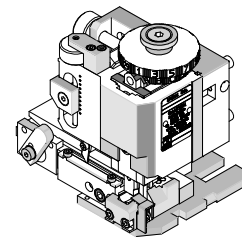


**FineAdjust  
Applicator**



**Application Tooling  
Specification Sheet**



**Order No. 63902-9400**

**FEATURES**

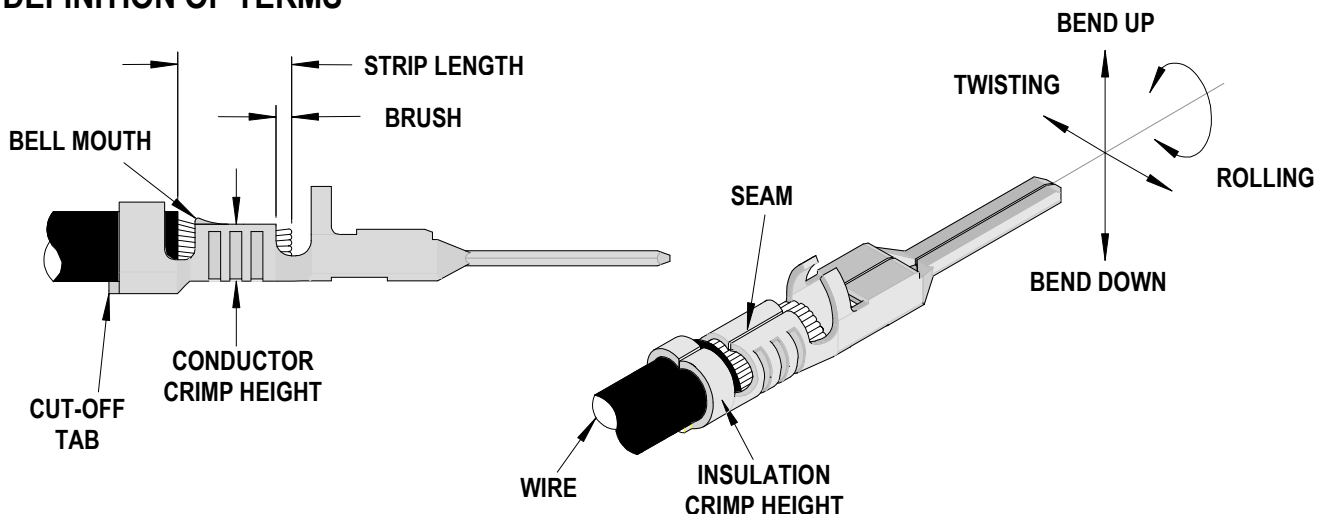
- Directly adapts to most automatic wire processing machines
- Quick punch removal with the push of a button for fast and easy tooling change
- Applicator designed to industry standard mounting and shut height 135.80mm (5.346")
- Quick set-up time; plus the crimp height, track and feed adjustments can 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: 6.0 W/W Plug Terminals, 18-20 AWG (UL1007) wires.

Terminal Series No.	Terminal Order No.	Wire Size and Type			◆Insulation Diameter		Strip Length	
		AWG	mm <sup>2</sup>	Type	mm	In.	mm	In.
35040	35040-9802	18-20	0.82-0.52	UL1007	1.60-2.10	.063-.083	4.20-5.00	.165-.197
◆ For 18-20 AWG (UL1015) with Insulation Diameter 2.20-2.90mm (.087"-.114") Use Applicator 63902-9300								

**DEFINITION OF TERMS**



## CRIMP SPECIFICATION

Terminal Series No.	Bell mouth		Cut-off Tab Maximum		Conductor Brush	
	mm	In.	mm	In.	mm	In.
35040	0.20-0.50	.008-.020	0.20	.008	0.00-1.00	.000-.039

Terminal Series No.	Bend up	Bend down	Twist	Roll	Punch Width (Ref)				Seam Seam shall not be open and no wire allowed out of the crimping area
					Conductor		Insulation		
	Degree (Max)		Degree (Max)		mm	In	mm	In	
35040	3	3	3	5	2.40	.095	2.50	.098	

After crimping, the conductor profile should measure the following.

Terminal Series No.	Wire Size		Conductor Crimp Height		Conductor Crimp Width (Max)		Pull Force Minimum	
	AWG	mm <sup>2</sup>	mm	In.	mm	In.	N	Lb.
35040	18	0.82	1.33-1.40	.052-.055	2.50	.098	107.8	24.3
	20	0.52	1.25-1.32	.049-.052	2.50	.098	58.8	13.2

Terminal Series No.	Wire Size		Insulation Crimp Height (Max)		Insulation Crimp Width (Max)	
	AWG	mm <sup>2</sup>	mm	In.	mm	In.
35040	18	0.82	3.00	.118	2.60	.102
	20	0.52	2.80	.110	2.60	.102

