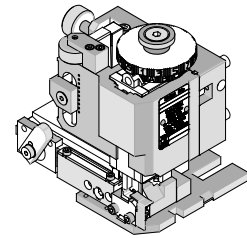




**FineAdjust  
Applicator**

**Application Tooling  
Specification Sheet**



**Order No. 63903-8400**

**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 shut height 135.80mm (5.346")
- Quick set-up 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 .015mm (.0006") for conductor crimp height and .063mm (.0025") for insulation height
- Independent adjustment rings allow users to quickly adjust the conductor or insulation crimp height without affecting each other

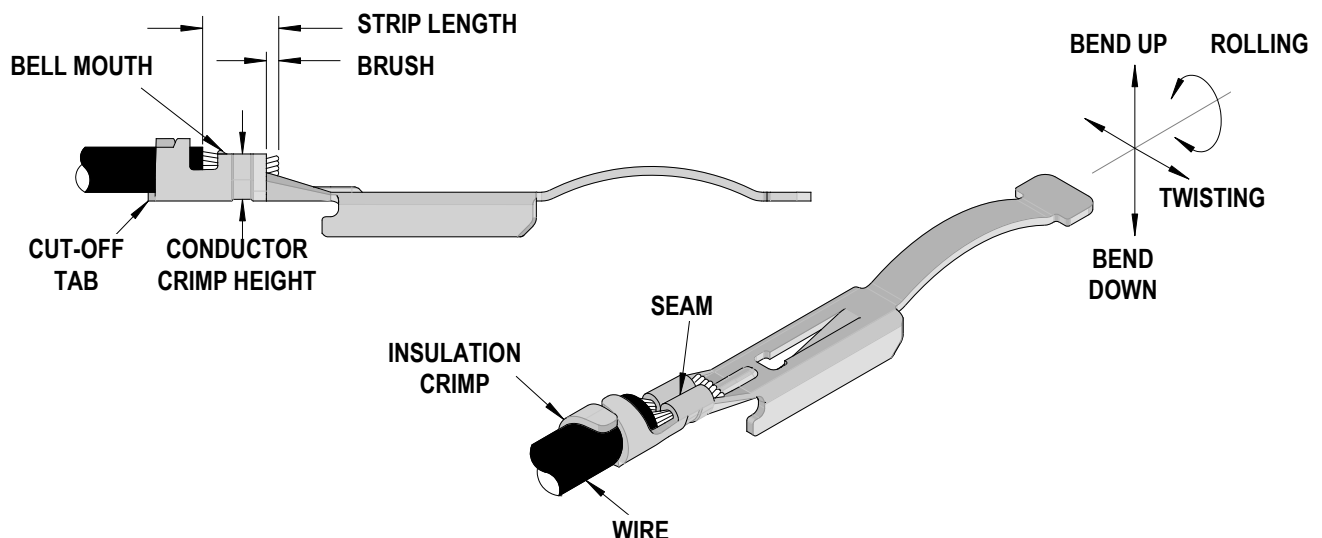
**SCOPE**

Products: Male and Female Terminal Ditto "Wing" Interconnects, 20-22 AWG.

Terminal Series No.	Terminal Order No.	Wire Size		Insulation Diameter				Strip Length	
				IPC/WHMA-A620 (1)		Terminal (2)			
		AWG	mm <sup>2</sup>	mm	In.	mm	In.	mm	In.
150197	150197-0001	20-22	0.50-0.35	1.45-1.70	.057-.067	1.35-1.70	.053-.067	2.30-2.80	.091-.110
150200	150200-0001	20-22	0.50-0.35	1.45-1.70	.057-.067	1.35-1.70	.053-.067	2.30-2.80	.091-.110

(1) To achieve optimum IPC-A620 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.
150197	0.10-1.00	.004-.039	0.50	.020	0.20-1.00	.008-.039
150200						

Terminal Series No.	Bend up Bend down		Twist	Roll	Punch Width mm (Ref)				Seam
	Degree				Degree		Conductor		
	mm	In	mm	In	mm	In	mm	In	
150197	3	3	4	8	1.70	.067	1.90	.075	Seam shall not be open and no wire allowed out of the crimping area
150200									

After crimping, the conductor profile should measure the following.

