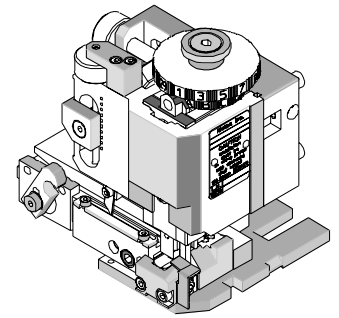




# FineAdjust Applicator Specification Sheet Part No. 63860-6000



## FEATURES

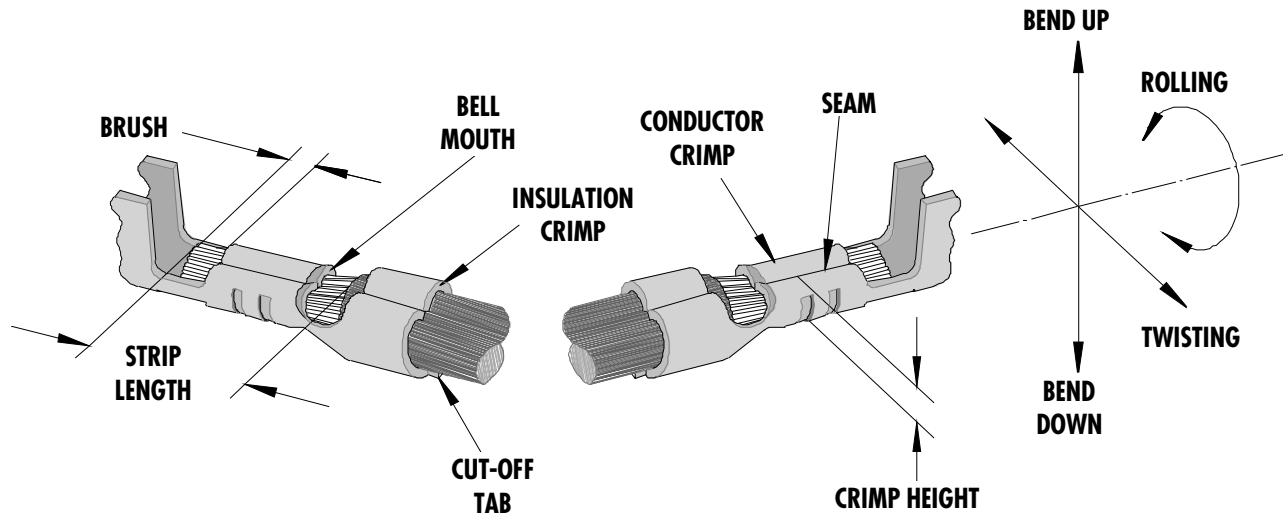
- Directly adapts to most automatic wire processing machines
- Quick punch removal with the push of a button for fast and easy tooling change
- Applicator designed to industry standard mounting and shut height 135.80mm (5.346")
- Quick set-up time; plus the crimp height, track and feed adjustments can 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: 2.50mm (.098") Pitch Splash Proof Crimp Terminal, 20-22 AWG.

Terminal Series No.	Terminal Order No.	Wire Size		Insulation Diameter		Strip Length	
		AWG	mm <sup>2</sup>	mm	In.	mm	In.
50038	50038-8000	20-22	0.50-0.35	1.50-1.90	.059-.075	2.00-2.50	.078-.098
50039	50039-8000	20-22	0.50-0.35	1.50-1.90	.059-.075	2.00-2.50	.078-.098

## 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 Max.		Conductor Brush	
	mm	In.	mm	In.	mm	In.
50038	0.00-0.30	.000-.012	0.30	.012	0.10-0.90	.004-.035
50039	0.00-0.30	.000-.012	0.30	.012	0.10-0.90	.004-.035

Terminal Series No.	Bend up	Bend down	Twist	Roll	Punch Width mm (Ref)				Seam
					Conductor		Insulation		
	Degree (Max)		Degree (Max)		mm	In	mm	In	
50038	2	0	3	10	1.40	.055	1.80	.070	Seam shall not be open and no wire allowed out of the crimping area
50039	2	0	3	10	1.40	.055	1.80	.070	

After crimping, the conductor profile should measure the following.

Terminal Order No.	Wire Size		Conductor Crimp Height		Pull Force Min.	
	AWG	mm <sup>2</sup>	mm	In.	N	Lb.
50038-8000	20	0.50	0.96-1.06	.038-.042	53.3	12.0
	22	0.35	0.94-0.99	.037-.039	48.9	11.0
50039-8000	20	0.50	0.96-1.06	.038-.042	53.3	12.0
	22	0.35	0.94-0.99	.037-.039	48.9	11.0

