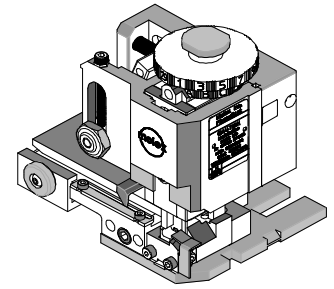




## FineAdjust Applicator Specification Sheet Part No. 63866-3000



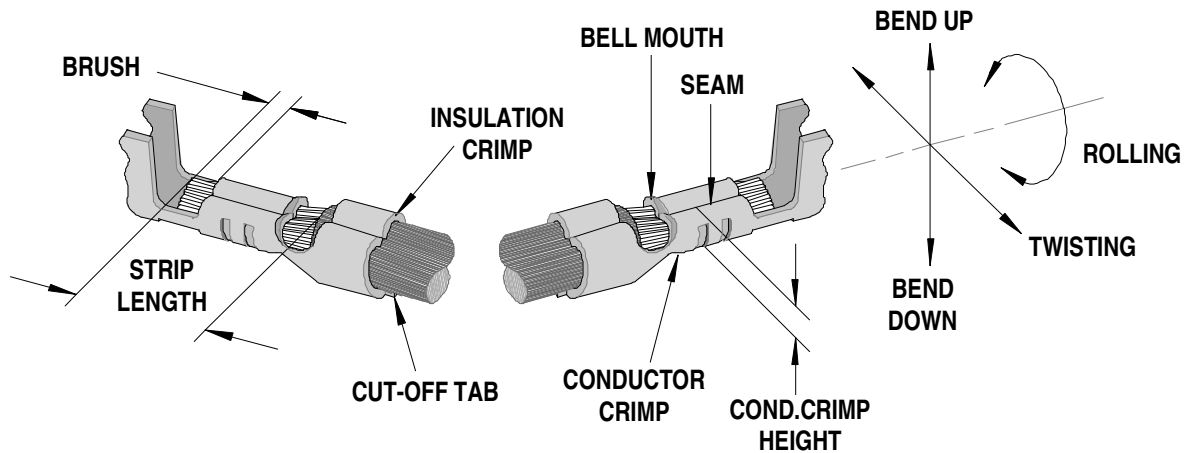
### FEATURES

- 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 0.15mm (.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
- Directly adapts to most automatic wire processing machines

### SCOPE

Terminal Series No.	Wire Size		Insulation Diameter		Strip Length	
	AWG	mm <sup>2</sup>	mm	In.	mm	In.
42023-****	14-16	2.00-1.30	2.28-3.30	.090-.130	3.96-5.54	.156-.218
42024-****	14-16	2.00-1.30	2.28-3.30	.090-.130	3.96-5.54	.156-.218

### 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.
42023-****	.25-.51	.010-.020	.13	.005	.38-.70	.015-.027
42024-****	.25-.51	.010-.020	.13	.005	.38-.70	.015-.027

Terminal Series No.	Bend up	Bend down	Twist	Roll	Punch Width mm (Ref)				Seam Seam shall not be open and no wire allowed out of the crimping area
	Degree		Degree		Conductor		Insulation		
					mm	In	mm	In	
42023-****	3	3	4	8	2.30	.090	3.60	.142	
42024-****	3	3	4	8	2.30	.090	3.60	.142	

After crimping, the conductor profile should measure the following.

Terminal Series No.	Wire Size		Conductor Crimp				Pull Force Minimum	
	AWG	mm <sub>2</sub>	Height		Width		N	Lb.
			mm	In	mm	In		
42023-****	14	2.00	1.70-1.80	.067-.071	2.33-2.53	.092-.100	222.4	50.0
42023-****	16	1.30	1.45-1.55	.057-.061	2.31-2.51	.091-.099	200.2	45.0
42024-****	14	2.00	1.70-1.80	.067-.071	2.33-2.53	.092-.100	222.4	50.0
42024-****	16	1.30	1.45-1.55	.057-.061	2.31-2.51	.091-.099	200.2	45.0

Pull Force should be measured with no influence from the insulation crimp.

The above specifications are guidelines to an optimum crimp.

