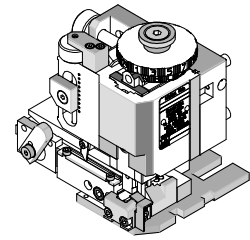


**FineAdjust™
Applicator**



**Application Tooling
Specification Sheet**



Order No. 63903-9700

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 .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
- Directly adapts to most automatic wire processing machines

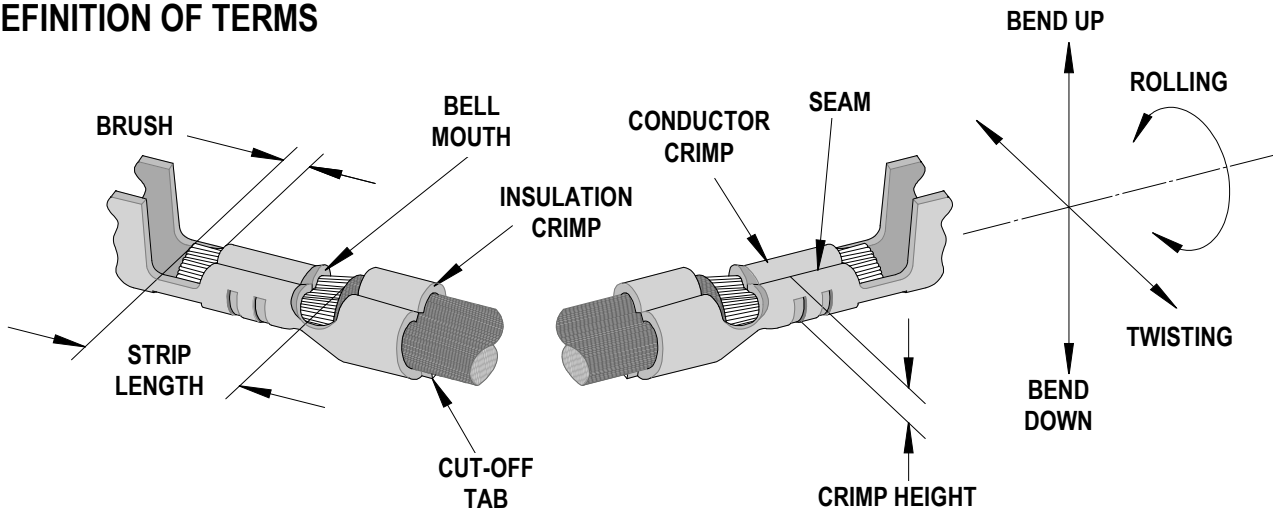
SCOPE

Products: TAK50™ Two Piece Tang Terminal, Large Grip, 0.35mm² conductor wire.

Terminal Series No.	Terminal Order No.	Wire Size		Insulation Diameter		Strip Length	
		AWG	mm ²	mm	In.	mm	In.
200096	2000960101	NA	0.35	1.20 – 1.30	0.047 – 0.051	3.5 – 3.7	0.14 – 0.15

NOTE: Terminal oiler required when crimping terminals to prevent sticking in tooling and to prolong tooling life. Use 63801-7240 oiler or equivalent.

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 Order No.	Bell mouth		Cut-Off Tab Maximum		Conductor Brush	
	mm	In.	mm	In.	mm	In.
2000960101	0.10 – 0.40	0.004 – 0.016	0.20	0.008	0.3 – 0.7	0.012 – 0.028

Terminal Order No.	Bend Up	Bend Down	Twist	Roll	Punch Width (Ref)				Seam
	Degree	Degree			Conductor		Insulation		
			mm	In.	mm	In.			
2000960101	1	1	2	NA	1.07	0.042	1.17	0.046	Seam shall not be open and no wire allowed out of the crimping area.

After crimping, the crimped terminal should measure the following:

Terminal Order No.	Wire Size		Conductor				Pull Force Minimum	
	AWG	mm ²	Crimp Height		Crimp Width (Ref)		N	Lb.
			mm	In.	mm	In.		
2000960101	NA	0.35	0.76 – 0.80	0.030 – 0.032	1.07	0.042	60	13.5

