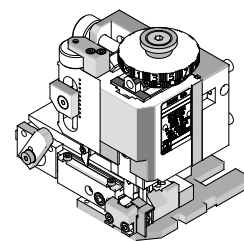




**FineAdjust
Applicator**

**Application Tooling
Specification Sheet**



Order No. 63903-9100

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

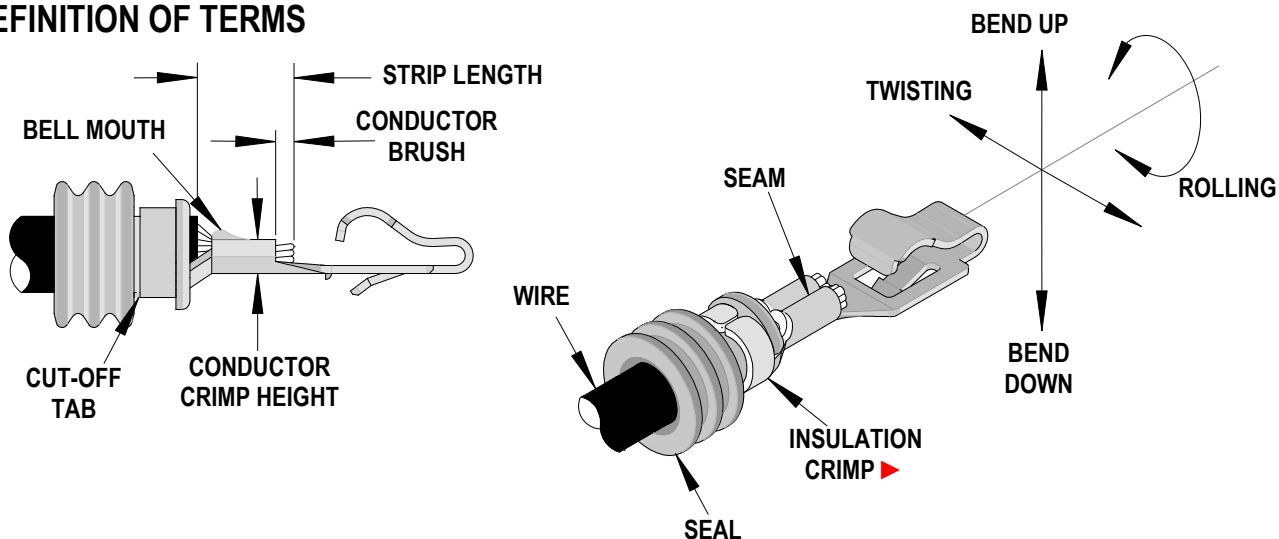
SCOPE

Products: Sealed Single Contact Terminal for S8 and T20 Socket, AVS 0.50mm² & 0.85mm² and FLRY-A 0.75mm².

Terminal Series No.	Terminal Order No.	Wire Size and Type		Insulation Diameter		Strip Length	
				Terminal (1)			
		Type	mm ²	mm	In.	mm	In.
49869	49869-9702	AVS	0.5	2.0 – 2.1	.078 – .083	5.0 – 5.5	0.20 – 0.22
		FLRY-A	0.75	1.7 – 1.9	.067 – .075		
		AVS	0.85	2.2 – 2.3	.087 – .091		

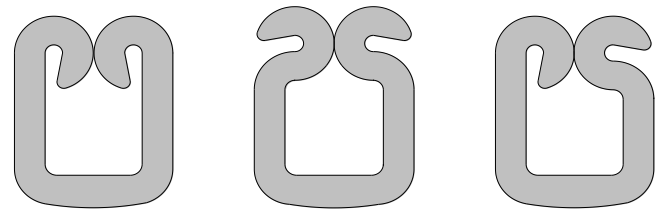
(1) Overall insulation OD specification for terminal.

