

**FineAdjust
Applicator**

**Application Tooling
Specification Sheet**

Order No. 63900-2400

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

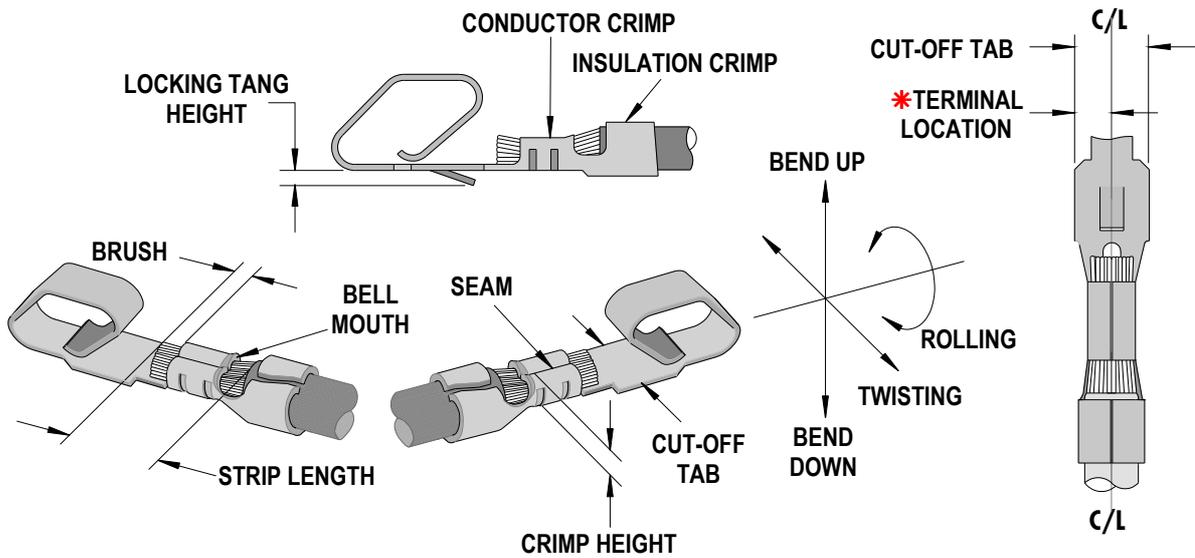
Products: KK® Crimp Terminal and Cat Ear Crimp Terminals, 22-30 AWG. Use with larger wire insulation diameters.

Terminal Series No.	Terminal Order No.		Wire Size		Insulation Diameter				Strip Length	
					IPC/WHMA-A620 ♦		Terminal ♦♦			
					mm	In.	mm	In.		
2759	08-50-0113	39-00-0032	22-30	0.35-0.05	1.57-1.20	.062-.047	1.57 Max.	.062 Max.	2.54-3.18	.100-.125
	08-50-0159	39-00-0064								
	08-50-0274	39-00-0372								
	08-51-0101	39-00-0374								
	08-51-0108	39-00-0376								
	08-55-0101	39-00-0378								
	08-55-0130	39-00-0380								
08-56-0109	50-29-1757									
5139	08-70-0046		22-30	0.35-0.05	1.57-1.20	.062-.047	1.57 Max.	.062 Max.	2.54-3.18	.100-.125
5159	08-70-0048	08-70-0064	22-28	0.35-0.08	1.57-1.20	.062-.047	1.70-1.20	.067-.047	2.54-3.18	.100-.125
6459	08-52-0101	08-65-0813	22-30	0.35-0.05	1.57-1.20	.062-.047	1.57 Max.	.062 Max.	2.54-3.18	.100-.125
	08-52-0118	08-65-0815								
	08-52-0121	08-65-0817								
	08-65-0801	40-07-0815								
08-65-0811										
40445	08-50-0321	97-00-0920	22-30	0.35-0.05	1.57-1.20	.062-.047	1.57 Max.	.062 Max.	2.54-3.18	.100-.125
	97-00-0444									
41572	08-65-0804		22-30	0.35-0.05	1.57-1.20	.062-.047	1.57 Max.	.062 Max.	2.54-3.18	.100-.125

♦ To achieve optimum IPC-A620 insulation crimps, use this insulation OD range.
 To achieve optimum IPC-A620 insulation crimps for 1.09-0.94mm (.043-.037") diameter, use Applicator 63900-5700.

