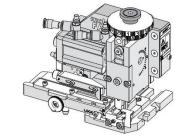
Order Number 213069-0110





Application Tooling Specification

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
- This applicator is configured with a pneumatic feed, which requires a 4-way pneumatic valve for operation

SCOPE

Products: Micro-Lock PLUS, 22-26 AWG UL1061 and 0.30mm² AVSS Wire.

Terminal	Terminal Order No.	Wire		Insulation Diameter		Strip Length	
Series No.		Size	Туре	mm	In.	mm	In.
505572	505572-1000 505572-1100 505572-1200 505572-1300	22 AWG	UL1061	0.90-1.50	.035059	1.90-2.10	.075083
		24 AWG					
		26 AWG					
		0.30mm ²	AVSS	0.90-1.50	.035059	1.90-2.10	.075083

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

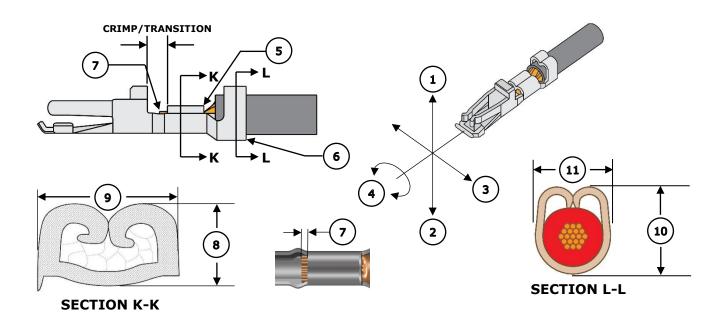
CAUTION: To operate the pneumatic feed, a 4-way pneumatic valve is required.

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DEFINITION OF TERMS



CRIMP SPECIFICATIONS

Feature	Requirement						
1. Bend Up	4° Max						
2. Bend Down	2° Max						
3. Twist	3° Max						
4. Roll	6° Max						
5. Bell Mouth	0.10-0.45mm (.004018")						
6. Cut-Off Tab	0.10mm (.004") Max						
7. Conductor Brush	0.10-0.65mm (.004026")						
	Wire Size	8. Crimp Height		9. Crimp Width (REF)			
	22 AWG	0.78-0.83mm	.031033 in.	1.20mm	.047 in.		
Conductor Crimp	24 AWG	0.70-0.75mm	.028030 in.				
	26 AWG	0.65-0.70mm	.026028 in.				
	0.30mm ²	0.78-0.83mm	.031033 in.				
	Wire Size	10. Crimp Height (REF)		11. Crimp Width (REF)			
	22 AWG	1.74mm	.069 in.	1.50mm	.059 in.		
Insulation Crimp	24 AWG	1.66mm	.065 in.				
	26 AWG	1.57mm	.062 in.				
	0.30mm ²	1.79mm	.070 in.				
	Wire Size	Minimu	m Force				
	22 AWG	39.2 N	8.8 lb.	To be measured with no influence from the insulation crimp.			
Pull Force	24 AWG	29.4 N	6.6 lb.				
	26 AWG	19.6 N	4.4 lb.				
	0.30mm ²	39.2 N	8.8 lb.				

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NOTES

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 stranded copper wire only.

