Down Plunger 1 13 63600-0021 63600-0021 Wire Hold Down Spring 1 14 63600-5776 63600-5776 Nose Hold Down Shank 1 15 63600-5775 63600-5775 Nose Hold Down Shank 1 16 63443-4701 63443-4701 Terminal Guide 1+ 17 63443-7403 63443-3403 Hold Down Block 1 18 63808-0229 63808-0229 Bend Adjust Dial 1 19 63443-4409 63443-4409 Feed Cam 1 20 63808-0249 Feed Pawl 1 21 63808-0249 G3808-0249 Feed Pawl 1 22 63808-0197 Mechanical Feed Assembly 1 23 63808-0191 Track Assembly 1 24 — — M3 Fla | 8 | 63443-0117 | 63443-0117 | Front Scrap Chute | 1 | | | | |
| 11 63443-2802 63443-2802 Front Plunger Striker 1 12 63443-2921 Wire Hold Down Plunger 1 13 63600-0021 63600-0021 Wire Hold Down Spring 1 14 63600-5776 63600-5776 Nose Hold Down Shank 1 15 63600-5775 63600-5775 Nose Hold Down Shank 1 16 63443-4701 Terminal Guide 1+ 17 63443-7403 Hold Down Block 1 18 63808-0229 63808-0229 Bend Adjust Dial 1 19 63443-4409 63443-4409 Feed Cam 1 20 63808-0249 63808-0249 Feed Pawl 1 Frame 21 63808-0197 63808-0197 Mechanical Feed Assembly 1 Hardware 24 — — M3.5 x 3 SHCS 1* 25 — — M3 Flat Washer Hard 1* 26 — — M3 Inner Tooth Lock Washer | 9 | 63443-7519 | 63443-7519 | Anvil Mount | 1 | | | | |
| 12 63443-2921 63443-2921 Wire Hold Down Plunger 1 13 63600-0021 63600-0021 Wire Hold Down Spring 1 14 63600-5776 63600-5776 Nose Hold Down Shank 1 15 63600-5775 63600-5775 Nose Hold Down Shank 1 16 63443-4701 Terminal Guide 1+ 17 63443-7403 Hold Down Block 1 18 63808-0229 63808-0229 Bend Adjust Dial 1 19 63443-4409 63443-4409 Feed Cam 1 20 63808-0249 63808-0249 Feed Pawl 1 Frame 21 63808-0249 63808-0200 Applicator Core 1 22 63808-0197 63808-0197 Mechanical Feed Assembly 1 Hardware 24 — — M2.5 x 3 SHCS 1* 25 — — M3 Flat Washer Hard 1* 26 — — M3 Inner To | 10 | 63443-0090 | 63443-0090 | Wire Stop | 1 | | | | |
| 13 63600-0021 63600-0021 Wire Hold Down Spring 1 14 63600-5776 63600-5776 Nose Hold Down 1 15 63600-5775 63600-5775 Nose Hold Down Shank 1 16 63443-4701 Terminal Guide 1† 17 63443-7403 Hold Down Block 1 18 63808-0229 63808-0229 Bend Adjust Dial 1 19 63443-4409 Feed Cam 1 20 63808-0249 63808-0249 Feed Pawl 1 Frame 21 63808-0249 63808-0200 Applicator Core 1 22 63808-0197 63808-0197 Mechanical Feed Assembly 1 Hardware 24 — — M2.5 x 3 SHCS 1* 25 — — M3 Flat Washer Hard 1* 26 — — M3 Inner Tooth Lock Washer 1* 27 — — M3 Hex Nut 1* | 11 | 63443-2802 | 63443-2802 | Front Plunger Striker | 1 | | | | |
| 14 63600-5776 63600-5776 Nose Hold Down 1 15 63600-5775 63600-5775 Nose Hold Down Shank 1 16 63443-4701 Terminal Guide 1† 17 63443-4703 Hold Down Block 1 18 63808-0229 63808-0229 Bend Adjust Dial 1 19 63443-4409 63443-4409 Feed Cam 1 20 63808-0249 63808-0249 Feed Pawl 1 Frame 21 63808-0200 63808-0200 Applicator Core 1 22 63808-0197 63808-0197 Mechanical Feed Assembly 1 Hardware 24 — — M3 Flat Washer Hard 1* 25 — — M3 Inner Tooth Lock Washer 1* 26 — — M3 Hex Nut 1* 28 — — M3 x 6 BHCS 2* 29 — — M3 x 12 SHCS 4* | 12 | 63443-2921 | 63443-2921 | Wire Hold Down Plunger | 1 | | | | |
