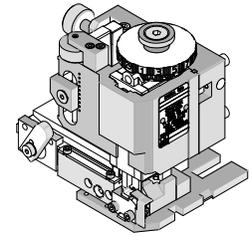**molex®**

FineAdjust Applicator	Application Tooling Specification Sheet

**Order No. 63901-6000**

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: CRC™ (Compact Robot Connector) Power Crimp Pin and Socket Terminals, 18-22 AWG.

Terminal Series No.	Terminal Order No.		Wire Size		Insulation Diameter		Strip Length	
			AWG	mm²	mm	In.	mm	In.
56193	56193-4028	56193-4085	14-18	2.00-0.80	2.60-3.80	.102-.150	3.70-4.10	.146-.161
	56193-4099							
56194	56194-9028	56194-9085	14-18	2.00-0.80	2.60-3.80	.102-.150	3.70-4.10	.146-.161
	56194-9099							

DEFINITION OF TERMS
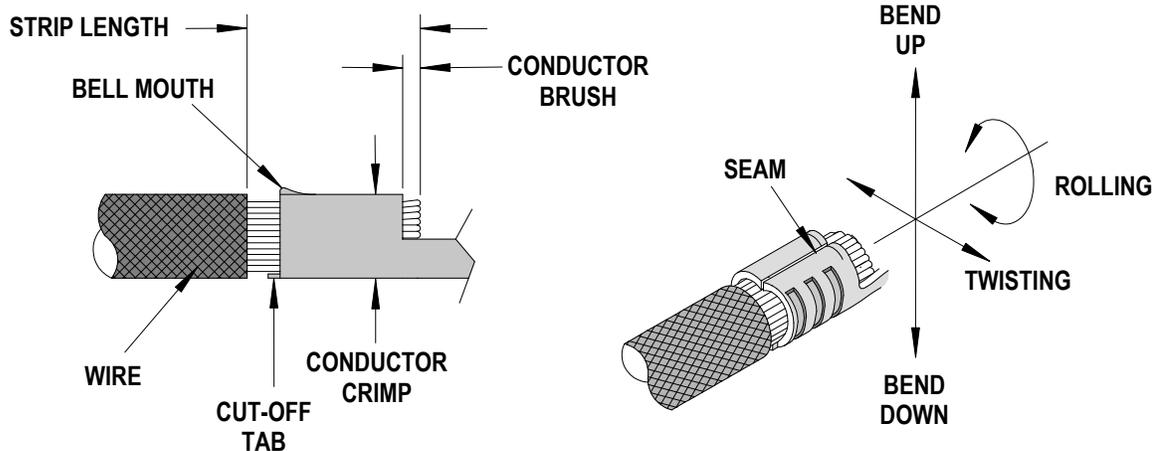
The above terminal drawing is a generic terminal representation. It is not an image of a terminal listed in the scope.

CRIMP SPECIFICATION

Terminal Series No.	Bell mouth		Cut-off Tab Maximum		Conductor Brush	
	mm	In.	mm	In.	mm	In.
56193	0.10-0.50	.004-.020	0.25	.010	0.20-1.00	.008-.039
56194	0.10-0.50	.004-.020	0.25	.010	0.20-1.00	.008-.039

Terminal Series No.	Bend up	Bend down	Twist	Roll	Punch Width mm (Ref) Conductor		Seam Seam shall not be open and no wire allowed out of the crimping area
	Degree (Max)		Degree (Max)		mm	In	
56193	3	3	3	6	2.60	.102	
56194	3	3	3	6	2.60	.102	

After crimping, the conductor profile should measure the following.

Terminal Series No.	Wire Size	Actual mm²	Conductor Crimp				Pull Force Minimum	
			Crimp Height		Crimp Width (Ref.)			
			mm	In.	mm	In.	N	Lb.
56193	14 AWG	2.00	1.41-1.51	.056-.059	2.65	.104	147.0	33.05
	16 AWG	1.30	1.39-1.49	.055-.058	2.65	.104	127.4	28.64
	18 AWG	0.80	1.20-1.30	.047-.051	2.65	.104	88.2	19.83
56194	14 AWG	2.00	1.41-1.51	.056-.059	2.65	.104	147.0	33.05
	16 AWG	1.30	1.39-1.49	.055-.058	2.65	.104	127.4	28.64
	18 AWG	0.80	1.20-1.30	.047-.051	2.65	.104	88.2	19.83

Tool Qualification Notes:

1. The above specifications are guidelines to an optimum crimp.

PARTS LIST

| Item	Order No	Engineering No.	Description	Quantity
**FineAdjust Applicator 63901-6000**				
**Perishable Tooling**				
	63901-6070	63901-6070	Tool Kit (All "Y" Items)	REF
1	63457-0074	63457-0074	Conductor Punch	1 Y
2	63455-0101	63455-0101	Conductor Anvil	1 Y
3	63443-0005	63443-0005	Cut-Off Plunger	1 Y
4	63443-0012	63443-0012	Front Plunger Retainer	1 Y
**Other Components**				
5	11-17-0022	1739-21	Hold Down Spring	1
6	11-18-4083	60707-8	Feed Guide	1
7	63443-0009	63443-0009	Scrap Chute	1
8	63443-0024	63443-0024	Key	1
9	63443-0090	63443-0090	Wire Stop	1
10	63443-0093	63443-0093	Shank	1
11	63443-1719	63443-1719	18.90mm Spacer	1
12	63443-2214	63443-2214	14.00mm Spacer	1
13	63443-2315	63443-2315	3.75mm Spacer	1
14	63443-3101	63443-3101	Front Plunger Striker	1
15	63443-6115	63443-6115	Rear Cover	1
16	63454-0101	63454-0101	Punch Spacer	1
17	63890-0095	63890-0095	Terminal Hold Down	1
18	63700-0539	63700-0539	Cut-off Plunger Spring	1
**Frame**				
19	63800-4901	63800-4901	Top	1
20	63801-3281	63801-3281	Base	1
21	63801-4650	63801-4650	Track	1
**Hardware**				
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	M3 by 8 Long SHCS	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 45 Long SHCS	2**
28	N/A	N/A	M5 by 12 Long SHCS	1**
29	N/A	N/A	#10-32 by 3/8"Long Flat Point SSS	1**
30	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
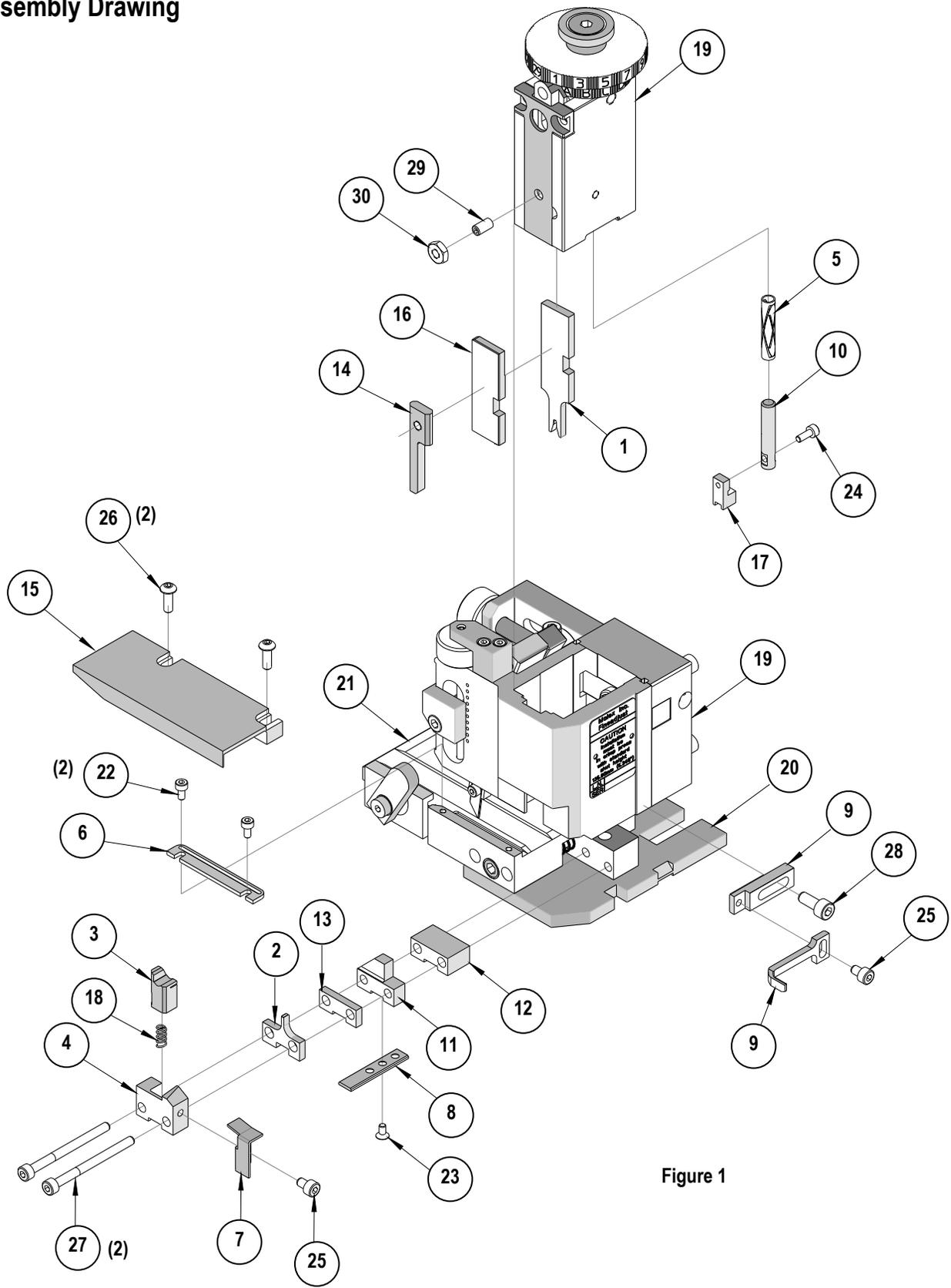
Figure 1

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.

http://www.molex.com