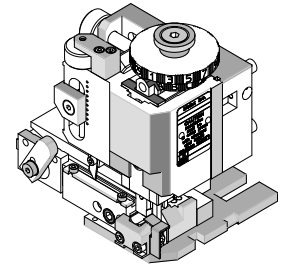


**Order Number**  
**226045-0600**



## 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 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

### SCOPE

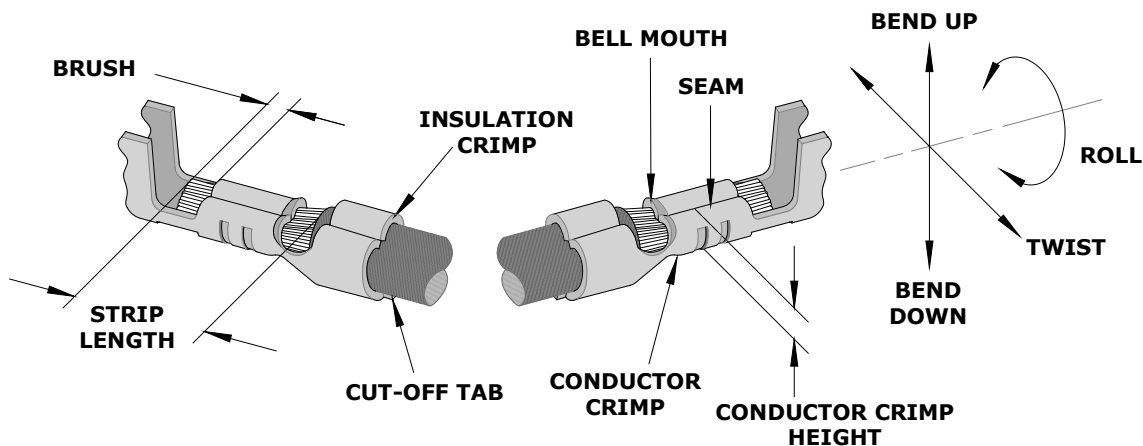
**Products:** Mega-Fit Crimp Terminals, 22 AWG (UL10368 Wire)

Terminal Series No.	Terminal Order No.	Wire		Insulation Diameter IPC/WHMA-A-620 (1)		Strip Length	
		Wire Type	Wire Size	mm	In.	mm	In.
225879	225879-0003	UL10368	22 AWG	1.20-1.50	.047-.059	4.00-4.50	.157-.177

(1) Wire Style shown was used to validate the crimp tooling. It is the responsibility of the end user to choose the wire style that is appropriate for their needs. Other wire styles may not meet the same range for IPC/WHMA-A-620.  
(2) To achieve optimum IPC/WHMA-A-620 Class 2 insulation crimps, use this insulation OD range

**CAUTION: We recommend the use of lubricant for this applicator. Use 63801-7240 oiler, or equivalent.**

## DEFINITION OF TERMS



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

## CRIMP SPECIFICATION

Terminal Series No.	Bell Mouth		Cut-Off Tab Maximum		Conductor Brush	
	mm	In.	mm	In.	mm	In.
225879	0.30-0.70	.012-.028	0.20	.008	0.10-0.80	.004-.031

Terminal Series No.	Bend Up	Bend Down	Twist	Roll	Seam
	Degree (Max)		Degree (Max)		
225879	3	3	4	8	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	Conductor				Pull Force Minimum	
		Crimp Height		Crimp Width			
	Wire Size	mm	In.	mm	In.	N	Lb.
225879	22 AWG	1.02-1.12	.040-.044	1.60-1.70	.063-.067	35.6	8.0

Terminal Series No.	Wire		Insulation			
			Crimp Height (Ref)		Crimp Width (Ref)	
	Wire Type	Wire Size	mm	In.	mm	In.
225879	UL10368	22 AWG	1.60-1.80	.063-.071	1.90-2.10	.075-.083

### **Tool Qualification Notes**

1. Pull force should be measured with no influence from the insulation crimp.
2. Pull force specifications on double crimps are based on pulling one wire.
3. Double crimps should have wires presented side-by-side to achieve the best insulation crimp.
4. The above specifications are guidelines to an optimum crimp.