| 15 63600-5775 63600-5775 Nose Hold Down Shank 1 16 63443-4701 63443-4701 Terminal Guide 1+ 17 63443-7403 63443-7403 Hold Down Block 1 18 63808-0229 63808-0229 Bend Adjust Dial 1 19 63443-4409 63443-4409 Feed Cam 1 20 63808-0249 63808-0249 Feed Pawl 1 Frame 21 63808-0200 63808-0200 Applicator Core 1 22 63808-0197 63808-0197 Mechanical Feed Assembly 1 Hardware 24 — — M2.5 x 3 SHCS 1* 25 — — M3 Flat Washer Hard 1* 26 — — M3 Inner Tooth Lock Washer 1* 27 — — M3 Hex Nut 1* 28 — — M3 x 6 BHCS 2* 29 — — M3 x 12 SHCS | 13 | 63600-0021 | 63600-0021 | Wire Hold Down Spring | 1 | | | | |
| 16 63443-4701 63443-4701 Terminal Guide 1† 17 63443-7403 63443-7403 Hold Down Block 1 18 63808-0229 63808-0229 Bend Adjust Dial 1 19 63443-4409 63443-4409 Feed Cam 1 20 63808-0249 Feed Pawl 1 Frame 21 63808-0249 Applicator Core 1 22 63808-0200 Applicator Core 1 23 63808-0197 Mechanical Feed Assembly 1 Hardware 24 — — M2.5 x 3 SHCS 1* 25 — — M3 Flat Washer Hard 1* 26 — — M3 Inner Tooth Lock Washer 1* 27 — — M3 Hex Nut 1* 28 — — M3 x 6 BHCS 2* 29 — — M3 x 12 SHCS 4* | 14 | 63600-5776 | 63600-5776 | Nose Hold Down | 1 | | | | |
| 17 63443-7403 63443-7403 Hold Down Block 1 18 63808-0229 63808-0229 Bend Adjust Dial 1 19 63443-4409 63443-4409 Feed Cam 1 20 63808-0249 63808-0249 Feed Pawl 1 Frame 21 63808-0200 63808-0200 Applicator Core 1 22 63808-0197 63808-0197 Mechanical Feed Assembly 1 Hardware 24 — — M2.5 x 3 SHCS 1* 25 — — M3 Flat Washer Hard 1* 26 — — M3 Inner Tooth Lock Washer 1* 27 — — M3 Hex Nut 1* 28 — — M3 x 6 BHCS 2* 29 — — M3 x 12 SHCS 4* | 15 | 63600-5775 | 63600-5775 | Nose Hold Down Shank | 1 | | | | |
| 18 63808-0229 63808-0229 Bend Adjust Dial 1 19 63443-4409 Feed Cam 1 20 63808-0249 63808-0249 Feed Pawl 1 Frame 21 63808-0200 63808-0200 Applicator Core 1 22 63808-0197 63808-0197 Mechanical Feed Assembly 1 Hardware 24 — — M2.5 x 3 SHCS 1* 25 — — M3 Flat Washer Hard 1* 26 — — M3 Inner Tooth Lock Washer 1* 27 — — M3 Hex Nut 1* 28 — — M3 x 6 BHCS 2* 29 — — M3 x 12 SHCS 4* | 16 | 63443-4701 | 63443-4701 | Terminal Guide | 1† | | | | |
| 19 63443-4409 63443-4409 Feed Cam 1 Frame 21 63808-0200 63808-0200 Applicator Core 1 22 63808-0197 63808-0197 Mechanical Feed Assembly 1 23 63808-0191 Track Assembly 1 Hardware 24 — — M3 Flat Washer Hard 1* 25 — — M3 Inner Tooth Lock Washer 1* 26 — — M3 Hex Nut 1* 27 — — M3 x 6 BHCS 2* 29 — — M3 x 12 SHCS 4* | 17 | 63443-7403 | 63443-7403 | Hold Down Block | 1 | | | | |
| 20 63808-0249 Feed Pawl 1 Frame 21 63808-0200 63808-0200 Applicator Core 1 22 63808-0197 63808-0197 Mechanical Feed Assembly 1 23 63808-0191 Track Assembly 1 Hardware 24 — — M2.5 x 3 SHCS 1* 25 — — M3 Flat Washer Hard 1* 26 — — M3 Inner Tooth Lock Washer 1* 27 — — M3 Hex Nut 1* 28 — — M3 x 6 BHCS 2* 29 — — M3 x 12 SHCS 4* | 18 | 63808-0229 | 63808-0229 | Bend Adjust Dial | 1 | | | | |
