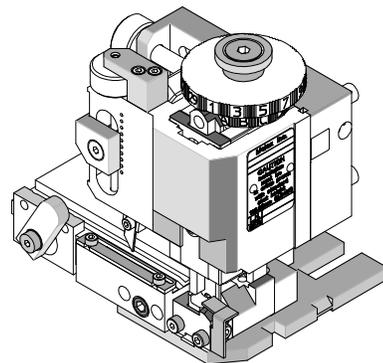




# FineAdjust Applicator Specification Sheet Order No. 63900-8200



## FEATURES

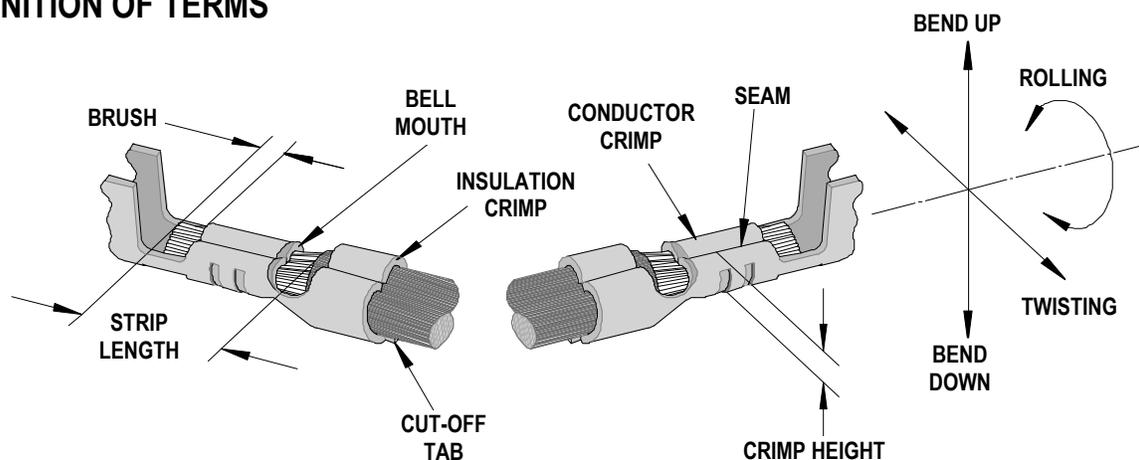
- Directly adapts to most automatic wire processing machines
- Quick punch removal with the push of a button for fast and easy tooling change
- Applicator designed to industry standard mounting and shut height 135.80mm (5.346")
- Quick set-up time; plus the crimp height, track and feed adjustments can 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: MX150L™ Male and Female Terminal for 14-16 AWG Wire.

Terminal Series No	Terminal Order No.		Wire Size		Insulation Diameter		Strip Length	
			AWG	mm <sup>2</sup>	mm	In.	mm	In.
19417	19417-0011	Male (Tin)	14-16	2.00-1.27	2.87-3.53	.113-.139	4.20-5.00	.165-.197
	19417-0025	Male (Gold)	14-16	2.00-1.27	2.87-3.53	.113-.139	4.20-5.00	.165-.197
	19417-0027	Male (Tin) Long	14-16	2.00-1.27	2.87-3.53	.113-.139	4.20-5.00	.165-.197
	19417-0029	Male (Gold) Long	14-16	2.00-1.27	2.87-3.53	.113-.139	4.20-5.00	.165-.197
19420	19420-0001	Female (Tin)	14-16	2.00-1.27	2.87-3.53	.113-.139	4.20-5.00	.165-.197
	19420-0003	Female (Gold)	14-16	2.00-1.27	2.87-3.53	.113-.139	4.20-5.00	.165-.197

## 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.
19417	0.25-1.25	.010-.049	0.50	.020	0.15-0.65	.006-.026
19420	0.25-1.25	.010-.049	0.50	.020	0.15-0.65	.006-.026

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.	
19417	5	5	4	8	2.50	.098	4.30	.169	
19420	5	5	4	8	2.50	.098	4.30	.169	

After crimping, the conductor profile should measure the following.

Terminal Series No.	Wire Size		Conductor Crimp Height		Insulation Crimp Height Maximum		Pull Force Minimum	
	AWG	mm <sup>2</sup>	mm	In.	Mm (Ref)	In. (Ref)	N	Lb.
19417	14	2.00	1.65-1.75	.065-.069	3.40	.130	222.6	50.00
	16	1.27	1.60-1.70	.063-.067	3.40	.130	133.5	30.00
19420	14	2.00	1.45-1.55	.057-.061	3.40	.130	222.6	50.00
	16	1.27	1.40-1.50	.055-.059	3.40	.130	133.5	30.00

