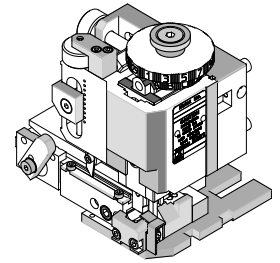# Order Number 2260451200

molex

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
- This tool is IPC/WHMA-A-620 compliant.
- 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.
- Directly adapts to most automatic wire processing machines.
- For Crimping terminal 217347-8300 Versa-Blade Male Terminal use applicator 226045-0200.
- For Crimping UL1015 wire (20+20/22+22) with 217347-8300 Versa-Blade Male Terminal use Applicator 226045-0100.
- For Crimping UL1015 wire (20+20/22+22) with 217348-8300 Versa-Blade Female Terminal use Applicator 226045-1100
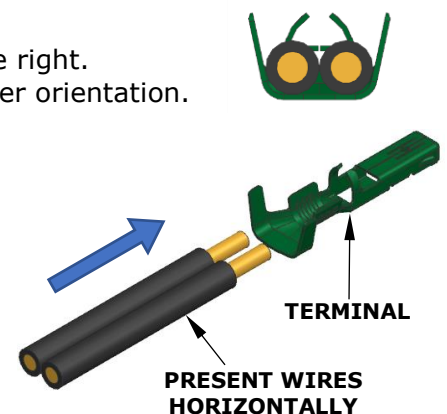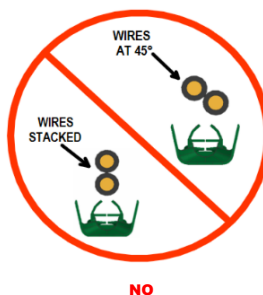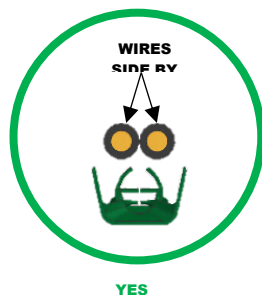
SCOPE

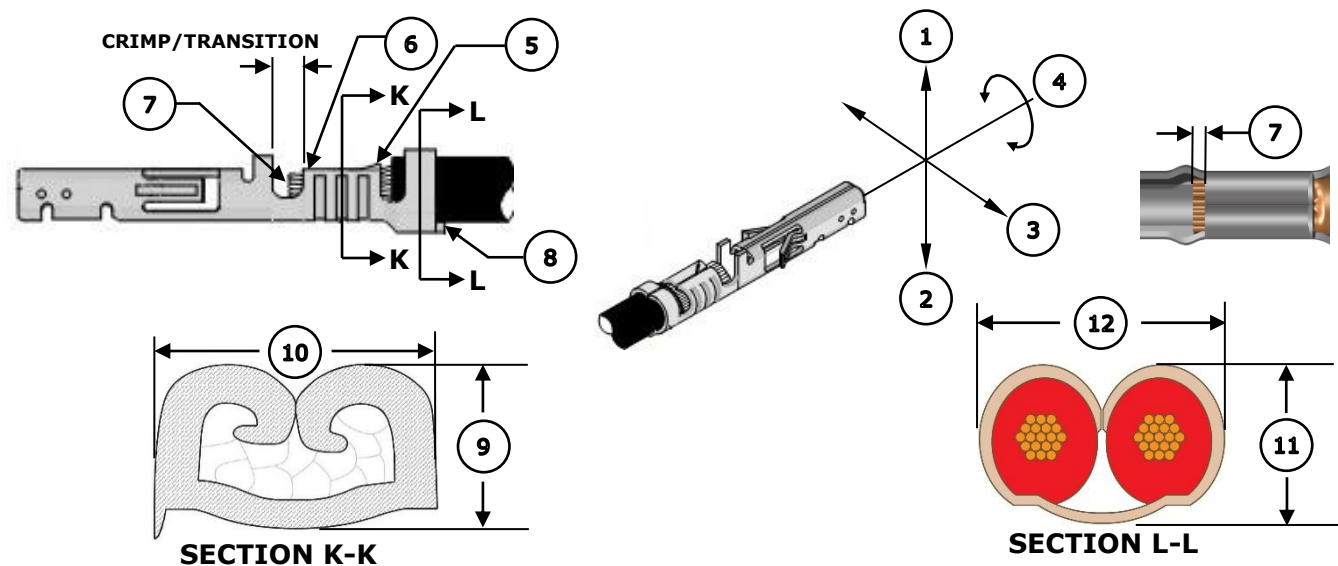**Products:** Versa-Blade Female Double Crimp Terminals, 20+20 & 22+22 AWG UL1007 wire.