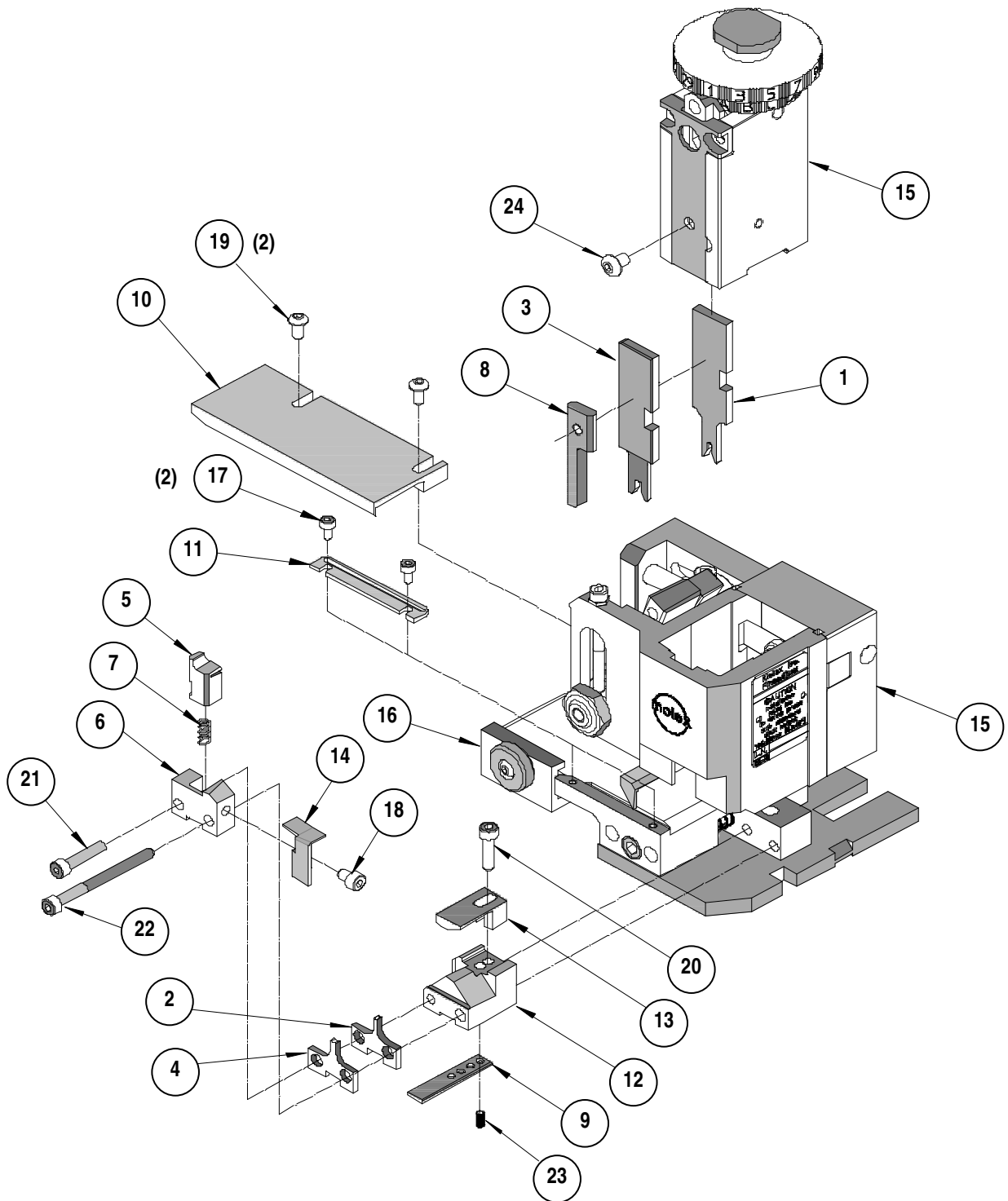
**PARTS LIST**

Item	Order No	Engineering No.	Description	Quantity
	<b>63866-3000</b>	<b>63866-3000</b>	<b>FineAdjust Applicator (Fig. 1)</b>	<b>REF</b>
1	63444-2313	63444-2313	Conductor Punch	1 Y
2	63445-2343	63445-2343	Conductor Anvil	1 Y
3	63446-3622	63446-3622	Insulation Punch	1 Y
4	63445-3643	63445-3643	Insulation Anvil	1 Y
5	63443-0002	63443-0002	Cut-Off Plunger	1 Y
6	63443-0012	63443-0012	Front Plunger Retainer	1 Y
7	11-24-1067	4996-4	Cut-off Plunger Spring	1
8	63443-3160	63443-3160	Front Plunger Striker	1
9	63443-0021	63443-0021	Lower Tooling Key	1
10	63443-6011	63443-6011	Rear Cover	1
11	11-18-4083	60707-8	Front Cover	1
12	63443-2415	63443-2415	Anvil Mount	1
13	63443-4006	63443-4006	Wire Stop	1
14	63443-0009	63443-0009	Scrape Chute	1
15	63800-4900	63800-4900	Fine Adjust Applicator Frame	1
16	63860-2015	63860-2015	* Drag Frame (Modified)	1
17	N/A	N/A	M3 by 6Lg. SHCS	2**
18	N/A	N/A	M4 by 6Lg. SHCS	1**
19	N/A	N/A	M4 by 12Lg. BHCS	2**
20	N/A	N/A	M4 by 16Lg SHCS	1**
21	N/A	N/A	M4 by 20Lg. SHCS	1**
22	N/A	N/A	M4 by 50Lg. SHCS	1**
23	N/A	N/A	3MM by 6Lg. Roll Pin	1**
24	N/A	N/A	#10-32 by 1/4"Lg. BHCS	1**
	63866-3070	63866-3070	Tool Kit (All Y Items)	REF

\* Frame part - To be modified.

\*\* The following purchased parts are available from an Industrial supply company such as MSC (1-800-645-7270).

# Assembly Drawing



## 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 135.8 mm (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

**CAUTION:** Molex crimp specifications are valid only when used with Molex terminals, applicators and

### **Molex Application Tooling Group**

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