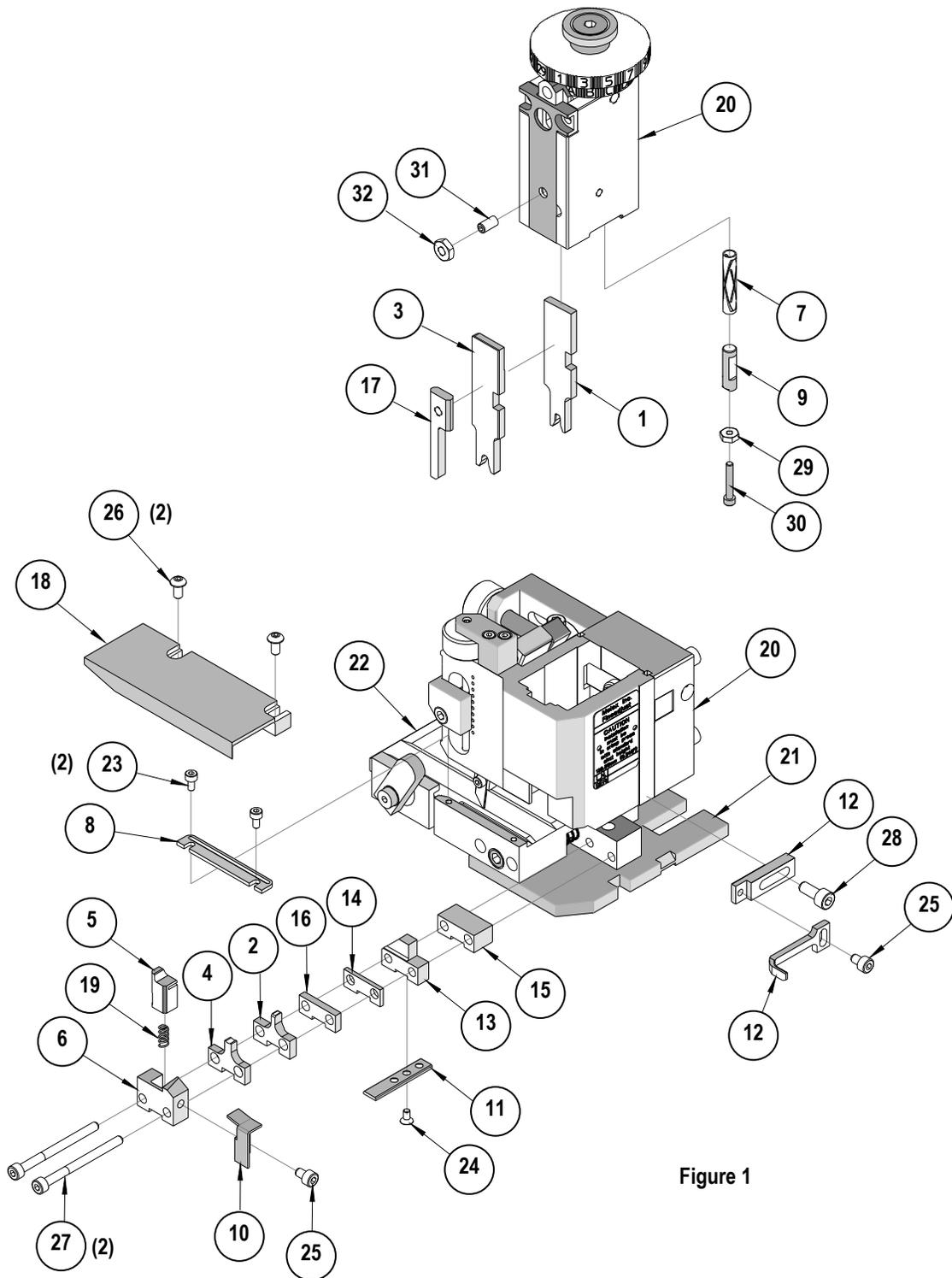
Pull Force should be measured with no influence from the insulation crimp.

The above specifications are guidelines to an optimum crimp.

**PARTS LIST**

<b>FineAdjust Applicator 63900-8200</b>				
<b>Item</b>	<b>Order No</b>	<b>Engineering No.</b>	<b>Description</b>	<b>Quantity</b>
<b>Perishable Tooling</b>				
	63900-8270	63900-8270	Tool Kit (All "Y" Items)	REF
1	63444-2524	63444-2524	Conductor Punch	1 Y
2	63455-2501	63455-2501	Conductor Anvil	1 Y
3	63460-4301	63460-4301	Insulation Punch	1 Y
4	63445-4322	63445-4322	Insulation Anvil	1 Y
5	63443-0035	63443-0035	Front Cut-Off Plunger	1 Y
6	63443-0036	63443-0036	Front Plunger Retainer	1 Y
<b>Other Components(REF 008250)</b>				
7	11-17-0022	1739-21	Hold Down Spring	1
8	11-18-4083	60707-8	Feed Guide	1
9	11-24-1149	4996-37	Shank	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	63443-1712	63443-1712	18.20mm Height Spacer	1
14	63443-2202	63443-2202	2.00mm Fine Spacer	1
15	63443-2212	63443-2212	12.00mm Coarse Spacer	1
16	63443-2312	63443-2312	3.60mm Fine Spacer	1
17	63443-3160	63443-3160	Front Plunger Striker	1
18	63443-6121	63443-6121	Rear Cover	1
19	63700-0539	63700-0539	Cut-Off Plunger Spring	1
<b>Frame</b>				
20	63800-4901	63800-4901	Top	1
21	63801-3281	63801-3281	Base	1
22	63801-4650	63801-4650	Track	1
<b>Hardware</b>				
23	N/A	N/A	M3 by 6 Long SHCS	2**
24	N/A	N/A	M3 by 6 Long FHCS	1**
25	N/A	N/A	M4 by 6 Long SHCS	2**
26	N/A	N/A	M4 by 12 Long BHCS	2**
27	N/A	N/A	M4 by 50 Long SHCS	2**
28	N/A	N/A	M5 by 12 Long SHCS	1**
29	N/A	N/A	#5-40 Hex Nut	1**
30	N/A	N/A	#5-40 by 1/2 Long SHCS	1**
31	N/A	N/A	#10-32 by 3/8" Long Flat Point SSS	1**
32	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



## 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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