♦♦ Overall insulation OD specification for terminal.

DEFINITION OF TERMS



*Terminal is to be centrally located between the two (2) cut-off edges, within +/- 0.13mm (+/- .005").

This illustration is a generic terminal representation and not an exact image of any terminal listed in the scope.

CRIMP SPECIFICATIONS

Terminal Series No.	Bell mouth		*Cut-off Tab		Conductor Brush	
	mm	In.	mm	In.	mm	In.
2759	0.20-0.50	.008-.020	1.98-1.85	.078-.073	.00-1.0	.000-.040
5139	0.20-0.50	.008-.020	1.98-1.85	.078-.073	.00-1.0	.000-.040
5159	0.20-0.50	.008-.020	1.98-1.85	.078-.073	.00-1.0	.000-.040
6459	0.20-0.50	.008-.020	1.98-1.85	.078-.073	.00-1.0	.000-.040
40445	0.20-0.50	.008-.020	1.98-1.85	.078-.073	.00-1.0	.000-.040
41572	0.20-0.50	.008-.020	1.98-1.85	.078-.073	.00-1.0	.000-.040

Terminal Series No.	Locking Tang Height		Bend up	Bend down	Twist	Roll	Punch Width (Ref)				Seam
	mm	In					Degree		Degree		
			mm	In	mm	In	mm	In	mm	In	
2759	0.51-0.64	.020-.025	3	3	4	8	1.40	.055	1.95	.077	Seam shall not be open and no wire allowed out of the crimping area.
5139	0.34-0.60	.013-.024	3	3	4	8	1.40	.055	1.95	.077	
5159	0.40-0.55	.016-.022	3	3	4	8	1.40	.055	1.95	.077	
6459	0.51-0.64	.020-.025	3	3	4	8	1.40	.055	1.95	.077	
40445	0.51-0.64	.020-.025	3	3	4	8	1.40	.055	1.95	.077	
41572	0.51-0.64	.020-.025	3	3	4	8	1.40	.055	1.95	.077	

After crimping, the conductor profile should measure the following.

Terminal Series No.	Wire Size		Crimp Height		Crimp Width (Ref)		Pull Force Minimum	
	AWG	mm ²	mm	In.	mm	In.	N	Lb.
2759	22	0.35	0.79-0.84	.031-.033	1.40	.055	44.88	10.0
	24	0.20	0.73-0.79	.029-.031	1.40	.055	35.59	8.0
	26	0.12	0.71-0.76	.028-.030	1.40	.055	17.79	4.0
	28	0.08	0.68-0.73	.027-.029	1.40	.055	13.34	3.0
	30	0.05	0.66-0.71	.026-.028	1.40	.055	8.89	2.0
5139	22	0.35	0.79-0.84	.031-.033	1.40	.055	44.88	10.0
	24	0.20	0.74-0.79	.029-.031	1.40	.055	35.59	8.0
	26	0.12	0.68-0.74	.027-.029	1.40	.055	17.79	4.0
	28	0.08	0.66-0.71	.026-.028	1.40	.055	13.34	3.0
	30	0.05	0.63-0.66	.026-.027	1.40	.055	8.89	2.0
5159	22	0.35	0.79-0.84	.031-.033	1.40	.055	44.88	10.0
	24	0.20	0.74-0.79	.029-.031	1.40	.055	35.59	8.0
	26	0.12	0.68-0.74	.027-.029	1.40	.055	17.79	4.0
	28	0.08	0.66-0.71	.026-.028	1.40	.055	13.34	3.0
6459	22	0.35	0.79-0.84	.031-.033	1.40	.055	44.88	10.0
	24	0.20	0.74-0.79	.029-.031	1.40	.055	35.59	8.0
	26	0.12	0.68-0.74	.027-.029	1.40	.055	17.79	4.0
	28	0.08	0.66-0.71	.026-.028	1.40	.055	13.34	3.0
	30	0.05	0.63-0.66	.026-.027	1.40	.055	8.89	2.0
40445	22	0.35	0.79-0.84	.031-.033	1.40	.055	44.88	10.0
	24	0.20	0.74-0.79	.029-.031	1.40	.055	35.59	8.0
	26	0.12	0.68-0.74	.027-.029	1.40	.055	17.79	4.0
	28	0.08	0.66-0.71	.026-.028	1.40	.055	13.34	3.0
	30	0.05	0.63-0.66	.026-.027	1.40	.055	8.89	2.0
41572	22	0.35	0.79-0.84	.031-.033	1.40	.055	44.88	10.0
	24	0.20	0.74-0.79	.029-.031	1.40	.055	35.59	8.0
	26	0.12	0.68-0.74	.027-.029	1.40	.055	17.79	4.0
	28	0.08	0.66-0.71	.026-.028	1.40	.055	13.34	3.0
	30	0.05	0.63-0.66	.026-.027	1.40	.055	8.89	2.0