| Frame 21 63808-0200 63808-0200 Applicator Core 1 22 63808-0197 63808-0197 Mechanical Feed Assembly 1 23 63808-0191 Track Assembly 1 Hardware 24 — — M2.5 x 3 SHCS 1* 25 — — M3 Flat Washer Hard 1* 26 — — M3 Inner Tooth Lock Washer 1* 27 — — M3 Hex Nut 1* 28 — — M3 x 6 BHCS 2* 29 — — M3 x 12 SHCS 4* | 19 | 63443-4409 | 63443-4409 | Feed Cam | 1 | | | | |
| 21 63808-0200 63808-0200 Applicator Core 1 22 63808-0197 63808-0197 Mechanical Feed Assembly 1 Hardware 24 — — M2.5 x 3 SHCS 1* 25 — — M3 Flat Washer Hard 1* 26 — — M3 Inner Tooth Lock Washer 1* 27 — — M3 Hex Nut 1* 28 — — M3 x 6 BHCS 2* 29 — — M3 x 12 SHCS 4* | 20 | 63808-0249 | 63808-0249 | Feed Pawl | 1 | | | | |
| 22 63808-0197 63808-0197 Mechanical Feed Assembly 1 Hardware 24 — — M2.5 x 3 SHCS 1* 25 — — M3 Flat Washer Hard 1* 26 — — M3 Inner Tooth Lock Washer 1* 27 — — M3 Hex Nut 1* 28 — — M3 x 6 BHCS 2* 29 — — M3 x 12 SHCS 4* | | | F | rame | | | | | |
| 23 63808-0191 Track Assembly 1 Hardware 24 — — M2.5 x 3 SHCS 1* 25 — — M3 Flat Washer Hard 1* 26 — — M3 Inner Tooth Lock Washer 1* 27 — — M3 Hex Nut 1* 28 — — M3 x 6 BHCS 2* 29 — — M3 x 12 SHCS 4* | 21 | 63808-0200 | 63808-0200 | Applicator Core | 1 | | | | |
| Hardware 24 — — M2.5 x 3 SHCS 1* 25 — — M3 Flat Washer Hard 1* 26 — — M3 Inner Tooth Lock Washer 1* 27 — — M3 Hex Nut 1* 28 — — M3 x 6 BHCS 2* 29 — — M3 x 12 SHCS 4* | 22 | 63808-0197 | 63808-0197 | Mechanical Feed Assembly | 1 | | | | |
| 24 — — M2.5 x 3 SHCS 1* 25 — — M3 Flat Washer Hard 1* 26 — — M3 Inner Tooth Lock Washer 1* 27 — — M3 Hex Nut 1* 28 — — M3 x 6 BHCS 2* 29 — — M3 x 12 SHCS 4* | 23 | 63808-0191 | 63808-0191 | Track Assembly | 1 | | | | |
| 25 — — M3 Flat Washer Hard 1* 26 — — M3 Inner Tooth Lock Washer 1* 27 — — M3 Hex Nut 1* 28 — — M3 x 6 BHCS 2* 29 — — M3 x 12 SHCS 4* | | | Har | dware | | | | | |
| 26 — M3 Inner Tooth Lock Washer 1* 27 — M3 Hex Nut 1* 28 — — M3 x 6 BHCS 2* 29 — — M3 x 12 SHCS 4* | 24 | _ | _ | M2.5 x 3 SHCS | 1* | | | | |
| 27 — M3 Hex Nut 1* 28 — — M3 x 6 BHCS 2* 29 — — M3 x 12 SHCS 4* | 25 | _ | _ | M3 Flat Washer Hard | 1* | | | | |
| 28 — — M3 x 6 BHCS 2* 29 — — M3 x 12 SHCS 4* | 26 | _ | _ | M3 Inner Tooth Lock Washer | 1* | | | | |
| 29 — — M3 x 12 SHCS 4* | 27 | _ | _ | M3 Hex Nut | 1* | | | | |
| | 28 | _ | _ | M3 x 6 BHCS | 2* | | | | |
| 30 — — M4 x 6 SHCS 1* | 29 | _ | _ | M3 x 12 SHCS | 4* | | | | |
| | 30 | _ | _ | M4 x 6 SHCS | 1* | | | | |
| 31 - M4 x 4 SSS 1* | 31 | _ | _ | M4 x 4 SSS | 1* | | | | |
| 32 M4 x 8 SHCS 2* | 32 | _ | _ | M4 x 8 SHCS | 2* | | | | |
| 33 M4 x 50 SHCS 2* | 33 | _ | _ | M4 x 50 SHCS | 2* | | | | |
| 34 M5 x 12 SHCS 1* | 34 | _ | _ | | 1* | | | | |
| 35 — #10-32UNF x .50" Cup Point SSS 1* | 35 | _ | _ | #10-32UNF x .50" Cup Point SSS | 1* | | | | |
| 36 — #10-32UNF Jam Nut 1* | 36 | _ | _ | | 1* | | | | |