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 63860-6000</b>				
<b>Item</b>	<b>Order No</b>	<b>Engineering No.</b>	<b>Description</b>	<b>Quantity</b>
<b>Perishable Tooling</b>				
	63860-6070	63860-6070	Tool Kit (All "Y" Items)	REF
1	63444-1407	63444-1407	Conductor Punch	1 Y
2	63445-1431	63445-1431	Conductor Anvil	1 Y
3	63446-1808	63446-1808	Insulation Punch	1 Y
4	63445-1810	63445-1810	Insulation Anvil	1 Y
5	63443-0002	63443-0002	Cut-Off Plunger	1 Y
6	63443-0012	63443-0012	Front Plunger Retainer	1 Y
<b>Other Components</b>				
7	11-18-4083	60707-8	Front Cover	1
8	11-24-1067	4996-4	Cut-off Plunger Spring	1
9	11-40-4039	8302-5	Front Plunger Striker	1
10	63443-0009	63443-0009	Scrape Chute	1
11	63443-0021	63443-0021	Lower Tooling Key	1
12	63443-2406	63443-2406	Anvil Mount	1
13	63443-4005	63443-4005	Wire Stop	1
14	63443-6003	63443-6003	Rear Cover	1
<b>Frame</b>				
15	63800-4901	63800-4901	Top	1
16	63801-3281	63801-3281	Base	1
17	63801-4650	63801-4650	Track	1
<b>Hardware</b>				
18	N/A	N/A	M3 by 6 Long SHCS	2**
19	N/A	N/A	M4 by 6 Long SHCS	1**
20	N/A	N/A	M4 by 12 Long BHCS	2**
21	N/A	N/A	M4 by 16Lg SHCS	1**
22	N/A	N/A	M4 by 20 Long SHCS	1**
23	N/A	N/A	M4 by 50 Long SHCS	1**
24	N/A	N/A	3mm by 6 Long Roll Pin	1**
25	N/A	N/A	#10-32 by 1/4" Long BHCS	1**
** Available from an industrial supply company such as MSC (1-800-645-7270).				

### Assembly Drawing

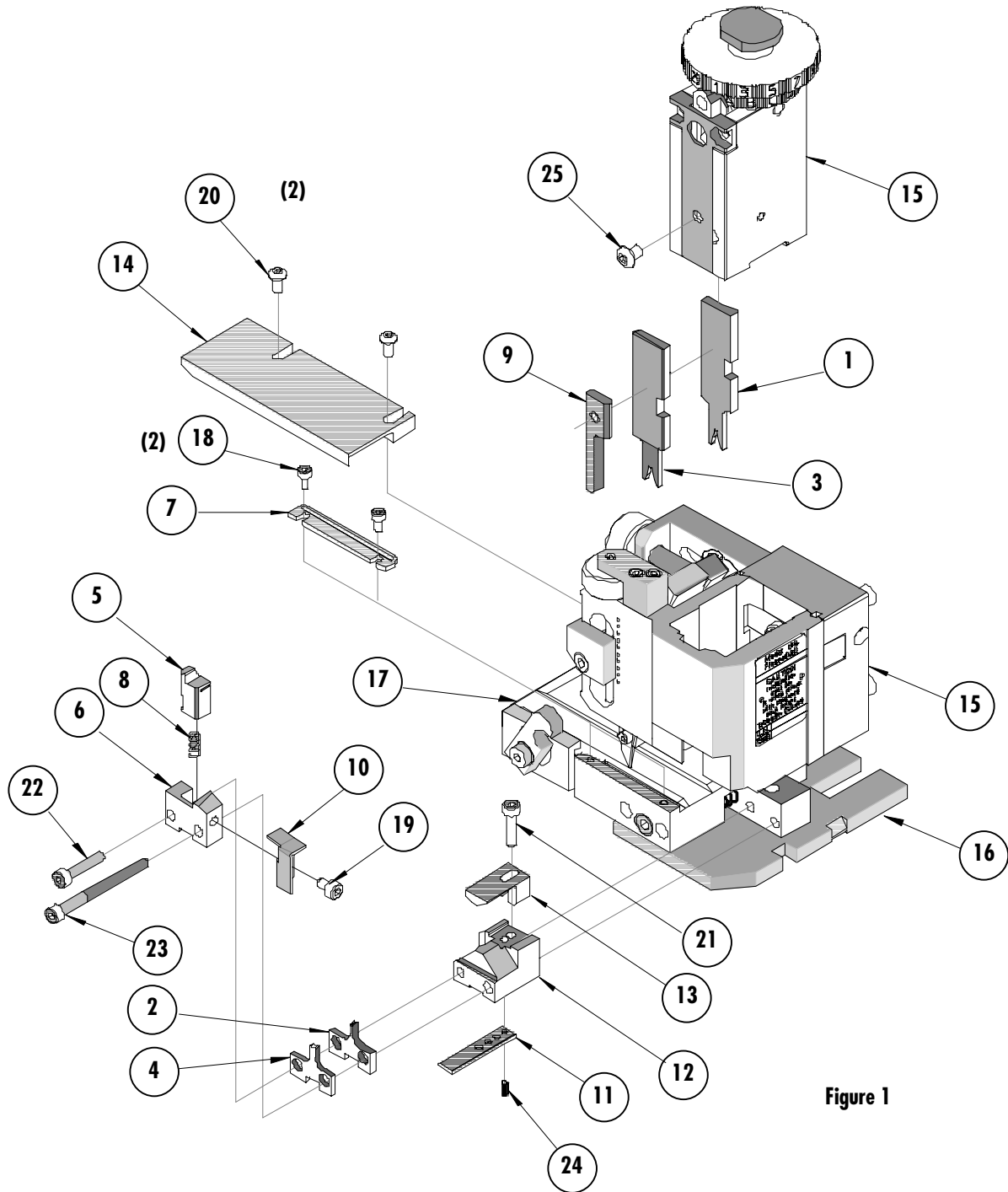


Figure 1

## 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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