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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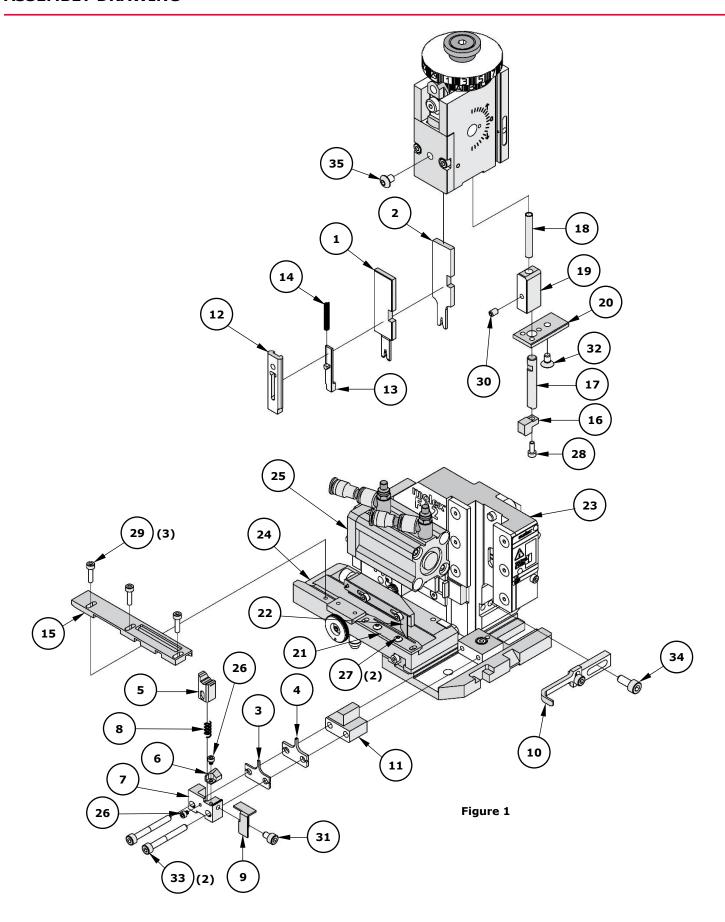
PARTS LIST