Terminal Series No.	Wire Size		Conductor				Pull Force Minimum	
			Crimp Height		Crimp Width (Ref)			
	AWG	mm <sup>2</sup>	mm	In.	mm	In.	N	Lb.
150197	20	0.50	1.10-1.20	.043-.047	1.75	.069	36.0	8.09
	22	0.35	1.00-1.10	.039-0.43	1.75	.069	36.0	8.09
150200	20	0.50	1.10-1.20	.043-.047	1.75	.069	36.0	8.09
	22	0.35	1.00-1.10	.039-0.43	1.75	.069	36.0	8.09

Terminal Series No.	Wire Size		Insulation			
			Crimp Height (Maximum)		Crimp Width (Ref.)	
	AWG	mm <sup>2</sup>	mm	In.	mm	In.
150197	20	0.50	2.10	.083	2.00	.079
	22	0.35	2.10	.083	2.00	.079
150200	20	0.50	2.10	.083	2.00	.079
	22	0.35	2.10	.083	2.00	.079

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.

**PARTS LIST**

<b>FineAdjust Applicator 63903-8400</b>				
<b>Item</b>	<b>Order No</b>	<b>Engineering No.</b>	<b>Description</b>	<b>Quantity</b>
<b>Perishable Tooling</b>				
	63903-8470	63903-8470	Tool Kit (All "Y" Items)	REF
1	63444-1709	63444-1709	Conductor Punch	1 Y
2	63445-1735	63445-1735	Conductor Anvil	1 Y
3	63454-1904	63454-1904	Insulation Punch	1 Y
4	63445-1918	63445-1918	Insulation Anvil	1 Y
5	63443-0005	63443-0005	Cut-Off Plunger Front	1 Y
6	63443-0012	63443-0012	Plunger Retainer Front	1 Y
<b>Other Components</b>				
7	11-17-0022	1739-21	Hold-Down Spring	1
8	11-18-4083	60707-8	Front Cover	1
9	11-24-1067	4996-4	Cut-off Plunger Spring	1
10	63443-0009	63443-0009	Scrap Chute Front	1
11	63443-0024	63443-0024	Lower Tooling Key	1
12	63443-0090	63443-0090	Wire Stop	1
13	63443-0093	63443-0093	Shank	1
14	63443-1708	63443-1708	Height Spacer (17.80mm)	1
15	63443-2216	63443-2216	Coarse Spacer (16.0mm)	1
16	63443-2305	63443-2305	Fine Spacer (3.25mm)	1
17	63443-2805	63443-2805	Plunger Striker Front	1
18	63443-2906	63443-2906	Wire Hold-Down Plunger	1
19	63443-6113	63443-6113	Rear Cover	1
20	63443-7128	63443-7128	Terminal Hold-Down	1
21	63600-0021	63600-0021	Wire Hold-Down Spring	1
<b>Frame</b>				
22	63800-4901	63800-4901	Top	1
23	63801-3281	63801-3281	Base	1
24	63801-4650	63801-4650	Track	1
<b>Hardware</b>				
25	N/A	N/A	M3 by 6 Long FHCS	1**
26	N/A	N/A	M3 by 6 Long SHCS	2**
27	N/A	N/A	M3 by 8 Long SHCS	1**
28	N/A	N/A	M4 by 6 Long SHCS	2**
29	N/A	N/A	M4 by 12 Long BHCS	2**
30	N/A	N/A	M4 by 50 Long SHCS	2**
31	N/A	N/A	M5 by 12 Long SHCS	1**
32	N/A	N/A	#10-32 by 3/8" Long Flat Point SSS	1**
33	N/A	N/A	#10-32 Hex Jam Nut	1**
** Available from an industrial supply company such as MSC (1-800-645-7270).				