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

FineAdjust Applicator 63900-2400				
Item No.	Order No.	Engineering No.	Description	Quantity
Perishable Tooling				
	63900-2470	63900-2470	Tool Kit (All "Y" Items)	REF
1	63444-1417	63444-1417	Conductor Punch	1 Y
2	63445-1445	63445-1445	Conductor Anvil	1 Y
3	63454-0003	63454-0003	Insulation Punch	1 Y
4	63445-1973	63445-1973	Insulation Anvil	1 Y
5	63443-3312	63443-3312	Cut-Off Die	1 Y
6	63443-3412	63443-3412	Cut-Off Punch	1 Y
Other Components				
7	11-18-4001	60703-3	Cover Plate	1
8	11-18-4003	60703-5	Front Cover	1
9	63443-0025	63443-0025	Key (Dual Carrier)	1
10	63443-1214	63443-1214	Cut-Off Plunger Retainer	1
11	63443-1202	63443-1202	Guide Block	1
12	63443-1203	63443-1203	Rear Cover Retainer	1
13	63443-1210	63443-1210	Wire Stop Mounting Bracket	1
14	63443-1211	63443-1211	Wire Stop	1
15	63443-2201	63443-2201	1.00mm Spacer	1
16	63443-2307	63443-2307	3.35mm Spacer	1
17	63443-2801	63443-2801	Front Plunger Striker	1
18	63443-2911	63443-2911	Wire Hold-Down Plunger	1
19	63443-3512	63443-3512	Terminal Lifter	1
20	63600-0021	63600-0021	Compression Spring	1
21	63600-2995	63600-2995	Spring Lifter	1
22	63700-0539	63700-0539	Compression Spring	1
23	63820-0012	63820-0012	Terminal Drag Cover	1
Frame				
24	63800-4901	63800-4901	Top	1
25	63801-3285	63801-3285	Base	1
26	63801-6950	63801-6950	Track	1
27	63801-4562	63801-4562	Feed Pawl .070mm Thick	1
Hardware				
28	N/A	N/A	M2.5 by 5 Long SHCS	2**
29	N/A	N/A	M3 by 5 Long SHCS	3**
30	N/A	N/A	M3 by 6 Long FHCS	1**
31	N/A	N/A	M3 by 6 Long SHCS	4**
32	N/A	N/A	M3 by 12 Long SHCS	1**
33	N/A	N/A	M4 by 6 Long SHCS	2**
34	N/A	N/A	M4 by 12 Long BHCS	2**
35	N/A	N/A	M4 by 45 Long SHCS	2**
36	N/A	N/A	#10-32 by 3/8" Long SSS (Flat Point)	1**
37	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