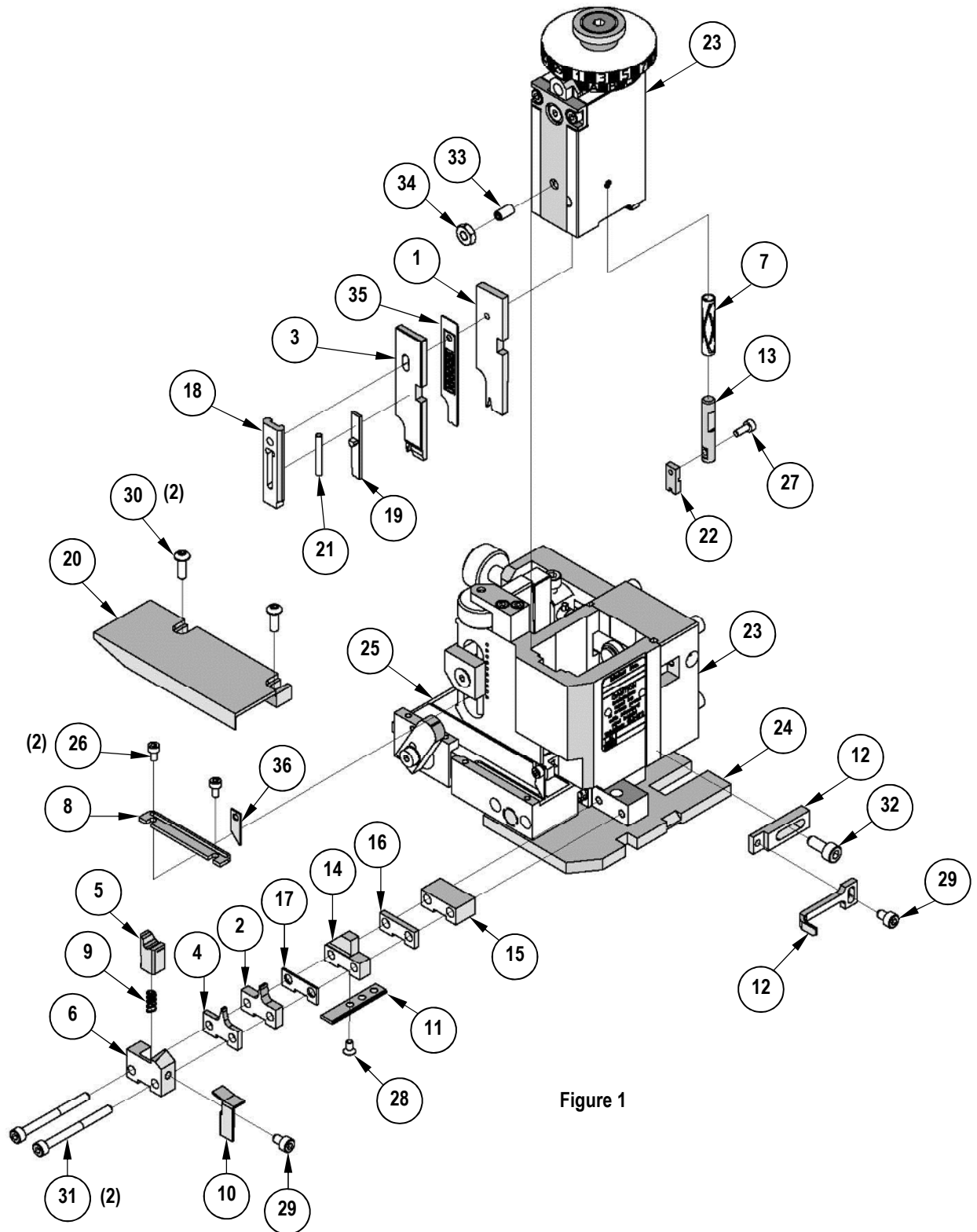
Tool Qualification Notes:

1. Pull force should be measured with no influence from the insulation crimp.
2. The above specifications are guidelines to an optimum crimp.
3. See product specification 2000960001 for additional crimp requirements.

PARTS LIST

FineAdjust™ Applicator 63903-9700				
Item	Order No	Engineering No.	Description	Quantity
Perishable Tooling				
	63903-9770	63903-9770	Tool Kit (All "Y" Items)	REF
1	63457-0112	63457-0112	Conductor Punch	1 Y
35	63443-1170	63443-1170	Wire Pusher	1 Y
2	63455-0139	63455-0139	Conductor Anvil	1 Y
3	63454-0162	63454-0162	Insulation Punch	1 Y
4	63456-0110	63456-0110	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
Other Components				
7	11-17-0022	1739-21	Hold Down Spring	1
8	11-18-4083	60707-8	Feed Guide	1
9	11-24-1067	4996-4	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	Shank	1
14	63443-1716	63443-1716	Height Spacer (18.60mm)	1
15	63443-2213	63443-2213	Coarse Spacer (13.00mm)	1
16	63443-2301	63443-2301	Fine Spacer (3.05mm)	1
17	63443-2201	63443-2201	Coarse Spacer (1.00mm)	1
18	63443-2805	63443-2805	Front Plunger Striker	1
19	63443-2917	63443-2917	Wire Hold-Down Plunger	1
20	63443-6108	63443-6108	Rear Cover	1
21	63600-0021	63600-0021	Striker Plunger Spring	1
22	63443-7125	63443-7125	Terminal Hold Down	1
36	63801-4562	63801-4562	Feed Pawl	1
Frame				
23	63800-4901	63800-4901	Top	1
24	63801-3281	63801-3281	Base	1
25	63801-4650	63801-4650	Track	1
Hardware				
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	M3 by 6 Long FHCS	1**
29	N/A	N/A	M4 by 6 Long SHCS	2**
30	N/A	N/A	M4 by 12 Long BHCS	2**
31	N/A	N/A	M4 by 50 Long SHCS	2**
32	N/A	N/A	M5 by 12 Long SHCS	1**
33	N/A	N/A	#10-32 by 3/8" Long Flat Point SSS	1**
34	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.

Application Tooling Support

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