**PARTS LIST**

<b>FineAdjust Applicator 226045-0600</b>				
<b>Item</b>	<b>Order No.</b>	<b>Engineering No.</b>	<b>Description</b>	<b>Quantity</b>
<b>Perishable Tooling</b>				
	226045-0670	226045-0670	Tool Kit (All "Y" Items)	REF
1	63446-2015	63446-2015	Insulation Punch	1 Y
2	63444-1647	63444-1647	Conductor Punch	1 Y
3	200221-2016	200221-2016	Insulation Anvil	1 Y
4	200217-1609	200217-1609	Conductor Anvil	1 Y
5	63443-0003	63443-0003	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	4996-4	Cut-Off Plunger Spring	1
9	63443-0009	63443-0009	Scrap Chute	1
10	63443-0024	63443-0024	Lower Tooling Key	1
11	63443-0090	63443-0090	Wire Stop Assembly	1
12	63443-2801	63443-2801	Front Plunger Striker	1
13	63443-2914	63443-2914	Wire Hold Down Plunger	1
14	63443-6108	63443-6108	Rear Track Cover	1
15	63600-0021	63600-0021	Spring	1
16	200213-0730	200213-0730	Anvil Mount	1
<b>Frame</b>				
17	63800-4901	63800-4901	Top	1
18	63801-3281	63801-3281	Base	1
19	63801-4650	63801-4650	Track	1
<b>Hardware</b>				
20	—	—	M3 by 5 Long FHCS	1*
21	—	—	M3 by 6 Long SHCS	2*
22	—	—	M4 by 6 Long SHCS	1*
23	—	—	M5 by 12 Long SHCS	1*
24	—	—	M4 by 12 Long BHCS	2*
25	—	—	M4 by 50 Long SHCS	2*
26	—	—	#10-32 by 3/8" Long Flat Point SSS	1*
27	—	—	#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

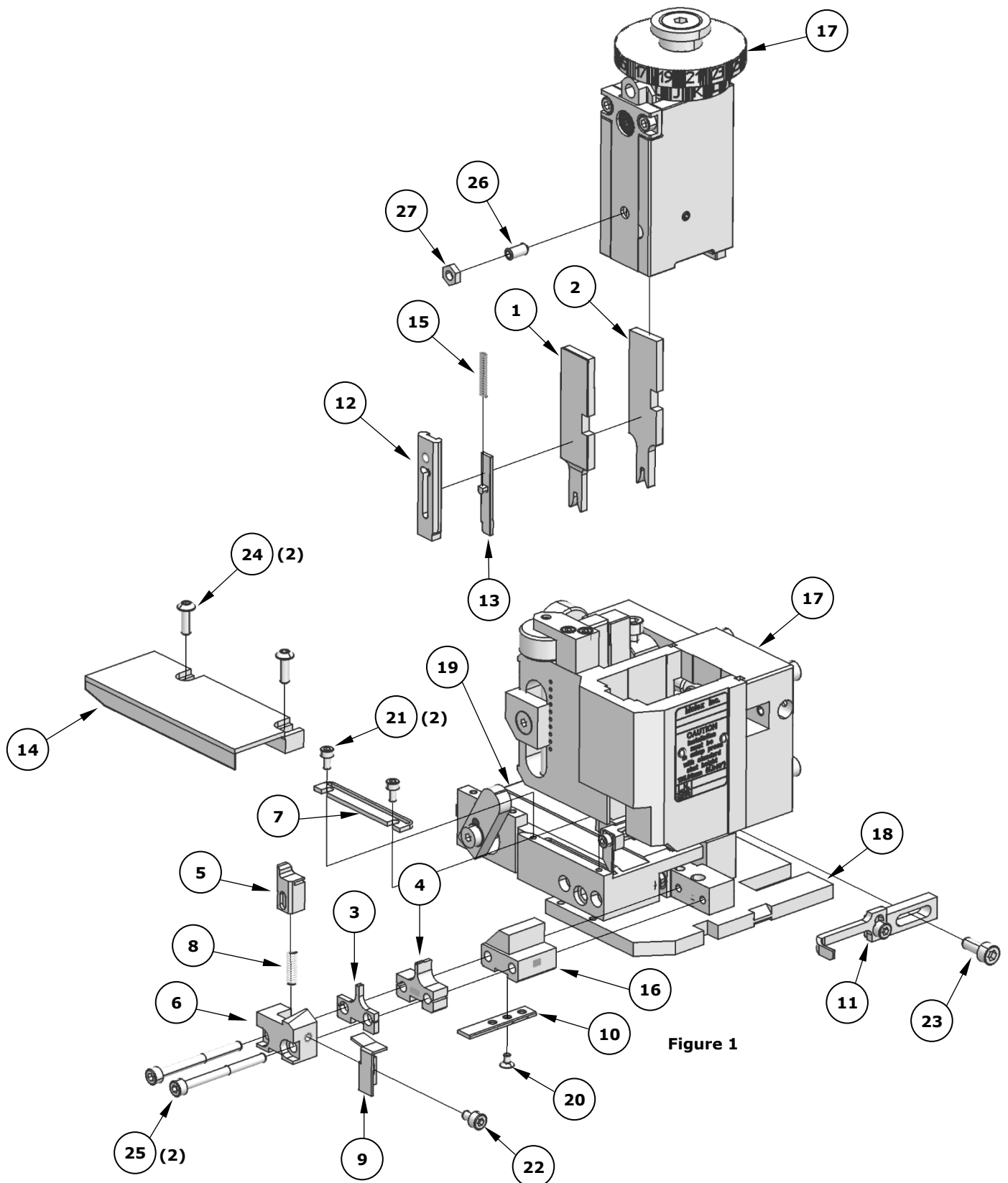


Figure 1

## NOTES

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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.

**CAUTION:** This applicator should only be used in a press with a shut height of 135.8mm (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

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

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

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