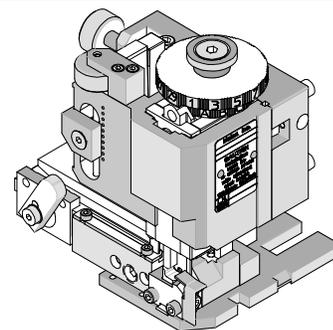




# FineAdjust Applicator Specification Sheet Order No. 63901-1900



## 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

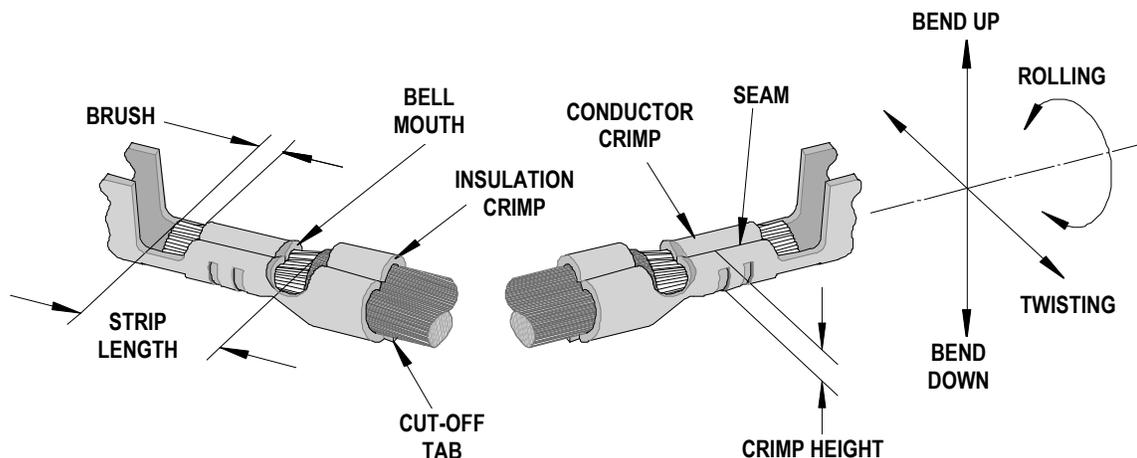
## SCOPE

Products: Wire to Motor Connector Crimp Terminals, 0.30-0.50mm<sup>2</sup>.

Terminal Series No.	Terminal Order No.	Wire Size		Insulation Diameter				Strip Length	
				IPC/WHMA-A620 ♦		Terminal ♦♦			
		AWG	mm <sup>2</sup>	mm	In.	mm	In.	mm	In.
59323	59323-8000	N/A	0.30-0.50	1.40-1.80	.055-.071	1.10-1.90	.043-.075	2.00-2.60	.079-.102

♦ To achieve optimum IPC-A620 insulation crimps, use this insulation OD range.  
♦♦ Overall insulation OD specification for terminal.

## 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.
59323	0.10-0.50	.004-.020	0.30	.012	0.00-1.00	0.00-.039

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	mm	In	mm	In	
59323	4	4	4	10	1.60	.063	2.00	.079	

After crimping, the conductor profile should measure the following.

Terminal Series No.	Wire Size	mm <sup>2</sup>	Wire Type	Conductor Crimp				Pull Force Minimum	
				Crimp Height		Crimp Width (Ref.)		N	Lb.
				mm	In.	mm	In.		
59323		0.30	AVSS	0.94-0.99	.037-.039	1.60	.063	49.0	11.0
		0.30	CAVUS	0.94-0.99	.037-.039	1.60	.063	49.0	11.0
		0.30	AVS	0.94-0.99	.037-.039	1.60	.063	49.0	11.0
		0.50	CAVS	0.99-1.09	.039-.043	1.60	.063	49.0	11.0

Terminal Series No.	Wire Size	mm <sup>2</sup>	Wire Type	Insulation			
				Crimp Height (Ref.)		Crimp Width (Ref.)	
				mm	In.	mm	In.
59323		0.30	AVSS	1.90	.075	2.00	.079
		0.30	CAVUS	1.90	.075	2.00	.079
		0.30	AVS	2.05	.081	2.00	.079
		0.50	CAVS	2.10	.083	2.00	.079