Step		Applicator 213069-0110							
213069-0170 213069-0170 Tool Kit (All "Y" Items) Ref	Item	Order No.	Engineering No.	Description	Quantity				
1 200220-1502 200220-1502 Insulation Punch 1 Y 2 200216-1202 200216-1202 Conductor Punch 1 Y 3 200221-1401 200221-1401 Insulation Anvil 1 Y 4 200217-1202 200217-1202 Conductor Anvil 1 Y 5 63443-0136 63443-0136 Cut-Off Plunger 1 Y 6 63443-0119 Cutting Insert 1 Y Non-Perishable Components 7 63443-0118 63443-0118 Front Plunger Retainer 1 8 11-24-1067 4996-4 Cut-Off Plunger Spring 1 9 63443-0117 63443-0117 Front Scrap Chute 1 10 63443-0090 63443-0090 Wire Stop Assembly 1 11 200213-0624 200213-0624 Anvil Mount 1 12 63443-2806 Front Plunger Striker 1 13 63443-2905 63443-2905 Wire Hold Down Plunger 1 14 63600-0021 Wire Hol									
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Non-Perishable Components	5	63443-0136	63443-0136	Cut-Off Plunger	1 Y				
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15 63443-4716 63443-7006 63443-7006 Terminal Guide 1 16 63443-7006 63443-7006 Terminal Hold Down 1 17 63808-0228 63808-0228 Nose Hold Down Shank 1 18 63600-5614 63600-5614 Hold Down Spring 1 19 63808-0226 63808-0226 Hold Down Block 1 20 63808-0224 63808-0224 Stop Plate 1 21 63443-4603 63443-4603 Carrier Cover 1 22 63808-0249 63808-0249 Feed Pawl 1 24 63808-0200 Applicator Core 1 24 63808-0191 Track Assembly 1 25 63808-0196 63808-0196 Pneumatic Feed Assembly 1 26 — — M2.5 x 3 SHCS 2* 27 — — M3 x 6 BHCS 2* 28 — — M3 x 8 SHCS 1* 30 — —	13	63443-2905	63443-2905	Wire Hold Down Plunger	1				
16 63443-7006 63443-7006 Terminal Hold Down 1 17 63808-0228 63808-0228 Nose Hold Down Shank 1 18 63600-5614 63600-5614 Hold Down Block 1 19 63808-0226 63808-0226 Hold Down Block 1 20 63808-0224 63808-0224 Stop Plate 1 21 63443-4603 Carrier Cover 1 22 63808-0249 63808-0249 Feed Pawl 1 Frame 23 63808-0200 63808-0200 Applicator Core 1 24 63808-0191 G3808-0191 Track Assembly 1 Hardware 26 — — M3 x 6 BHCS 2* 27 — — M3 x 8 SHCS 1* 29 — — M3 x 8 SHCS 1* 30 — — M4 x 6 SSS 1* 31 — — M4 x 8 FHCS 1*	14	63600-0021	63600-0021	Wire Hold Down Spring	1				
17 63808-0228 63808-0228 Nose Hold Down Shank 1 18 63600-5614 63600-5614 Hold Down Spring 1 19 63808-0226 63808-0226 Hold Down Block 1 20 63808-0224 63808-0224 Stop Plate 1 21 63443-4603 Carrier Cover 1 22 63808-0249 63808-0249 Feed Pawl 1 Frame 23 63808-0249 63808-0200 Applicator Core 1 24 63808-0290 63808-0200 Applicator Core 1 24 63808-0191 Track Assembly 1 Hardware 26 — — M2.5 x 3 SHCS 2* 27 — — M3 x 6 BHCS 2* 28 — — M3 x 12 SHCS 1* 30 — — M4 x 6 SSS 1* 31 — — M4 x 8 FHCS 1* 32	15	63443-4716	63443-4716	Terminal Guide	1				
18 63600-5614 63600-5614 Hold Down Spring 1 19 63808-0226 63808-0224 Stop Plate 1 20 63808-0224 63808-0224 Stop Plate 1 21 63443-4603 63443-4603 Carrier Cover 1 22 63808-0249 63808-0249 Feed Pawl 1 Frame 23 63808-0249 63808-0200 Applicator Core 1 24 63808-0200 63808-0200 Applicator Core 1 24 63808-0191 63808-0191 Track Assembly 1 25 63808-0196 Pneumatic Feed Assembly 1 Hardware 26 — — M3 x 6 BHCS 2* 27 — — M3 x 8 SHCS 1* 29 — — M3 x 12 SHCS 3* 30 — — M4 x 6 SSS 1* 31 — — M4 x 8 FHCS 1* <		63443-7006	63443-7006	Terminal Hold Down					
19 63808-0226 63808-0224 Stop Plate 1 20 63808-0224 Stop Plate 1 21 63443-4603 Carrier Cover 1 22 63808-0249 Feed Pawl 1 Frame 23 63808-0200 63808-0200 Applicator Core 1 24 63808-0191 63808-0191 Track Assembly 1 East Assembly 1 Hardware 26 — — M3 x 6 BHCS 2* 27 — — M3 x 8 SHCS 1* 29 — — M3 x 12 SHCS 3* 30 — — M4 x 6 SSS 1* 31 — — M4 x 6 SHCS 1* 32 — — M4 x 8 FHCS 1* 33 — — M4 x 35 SHCS 2* 34 — — M5 x 12 SHCS 1*	17	63808-0228	63808-0228	Nose Hold Down Shank					
