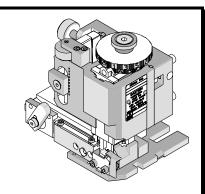


# FineAdjust Applicator Specification Sheet Part No. 63864-4100 (Full Radius Insulation Crimp)



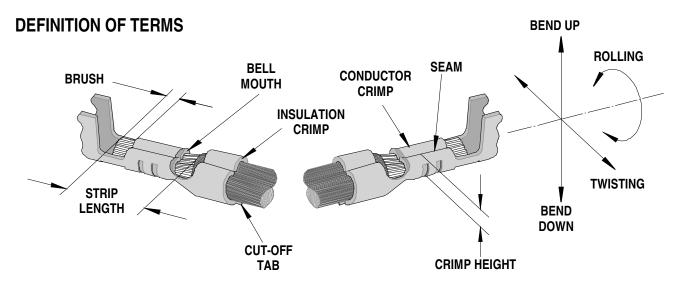
## **FEATURES**

- 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
- Also available: 63864-4000 with standard "B" insulation crimp recommended for small and min. insulation diameter, (See Scope)

### **SCOPE**

Products: Standard .093" (2.63mm) Pin and Socket Crimp Terminal

Terminal Series No.	Terminal Order No.	Wire Size		Insulation	Diameter	Strip Length	
	Terminal Order No.	AWG	mm²	mm	ln.	mm	ln.
42477	02-09-1615	14-18	0.81-2.07	2.36-3.56	.093140	3.96-5.33	.156218
42478	02-09-2611	14-18	0.81-2.07	2.36-3.56	.093140	3.96-5.33	.156218
42470	02-09-2612						



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

Doc No: ATS- 638644100 Release Date: 07-30-03 **UNCONTROLLED COPY** Page 1 of 5 Revision: C Revision Date: 07-16-07

# **CRIMP SPECIFICATION**

Terminal Series No.	Bell r	nouth	Cut-off Tab	Maximum	Conductor Brush	
reminiai Series No.	mm	ln.	mm	ln.	mm	ln.
42477	0.25-0.58	.010023	0.25	.010	0.13-0.55	.005022
42478	0.25-0.58	.010023	0.25	.010	0.13-0.55	.005022

	Bend up Bend down		Twist	Roll	Punch Width mm (Ref)			(Ref)	Coom	
Terminal Series No.	Degree		Degree		Conductor		Insulation		Seam Seam shall not be open and	
					mm	In	mm In		no wire allowed out	
42477	3	3	4	8	2.30	.090	3.60	.141	of the crimping area	
42478	3	3	4	8	2.30	.090	3.60	.141	or the chimping area	

After crimping, the conductor profile should measure the following.

Terminal Series No.	Wire Size		Crimp	Height	Pull Force Minimum		
Terminal Series No.	AWG	mm <sup>2</sup>	mm	ln.	N	Lb.	
	14	2.07	1.91-1.80	.075071	222.4	50.00	
42477	16	1.31	1.70-1.60	.067063	177.9	40.00	
	18	0.81	1.55-1.47	.061058	115.6	26.00	
	14	2.07	1.91-1.80	.075071	222.4	50.00	
42478	16	1.31	1.70-1.60	.067063	177.9	40.00	
	18	0.81	1.55-1.47	.061058	115.6	26.00	

Pull Force should be measured with no influence from the insulation crimp.