# Assembly Drawing

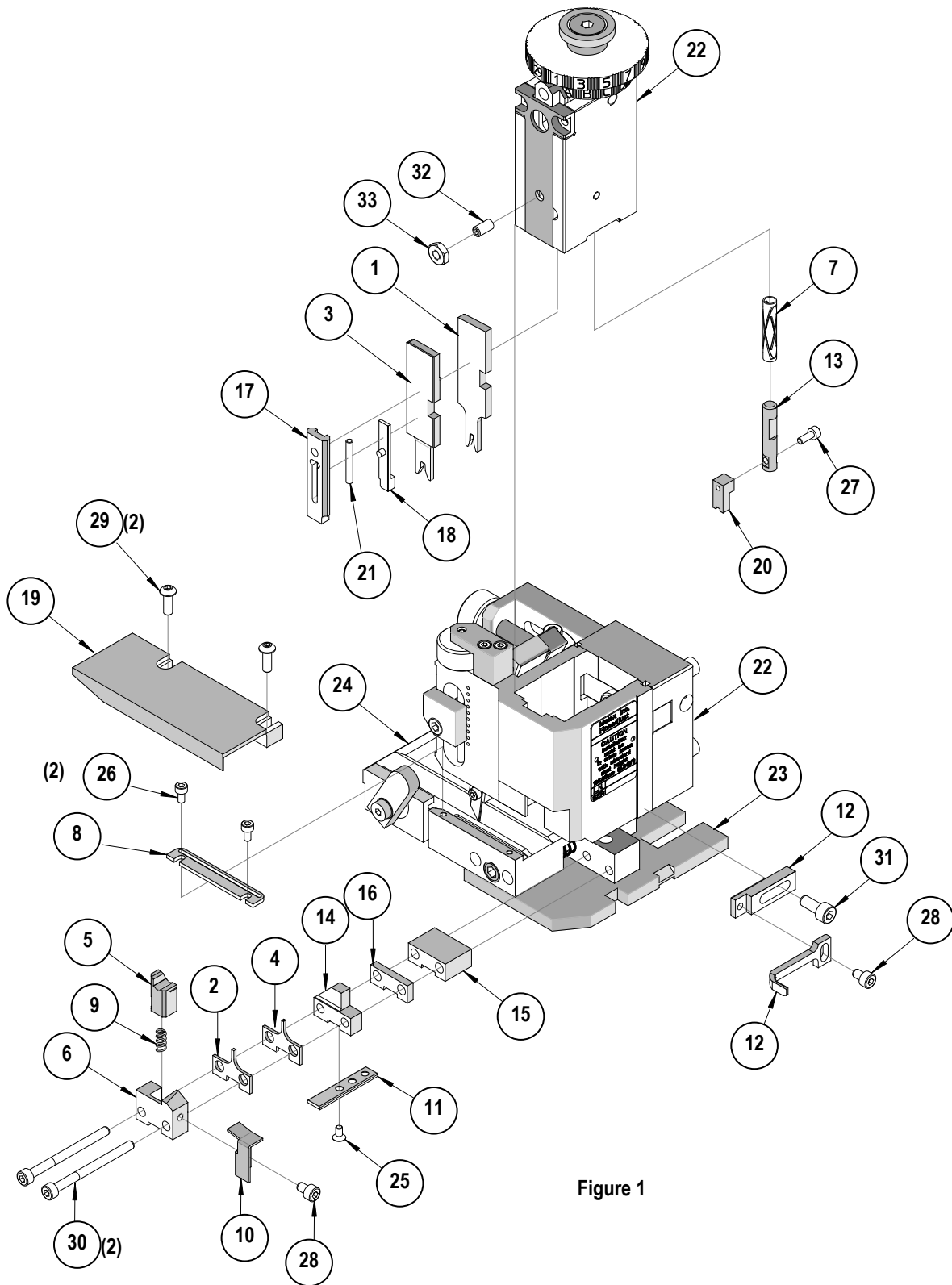


Figure 1

## NOTES

1. Molex recommends 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 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.

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