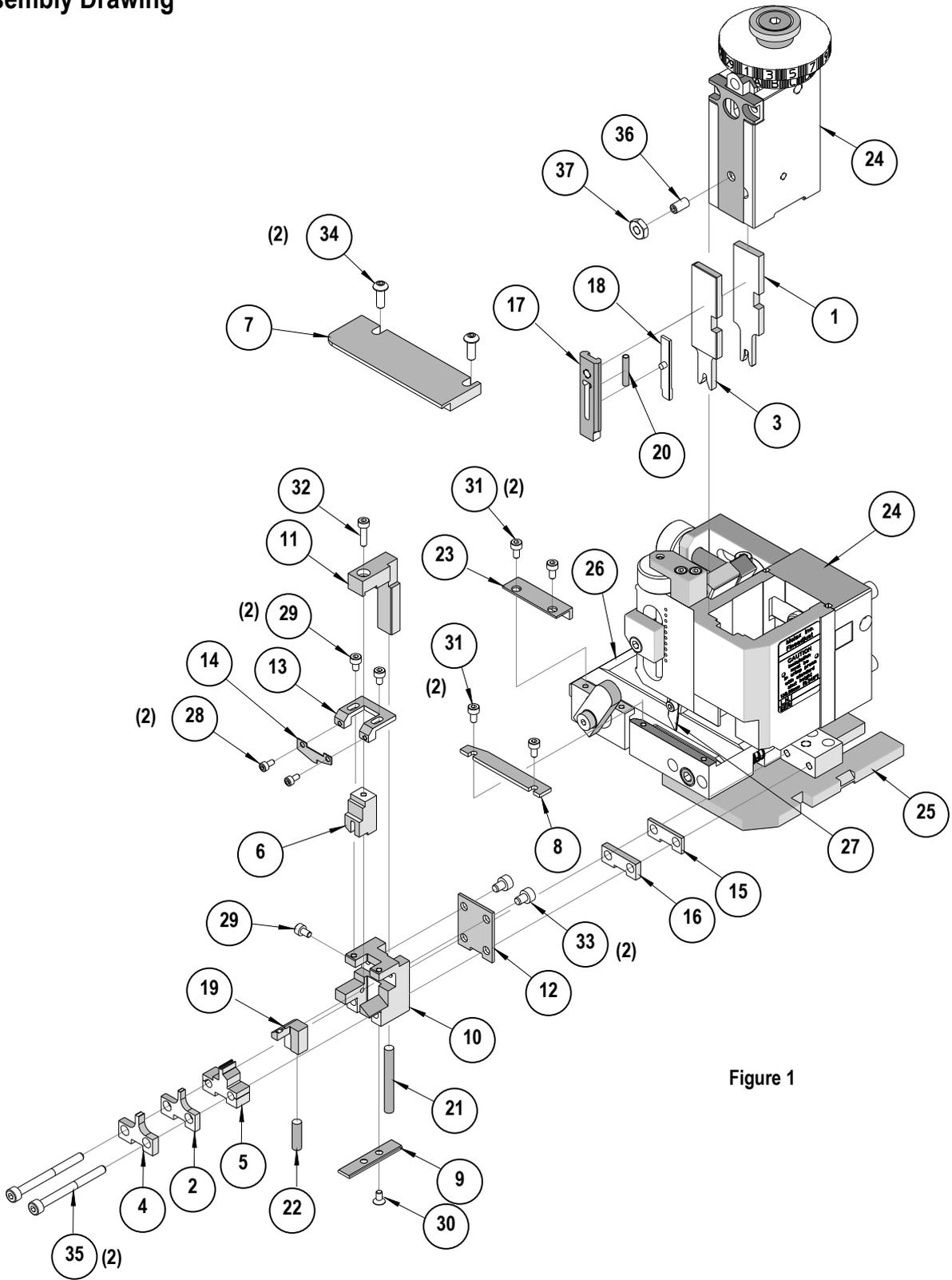


Figure 1

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 135.8 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.

<http://www.molex.com>