DEFINITION OF TERMS



► INSULATION CRIMP FORM

This crimp terminal is designed for miniaturization; therefore, each dimension of insulation crimp portion appears small as compared to the terminal material thickness. In order to avoid insulation piercing the crimp forms by the insulation barrel, coining is provided inside of the insulation barrel. For this reason, various crimp forms will occur at the tip of the insulation crimp barrel shown in the figure below.



These crimp forms maybe changed completely by a small change in the wire, insulation punch, or terminal.

These crimp forms are satisfactory for original function of the insulation crimp portion and it is confirmed that all of these forms below are acceptable insulation crimps.

CRIMP SPECIFICATION

Terminal Series No.	Bell mouth		Cut-off Tab Maximum		Conductor Brush	
	mm	In.	mm	In.	mm	In.
49869	0.30-0.60	.012-.024	0.25	.010	0.30-0.80	.012-.031

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
					Conductor		Insulation		
	Degree		Degree		mm	In	mm	In	
49869	3	3	3	5	2.10	.083	4.30	.169	

After crimping, the conductor profile should measure the following.

Terminal Series No.	Wire Size		Conductor Crimp Height		Pull Force Minimum	
	Type	mm ²	mm	In.	N	Lb.
49869	AVS	0.50	1.35-1.45	.053-.057	88.5	19.9
	FLRY-A	0.75	1.45-1.50	.057-.059	105.0	23.6
	AVS	0.85	1.45-1.55	.057-.061	127.5	28.7

Terminal Series No.	Wire Size		Insulation Diameter		Single Wire Seal		Seal Crimp			
	Type	mm ²	mm	In.	Order No.	Color	Crimp Height		Crimp Width	
							mm	In.	mm	In.
49869	AVS	0.50	2.0-2.1	.078-.083	49454-9002	Red	4.00 (Max.)	.157 (Max.)	4.20-4.40	.165-.173
	FLRY-A	0.75	1.7-1.9	.067-.075						
	AVS	0.85	2.2-2.3	.087-.091						

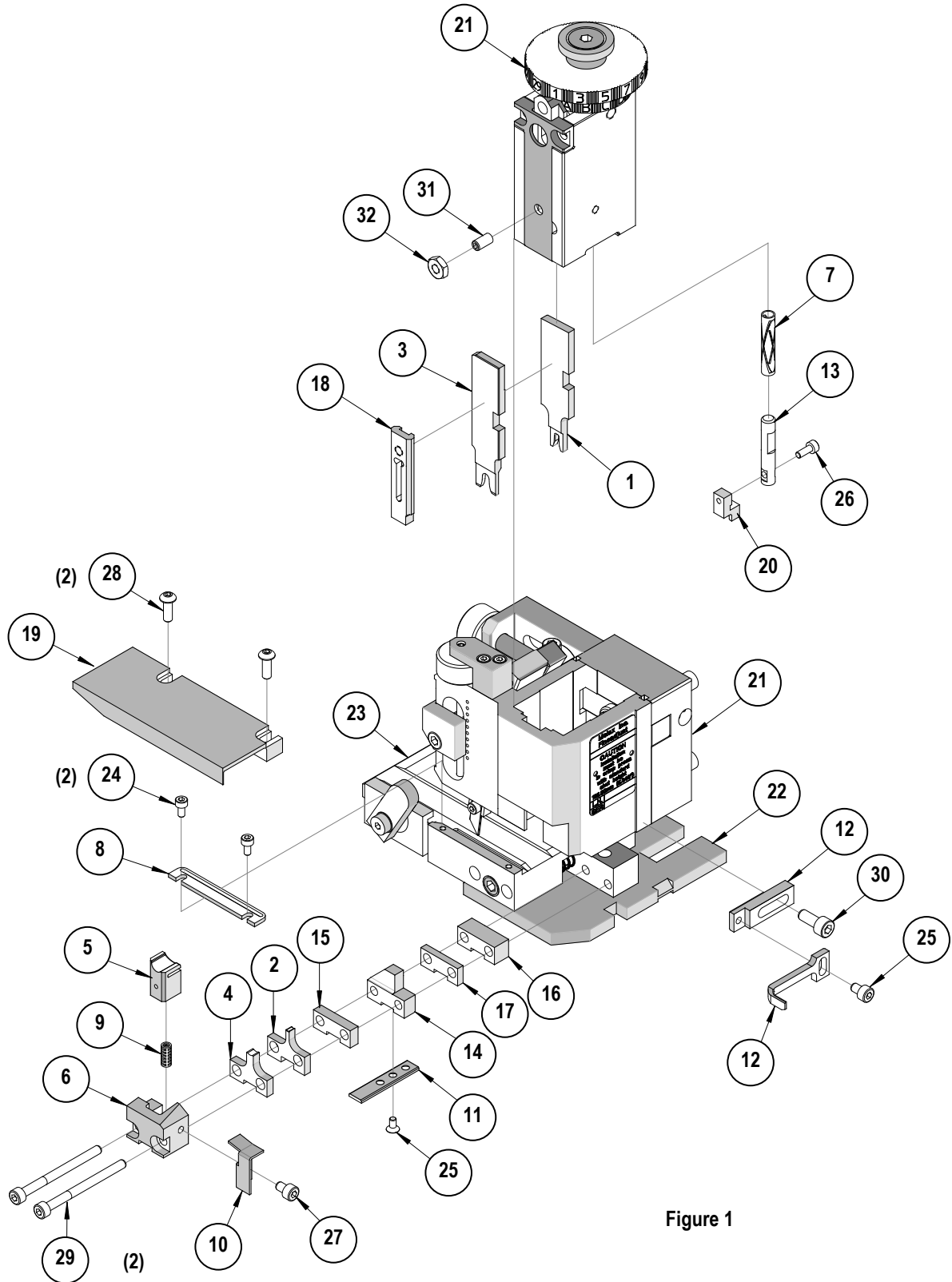
Tool Qualification Notes:

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

FineAdjust Applicator 63903-9100				
Item	Order No	Engineering No.	Description	Quantity
Perishable Tooling				
	63903-9170	63903-9170	Tool Kit (All "Y" Items)	REF
1	63457-2103	63457-2103	Conductor Punch	1 Y
2	63445-2149	63445-2149	Conductor Anvil	1 Y
3	63454-4301	63454-4301	Insulation Punch	1 Y
4	63456-4304	63456-4304	Insulation Anvil	1 Y
5	63443-0037	63443-0037	Cut-Off Plunger	1 Y
6	63443-0038	63443-0038	Front Plunger Retainer	1 Y
Other Components				
7	11-17-0022	1739-21	Terminal Hold Down Spring	1
8	11-18-4083	60707-8	Feed Guide	1
9	63700-0539	63700-0539	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	63443-0093	63443-0093	Terminal Hold Down Shank	1
14	63443-1720	63443-1720	Height Spacer (19.00mm)	1
15	63443-2205	63443-2205	Coarse Spacer (5.00mm)	1
16	63443-2209	63443-2209	Coarse Spacer (9.00mm)	1
17	63443-2310	63443-2310	Fine Spacer (3.45mm)	1
18	63443-2804	63443-2804	Front Plunger Striker	1
19	63443-6125	63443-6125	Rear Cover	1
20	63443-7130	63443-7130	Terminal Hold Down	1
Frame				
21	63800-4901	63800-4901	Top	1
22	63801-3281	63801-3281	Base	1
23	63801-4650	63801-4650	Track	1
Hardware				
24	N/A	N/A	M3 by 6 Long SHCS	2**
25	N/A	N/A	M3 by 6 Long FHCS	1**
26	N/A	N/A	M3 by 8 Long SHCS	1**
27	N/A	N/A	M4 by 6 Long SHCS	2**
28	N/A	N/A	M4 by 12 Long BHCS	2**
29	N/A	N/A	M4 by 50 Long SHCS	2**
30	N/A	N/A	M5 by 12 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 135.80 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 manual.

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

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