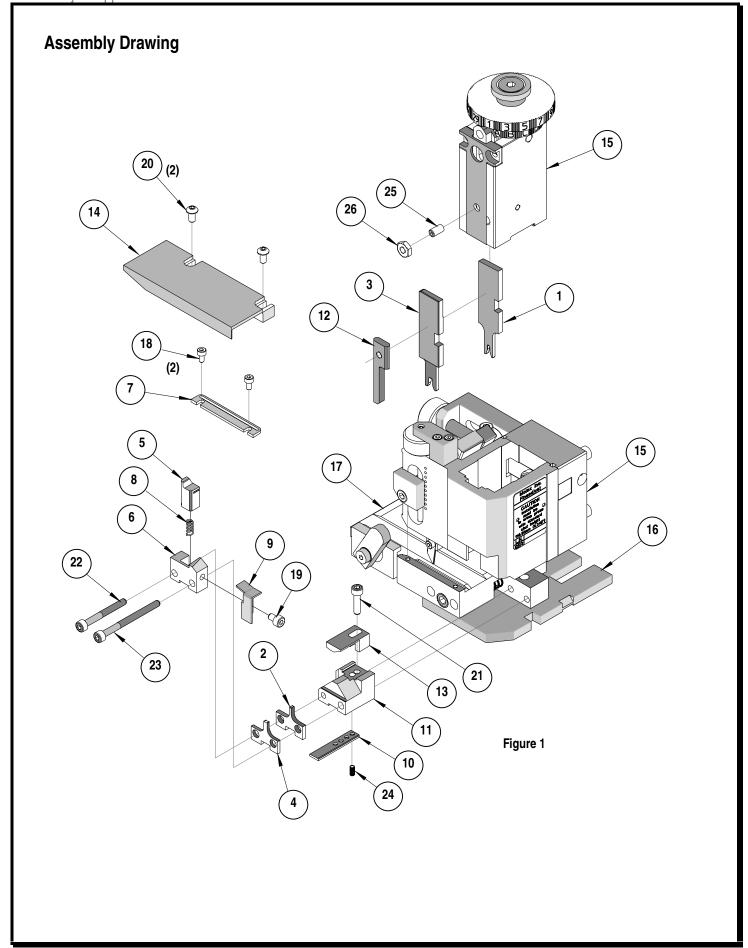
The above specifications are guidelines to an optimum crimp.

Doc No: ATS- 638644100 Release Date: 07-30-03 Revision: C Revision Date: 07-16-07

# **PARTS LIST**

FineAdjust Applicator 63864-4100								
Item	Order No	Engineering No.	Description	Quantity				
Perishable Tooling								
	63864-4170	\ /		REF				
1	63444-2323	63444-2323	Conductor Punch	1 Y				
2	63445-2348	63445-2348	Conductor Anvil	1 Y				
3	63460-3606	63460-3606	Insulation Punch-Full Radius	1 Y				
4	63445-3613	63445-3613	Insulation Anvil	1 Y				
5	63443-0002	63443-0002	Cut-Off Plunger	1 Y				
6	63443-0012	63443-0012	Front Plunger Retainer	1 Y				
		Other Com	ponents (644150)					
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	63443-0021	63443-0021	Lower Tooling Key	1				
11	63443-2417	63443-2417	Anvil Mount	1				
12	63443-3160	63443-3160	Front Plunger Striker	1				
13	63443-4006	63443-4006	Wire Stop	1				
14	63443-6011	63443-6011	Rear Cover	1				
			Frame					
15	63800-4901	63800-4901	Тор	1				
16	63801-3281	63801-3281	Base	1				
17	63801-4650	63801-4650	Track	1				
		Н	ardware					
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 3/8"Long Flat Point SSS	1**				
26	N/A	N/A	#10-32 Hex Jam Nut	1**				
** Available from an industrial supply company such as MSC (1-800-645-7270).								

Doc No: ATS- 638644100 Release Date: 07-30-03 Revision: C Revision Date: 07-16-07



Doc No: ATS- 638644100 Revision: C

Release Date: 07-30-03 Revision Date: 07-16-07

#### **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 135.8 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.

Americas Headquarters Lisle, Illinois 60532 U.S.A. 1-800-78MOLEX amerinfo@molex.com

Far East North Headquarters Yamato, Kanagawa, Japan 81-462-65-2324 feninfo@molex.com

Far East South Headquarters European Headquarters Jurong, Singapore 65-6-268-6868 fesinfo@molex.com

Munich, Germany 49-89-413092-0 eurinfo@molex.com **Corporate Headquarters** 2222 Wellington Ct. Lisle, IL 60532 U.S.A. 630-969-4550 Fax: 630-969-1352

Visit our Web site at http://www.molex.com

**UNCONTROLLED COPY** Doc No: ATS- 638644100 Release Date: 07-30-03 Page 5 of 5 Revision Date: 07-16-07

Revision: C