Terminal Series No.	Terminal Order No.	Wire Size		Insulation Diameter (Per wire)				Strip Length	
				IPC/WHMA-A-620 (2)		Terminal (3)			
		AWG	Wire Type(1)	mm	In.	mm	In.	mm	In.
217348	217348-8300	20+20	UL1007	1.70-2.10	.067-.083	1.70-2.60	.067-.102	4.0-4.8	.16 -.19
		22+22	UL1007	1.50-1.80	.059-.070	1.50-2.50	.059-.098		

(1) Wire type shown was used to validate the crimp tooling. It is the responsibility of the end user to choose the Wire type that is appropriate for their needs. Other wire types may not meet the same range for IPC/WHMA-A-620.
(2) To achieve IPC/WHMA-A-620 insulation crimps, use this Insulation Diameter range.
(3) Insulation Diameter per Crimp Specification 2173470000CS**.**

*Wire Presentation Notes

- Wires should be presented horizontally. See the illustration to the right.
- Avoid placing the wires vertically or at 45° orientation or any other orientation.

WIRES SIDE BY

YES

WIRES AT 45°

WIRES STACKED

NO

TERMINAL

PRESENT WIRES HORIZONTALLY

DEFINITION OF TERMS

SECTION K-K

SECTION L-L

Note: Image above is a generic terminal representation. The actual terminals of the scope may look different.

CRIMP SPECIFICATION

Feature	Requirement				
1. Bend Up	3° Max				
2. Bend Down	3° Max				
3. Twist	3° Max				
4. Roll	5° Max				
5. Bell Mouth Rear	0.30-0.80mm (.012-.031")				
6. Bell Mouth Front	Not Applicable				
7. Conductor Brush	0.30-1.20mm (.012-.047")				
8. Cut-Off Tab	0.50mm (.020") Max				
Conductor Crimp	**Terminal Order No.**	**Wire Size**	**9. Crimp Height**		**10. Crimp Width (Ref)**	
	217348-8300	20+20 AWG	1.10-1.20	.043 -.047 In.	2.25 mm	.088 In.
		22+22 AWG	1.00-1.10	.039-.043 In.	2.25 mm	.088 In.
Insulation Crimp	**Terminal Order No.**	**Wire Size**	**11. Crimp Height (Ref)**		**12. Crimp Width (Ref)**	
	217348-8300	20+20 AWG	2.10mm	.083 In.	4.85 mm	.190 In.
		22+22 AWG	1.75mm	.069 In.	4.80 mm	.189 In.
Pull Force	**Terminal Order No.**	**Wire Size**	**Minimum Pull Force**			
	217348-8300	20+20 AWG	58.8 N	13.2 lb.	To be measured with no influence from the insulation crimp.	
		22+22 AWG	39.2 N	8.81 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.

NOTE: Do not attempt to crimp a single wire in this applicator. Tooling damage will result if the insulation crimp height is adjusted too low.

PARTS LIST

Item	Order No.	Engineering No.	Description	Quantity
**FineAdjust Applicator 226045-1200**				
**Perishable Tooling**				
	226045-1270	226045-1270	Tool Kit (All "Y" Items)	REF
1	63444-2218	63444-2218	Conductor Punch	1 Y
2	200217-2201	200217-2201	Conductor Anvil	1 Y
3	200220-4805	200220-4805	Insulation Punch	1 Y
4	200221-4802	200221-4802	Insulation Anvil	1 Y
5	63443-0005	63443-0005	Cut-Off Plunger	1 Y
6	63443-0012	63443-0012	Front Plunger Retainer	1 Y
**Other Components**				
7	11-17-0022	1739-21	Compression Spring	1
8	11-18-4083	60707-8	Feed Guide	1
9	11-24-1067	4996-4	Cut-Off Plunger Spring	1
10	63443-0009	63443-0009	Front Scrap Chute	1
11	63443-0024	63443-0024	Key	1
12	63443-0090	63443-0090	Wire Stop	1
13	63443-0043	63443-0043	Shank	1
14	200213-7603	200213-7603	Anvil Mount	1
15	63443-2801	63443-2801	Front Plunger Striker	1
16	63443-2913	63443-2913	Wire Hold Down Plunger	1
17	63600-5776	63600-5776	Nose Hold Down	1
18	63443-6119	63443-6119	Rear Cover	1
19	63600-1057	63600-1057	Compression Spring	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 by 6 Long SHCS	2*
24	—	—	M3 by 5 Long FHCS	1*
25	—	—	M4 by 6 Long SHCS	2*
26	—	—	M4 by 12 Long BHCS	2*
27	—	—	M4 by 50 Long SHCS	2*
28	—	—	M5 by 12 Long SHCS	1*
29	—	—	M5 by 10 Long Flat Point SSS	1*
30	—	—	M5 Hex Jam Nut	1*
* Available from an industrial supply company.				