20 63808-0224 Stop Plate 1 21 63443-4603 Carrier Cover 1 22 63808-0249 Feed Pawl 1 Frame 23 63808-0200 63808-0200 Applicator Core 1 24 63808-0191 63808-0191 Track Assembly 1 Hardware 26 — — M2.5 x 3 SHCS 2* 27 — — M3 x 6 BHCS 2* 28 — — M3 x 8 SHCS 1* 29 — — M3 x 12 SHCS 3* 30 — — M4 x 6 SSS 1* 31 — — M4 x 6 SHCS 1* 32 — — M4 x 8 FHCS 1* 33 — — M4 x 35 SHCS 2* 34 — — M5 x 12 SHCS 1*		63600-5614	63600-5614						
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Feed Pawl 1 Frame 23 63808-0200 63808-0200 Applicator Core 1 24 63808-0191 63808-0191 Track Assembly 1 25 63808-0196 63808-0196 Pneumatic Feed Assembly 1 Hardware 26 — — M2.5 x 3 SHCS 2* 27 — — M3 x 6 BHCS 2* 28 — — M3 x 8 SHCS 1* 29 — — M3 x 12 SHCS 3* 30 — — M4 x 6 SSS 1* 31 — — M4 x 8 FHCS 1* 32 — — M4 x 35 SHCS 2* 34 — — M5 x 12 SHCS 1*	20	63808-0224	63808-0224	Stop Plate					
Frame 23 63808-0200 63808-0200 Applicator Core 1 24 63808-0191 Track Assembly 1 25 63808-0196 Pneumatic Feed Assembly 1 Hardware 26 — — M2.5 x 3 SHCS 2* 27 — — M3 x 6 BHCS 2* 28 — — M3 x 8 SHCS 1* 29 — — M3 x 12 SHCS 3* 30 — — M4 x 6 SSS 1* 31 — — M4 x 6 SHCS 1* 32 — — M4 x 8 FHCS 2* 33 — — M4 x 35 SHCS 2* 34 — — M5 x 12 SHCS 1*		63443-4603	63443-4603	Carrier Cover	1				
23 63808-0200 63808-0200 Applicator Core 1 24 63808-0191 63808-0191 Track Assembly 1 Estimate 1 Estimate 2 63808-0196 Pneumatic Feed Assembly 1 Hardware 26 — — M2.5 x 3 SHCS 2* 27 — — M3 x 6 BHCS 2* 28 — — M3 x 8 SHCS 1* 29 — — M3 x 12 SHCS 3* 30 — — M4 x 6 SSS 1* 31 — — M4 x 8 FHCS 1* 32 — — M4 x 8 FHCS 1* 33 — — M4 x 35 SHCS 2* 34 — — M5 x 12 SHCS 1*	22	63808-0249	63808-0249	Feed Pawl	1				
24 63808-0191 Track Assembly 1 Hardware 26 — — M2.5 x 3 SHCS 2* 27 — — M3 x 6 BHCS 2* 28 — — M3 x 8 SHCS 1* 29 — — M3 x 12 SHCS 3* 30 — — M4 x 6 SSS 1* 31 — — M4 x 8 FHCS 1* 32 — — M4 x 8 FHCS 2* 34 — — M5 x 12 SHCS 1*	Frame								
25 63808-0196 Pneumatic Feed Assembly 1 Hardware 26 — — M2.5 x 3 SHCS 2* 27 — — M3 x 6 BHCS 2* 28 — — M3 x 8 SHCS 1* 29 — — M3 x 12 SHCS 3* 30 — — M4 x 6 SSS 1* 31 — — M4 x 6 SHCS 1* 32 — — M4 x 8 FHCS 1* 33 — — M4 x 35 SHCS 2* 34 — — M5 x 12 SHCS 1*	23	63808-0200	63808-0200	Applicator Core					
Hardware 26 — — M2.5 x 3 SHCS 2* 27 — — M3 x 6 BHCS 2* 28 — — M3 x 8 SHCS 1* 29 — — M3 x 12 SHCS 3* 30 — — M4 x 6 SSS 1* 31 — — M4 x 6 SHCS 1* 32 — — M4 x 8 FHCS 1* 33 — — M4 x 35 SHCS 2* 34 — — M5 x 12 SHCS 1*	_		63808-0191						
26 — — M2.5 x 3 SHCS 2* 27 — — M3 x 6 BHCS 2* 28 — — M3 x 8 SHCS 1* 29 — — M3 x 12 SHCS 3* 30 — — M4 x 6 SSS 1* 31 — — M4 x 6 SHCS 1* 32 — — M4 x 8 FHCS 1* 33 — — M4 x 35 SHCS 2* 34 — — M5 x 12 SHCS 1*	25	63808-0196			1				
27 — — M3 x 6 BHCS 2* 28 — — M3 x 8 SHCS 1* 29 — — M3 x 12 SHCS 3* 30 — — M4 x 6 SSS 1* 31 — — M4 x 6 SHCS 1* 32 — — M4 x 8 FHCS 1* 33 — — M4 x 35 SHCS 2* 34 — — M5 x 12 SHCS 1*			Har						
28 — — M3 x 8 SHCS 1* 29 — — M3 x 12 SHCS 3* 30 — — M4 x 6 SSS 1* 31 — — M4 x 6 SHCS 1* 32 — — M4 x 8 FHCS 1* 33 — — M4 x 35 SHCS 2* 34 — — M5 x 12 SHCS 1*		_	_						
29 — — M3 x 12 SHCS 3* 30 — — M4 x 6 SSS 1* 31 — — M4 x 6 SHCS 1* 32 — — M4 x 8 FHCS 1* 33 — — M4 x 35 SHCS 2* 34 — — M5 x 12 SHCS 1*		_	_						
30 — — M4 x 6 SSS 1* 31 — — M4 x 6 SHCS 1* 32 — — M4 x 8 FHCS 1* 33 — — M4 x 35 SHCS 2* 34 — — M5 x 12 SHCS 1*		_	_						
31 — — M4 x 6 SHCS 1* 32 — — M4 x 8 FHCS 1* 33 — — M4 x 35 SHCS 2* 34 — — M5 x 12 SHCS 1*		_	_						
32 — — M4 x 8 FHCS 1* 33 — — M4 x 35 SHCS 2* 34 — — M5 x 12 SHCS 1*		_	_						
33 - - M4 x 35 SHCS 2* 34 - - M5 x 12 SHCS 1*		_	_						
34 M5 x 12 SHCS 1*									
35 — #10-32UNF x .25" BHCS 1*			_						
	35	_	_	#10-32UNF x .25" BHCS	1*				