### 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.

**PARTS LIST**

<b>FineAdjust Applicator 63902-9400</b>				
<b>Item</b>	<b>Order No</b>	<b>Engineering No.</b>	<b>Description</b>	<b>Quantity</b>
<b>Perishable Tooling</b>				
	63902-9470	63902-9470	Tool Kit (All "Y" Items)	REF
1	63444-2425	63444-2425	Conductor Punch	1 Y
2	63445-2443	63445-2443	Conductor Anvil	1 Y
3	63446-2519	63446-2519	Insulation Punch	1 Y
4	63445-2533	63445-2533	Insulation Anvil	1 Y
5	63443-0005	63443-0005	Front Cut-Off Plunger	1 Y
6	63443-0012	63443-0012	Front Plunger Retainer	1 Y
<b>Other Components</b>				
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	63443-1717	63443-1717	18.70mm Height Spacer	1
15	63443-2214	63443-2214	14.00mm Spacer	1
16	63443-2317	63443-2317	3.85mm Spacer	1
17	63443-2802	63443-2802	Front Plunger Striker	1
18	63443-2915	63443-2915	Striker Plunger	1
19	63443-6119	63443-6119	Rear Cover	1
20	63443-7120	63443-7120	Terminal Hold Down	1
21	63600-0021	63600-0021	Striker Plunger Spring	1
<b>Frame</b>				
22	63800-4901	63800-4901	Top	1
23	63801-3281	63801-3281	Base	1
24	63801-4650	63801-4650	Track	1
<b>Hardware</b>				
25	N/A	N/A	M3 by 6 Long SHCS	2**
26	N/A	N/A	M3 by 6 Long FHCS	1**
27	N/A	N/A	M3 by 8 Long SHCS	1**
28	N/A	N/A	M4 by 6 Long SHCS	2**
29	N/A	N/A	M4 by 12 Long BHCS	2**
30	N/A	N/A	M4 by 50 Long SHCS	2**
31	N/A	N/A	M5 by 12 Lg SHCS	1**
32	N/A	N/A	#10-32 by 3/8" Long Flat Point SSS	1**
33	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

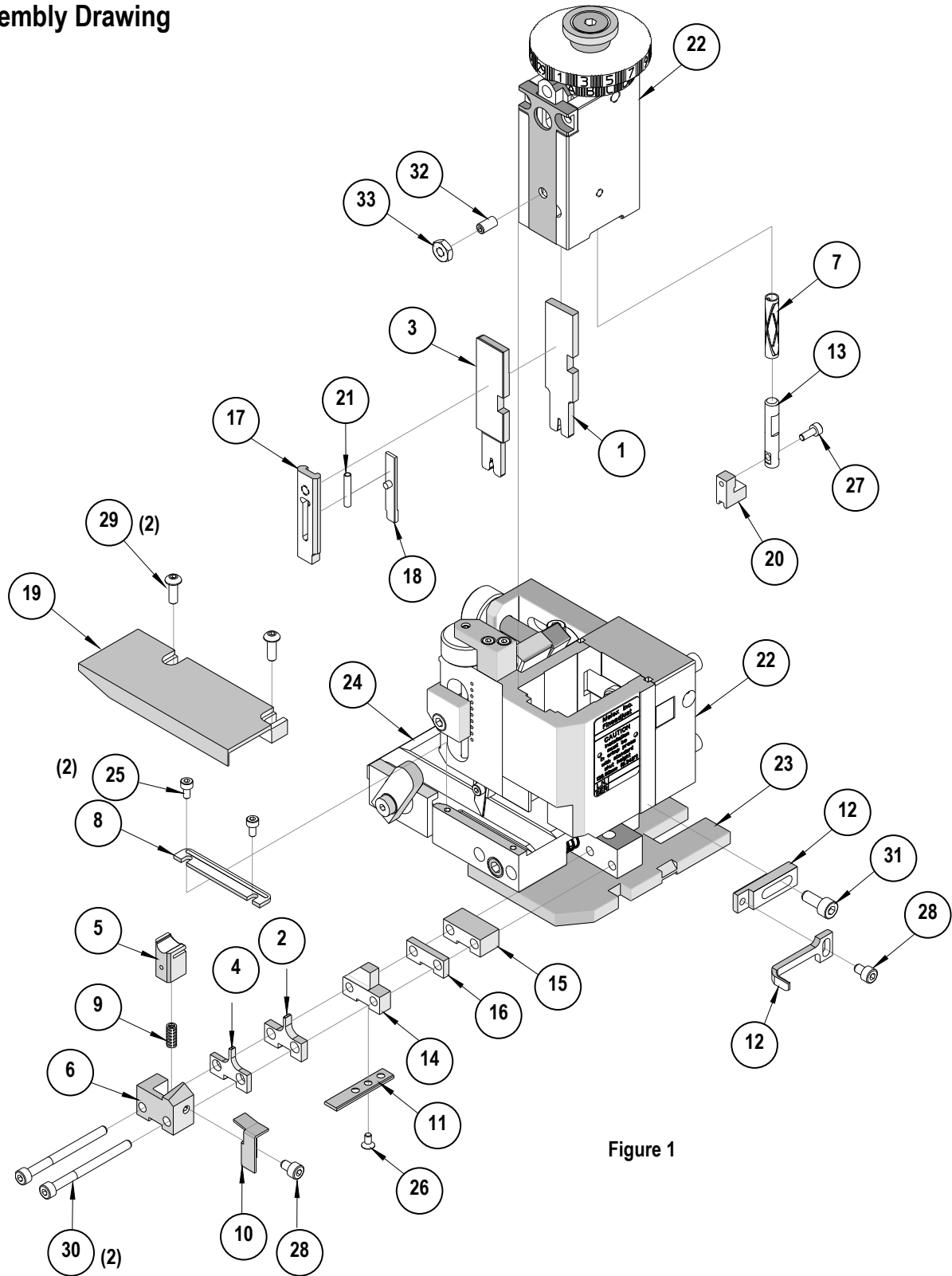


Figure 1

## 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.

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