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 63901-1900</b>				
<b>Item</b>	<b>Order No</b>	<b>Engineering No.</b>	<b>Description</b>	<b>Quantity</b>
<b>Perishable Tooling</b>				
	63901-1970	63901-1970	Tool Kit (All "Y" Items)	REF
1	63444-1622	63444-1622	Conductor Punch	1 Y
2	63445-1657	63445-1657	Conductor Anvil	1 Y
3	63446-2038	63446-2038	Insulation Punch	1 Y
4	63445-2006	63445-2006	Insulation Anvil	1 Y
5	63443-0003	63443-0003	Front Cut-Off Plunger	1 Y
6	63443-0012	63443-0012	Front Plunger Retainer	1 Y
<b>Other Components(REF 011950)</b>				
7	11-18-4083	60707-8	Feed Guide	1
8	11-24-1067	4996-4	Cut-Off Plunger Spring	1
9	63443-0009	63443-0009	Front Scrap Chute	1
10	63443-0024	63443-0024	Key	1
11	63443-0090	63443-0090	Wire Stop	1
12	63443-2217	63443-2217	17.0mm Coarse Spacer	1
13	63443-2318	63443-2318	3.90mm Fine Spacer	1
14	63443-2601	63443-2601	19.0mm Height Spacer	1
15	63443-2801	63443-2801	Front Plunger Striker	1
16	63443-2907	63443-2907	Wire Hold Down Plunger	1
17	63443-6111	63443-6111	Rear Cover	1
18	63600-0021	63600-0021	Wire Hold Down Spring	1
<b>Frame</b>				
19	63800-4901	63800-4901	Top	1
20	63801-3281	63801-3281	Base	1
21	63801-4650	63801-4650	Track Assembly	1
<b>Hardware</b>				
22	N/A	N/A	M3 by 6 Long SHCS	2**
23	N/A	N/A	M3 by 6 Long FHCS	1**
24	N/A	N/A	M4 by 6 Long SHCS	2**
25	N/A	N/A	M4 by 12 Long BHCS	2**
26	N/A	N/A	M4 by 50 Long SHCS	2**
27	N/A	N/A	M5 by 12 Lg SHCS	1**
28	N/A	N/A	#10-32 by 3/8" Long Flat Point SSS	1**
29	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

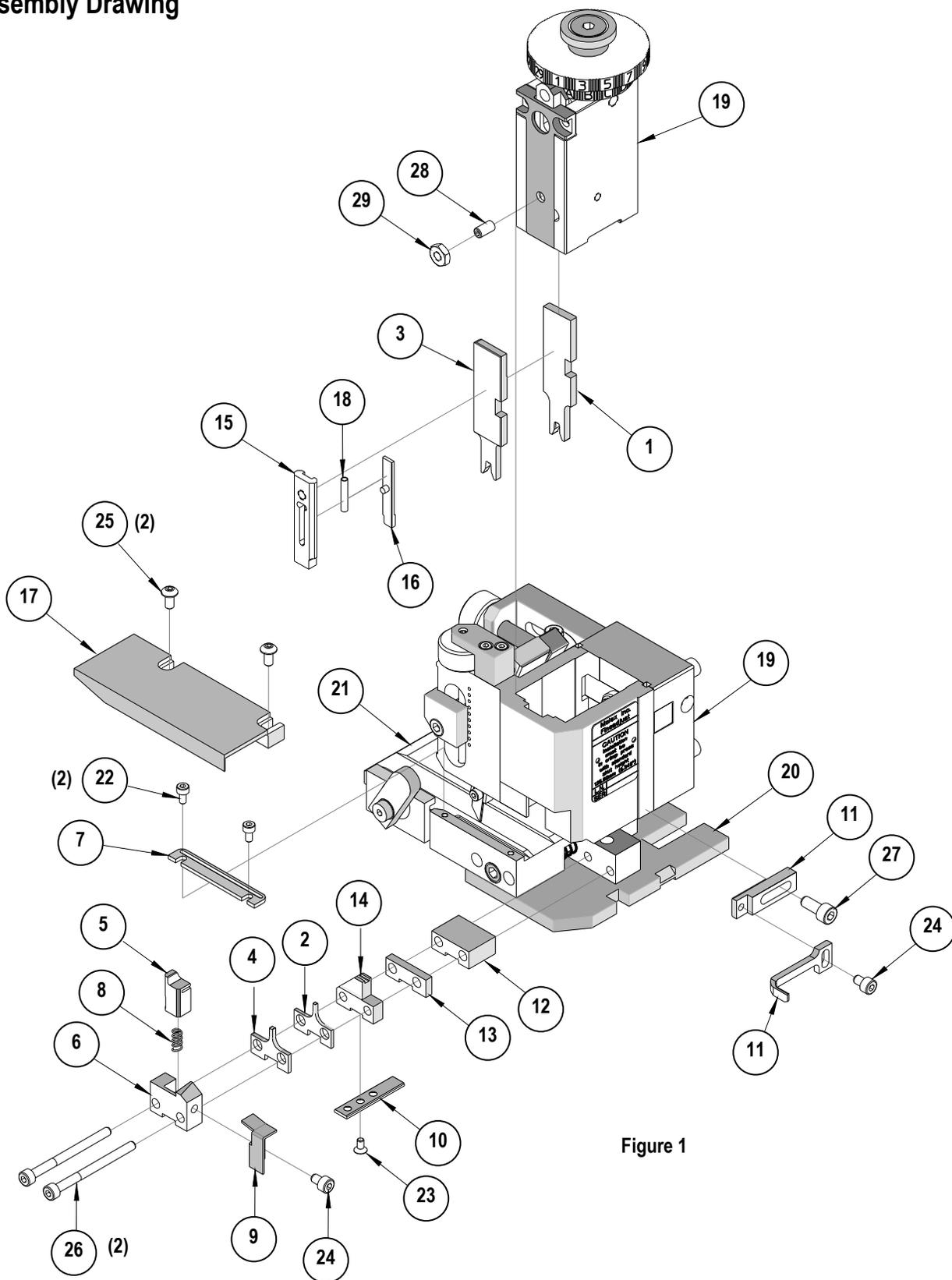


Figure 1

## 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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