^{*}Fastener parts can be purchased through most industrial suppliers by using the description in the table above.

Doc. No: 638084800 Release Date: 04-27-18 **UNCONTROLLED COPY** Page 4 of 7 Revision: D Revision Date: 08-12-20

ASSEMBLY DRAWING



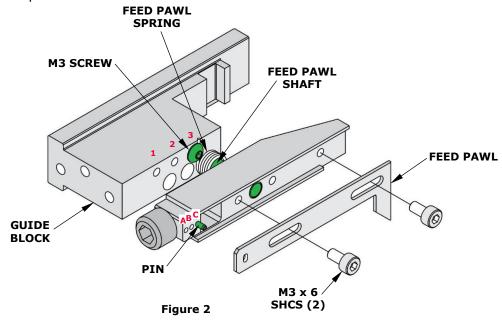
Doc. No: 638084800 Release Date: 04-27-18 **UNCONTROLLED COPY** Page 5 of 7 Revision: D Revision Date: 08-12-20

FACTORY SETTINGS

Feed Pawl Assembly

The FA2 applicator number 63808-4800 ships with the following factory settings. See Figure 2:

- The feed pawl shaft and M3 screw that holds the feed pawl spring are in position 3.
- The pin is in position C.



Note: Each applicator is configured and tested by Molex prior to shipping, and the above settings were used to produce the included sample crimps.

Third Dial/Ram Assembly

Indicates item number on the Parts List and Assembly Drawing **HOLD DOWN RAM** Front **BLOCK** 64.8mm **NOSE HOLD** (Ref) **BEND DOWN SHANK ADJUST DIAL NOSE HOLD NOSE HOLD DOWN** 12.3mm **DOWN SHANK** (Ref) **NOSE HOLD** DOWN Figure 3

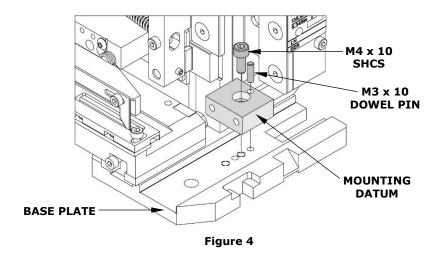
Note: The above dimensions were measured during setup and are included as a reference only. Additional adjustments may be required before crimping for production.

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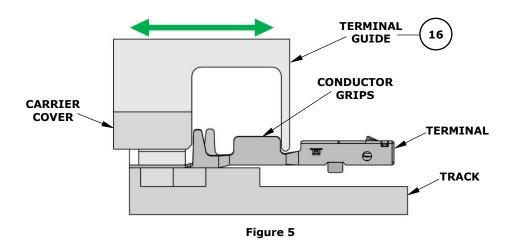
Mounting Datum Location

This applicator was assembled and tested by Molex with the mounting datum in the location shown in Figure 4. Do not remove the mounting datum.



Terminal Guide Position

The terminal guide on this applicator should be positioned so that it is in front of the terminal conductor grips, as shown in Figure 5.



Application Tooling Support

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