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

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ASSEMBLY DRAWING



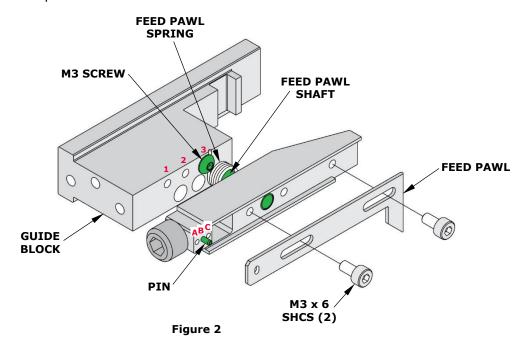
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FACTORY SETTINGS

Feed Pawl Assembly

The FA2 applicator number 213069-0110 ships with the following factory settings. See Figure 2:

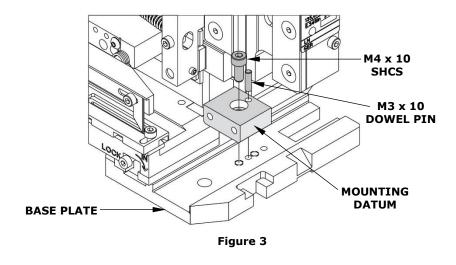
- The feed pawl shaft and M3 screw that holds the feed pawl spring are in position 3.
- The pin is in position B.



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

Mounting Datum Location

This applicator was assembled and tested by Molex with the mounting datum in the location shown in Figure 3. Do not remove the mounting datum.



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PNEUMATIC CONNECTION (AIR FEED)

- The pneumatic feed applicator uses a double-acting air cylinder that must be actuated by a 4-way pneumatic valve.
- The air cylinder is equipped with push-in fittings for 6mm diameter vinyl or Nylon tube. Adapters are included for ¼" diameter and 4mm diameter vinyl or Nylon tube.

Note: The TM-3000 and TM-4000 presses have pneumatic valves with $\frac{1}{4}$ " diameter tube fittings. Be sure to install the $\frac{1}{4}$ " diameter adapters in the air cylinder fittings and use $\frac{1}{4}$ " diameter vinyl or Nylon tube.

- Pneumatic tubes must be connected as shown in Figure 4. Tubes are typically connected so the terminal feed is forward when the applicator ram is up.
- When using the TM-3000 or TM-4000 presses, connect the tubes to the press pneumatic valve as shown in Figure 5.

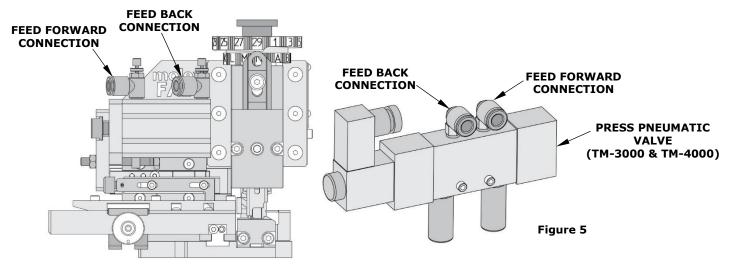


Figure 4

Application Tooling Support

Phone: (402) 458-TOOL (8665)
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Website: www.molex.com/applicationtooling

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