Doc. No: 2260451200
Revision: A
Release Date: 04-25-24
Revision Date: 04-25-24
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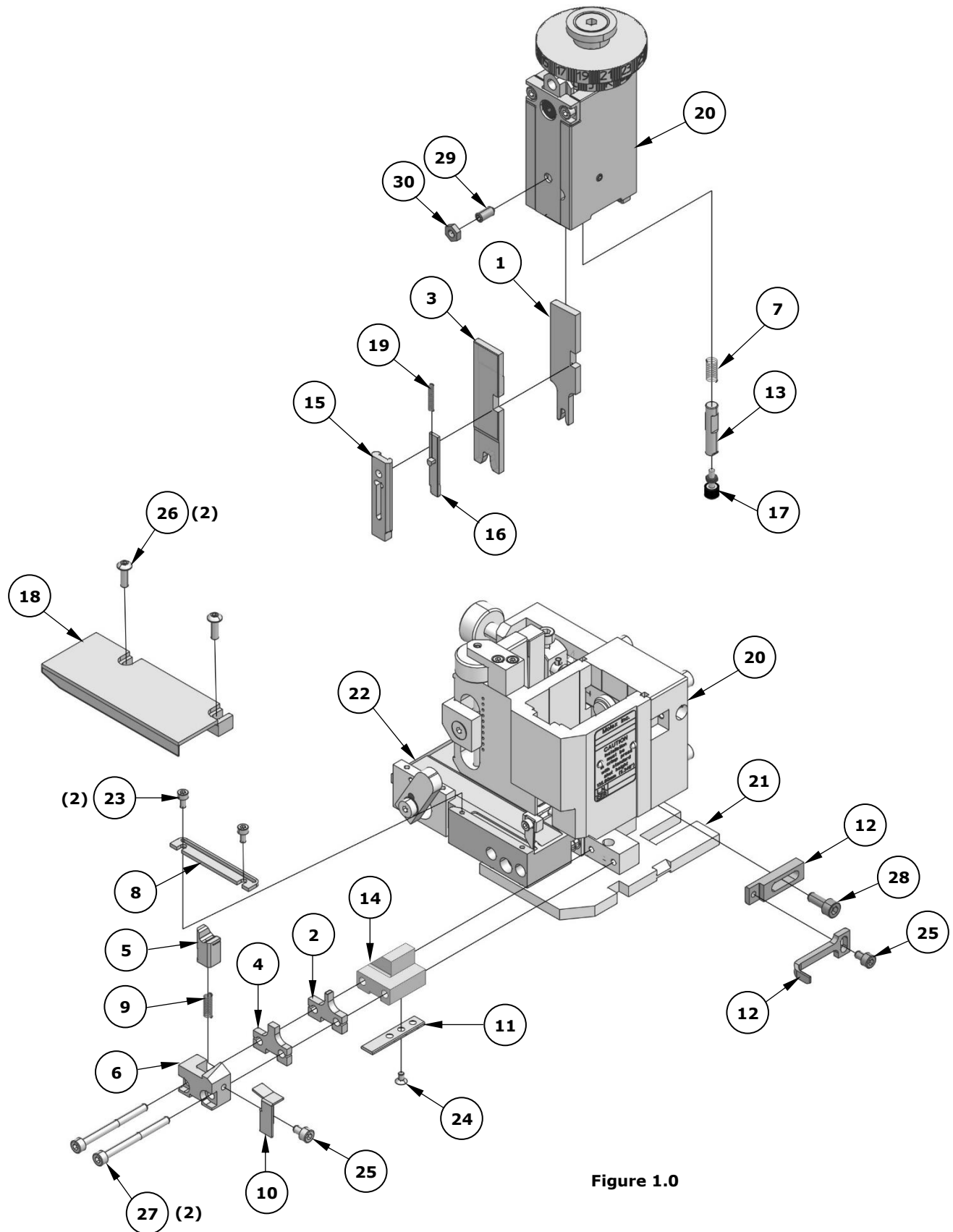Page 3 of 5

ASSEMBLY DRAWING

Figure 1.0

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.

> **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 crimp specifications are valid only when used with Molex terminals, applicators and tooling.

Application Tooling Support

E-Mail: toolingsupport@molex.com
Website: www.molex.com/applicationtooling