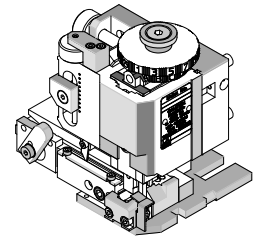




**FineAdjust  
Applicator**

**Application Tooling  
Specification Sheet**



**Order No. 63901-9700**

**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

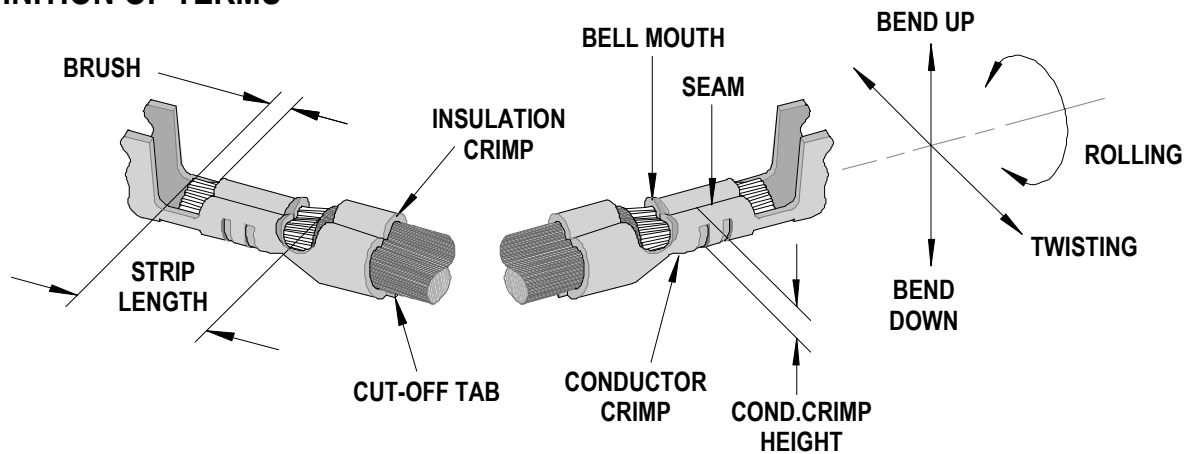
**SCOPE**

Products: RAST5 Normal Force (HNF) Female Crimp Terminal, 18-20 AWG.

Terminal Series No.	Terminal Order No.	Wire Size		Insulation Diameter				Strip Length	
				IPC/WHMA-A60 (1)		Terminal (2)			
		AWG	mm <sup>2</sup>	mm	In.	mm	In.	mm	In.
94518	94518-0100	18	0.80	2.20-2.80	.087-.110	2.20-2.80	.087-.110	5.00-5.50	.197-.216
	94518-0101	20	0.50						

(1) To achieve optimum IPC-A620 Class 2 insulation crimps, use this insulation OD.  
 (2) Overall insulation OD specification for terminal.

**DEFINITION OF TERMS**



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

## CRIMP SPECIFICATION

Terminal Series No.	Bell mouth		Cut-off Tab Maximum		Conductor Brush	
	mm	In.	mm	In.	mm	In.
94518	0.20-0.40	.008-.016	0.60	.024	0.50-1.50	.020-.059

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
	Degree		Degree		Conductor		Insulation		
	mm	In	mm	In	mm	In	mm	In	
94518	3 °	3 °	4 °	8 °	2.15	.085	2.80	.110	

After crimping, the crimp profiles should measure the following:

Terminal Series No.	Wire Size		Conductor				Insulation				Pull Force Minimum	
			Crimp Height		Crimp Width (Ref)		Crimp Height (Ref)		Crimp Width (Ref)			
	AWG	mm <sup>2</sup>	mm	In.	mm	In.	mm	In.	mm	In.	N	Lb.
94518	18	0.80	1.50-1.57	.059-.062	2.20-2.30	.087-.091	3.00-3.10	.118-.122	2.80-3.00	.110-.118	117.7	26.5
	20	0.50	1.25-1.35	.049-.053	2.20-2.30	.087-.091	2.90-3.00	.114-.118	2.80-3.00	.110-.118	78.2	17.6
		1.00	1.57-1.67	.062-.066	2.20-2.30	.087-.091	3.10-3.20	.122-.126	2.80-3.00	.110-.118	157.0	35.3

**T** 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 63901-9700</b>				
<b>Item</b>	<b>Order No</b>	<b>Engineering No.</b>	<b>Description</b>	<b>Quantity</b>
<b>Perishable Tooling</b>				
	63901-9770	63901-9770	Tool Kit (All "Y" Items)	REF
1	63457-0071	63457-0071	Conductor Punch	1 Y
2	63832-0102	63832-0102	Conductor Anvil	1 Y
3	63454-0116	63454-0116	Insulation Punch	1 Y
4	63445-2841	63445-2841	Insulation Anvil	1 Y
5	63443-0002	63443-0002	Cut-Off Plunger Front	1 Y
6	63443-0012	63443-0012	Plunger Retainer Front	1 Y
<b>Other Components</b>				
7	11-17-0022	1739-21	Hold-Down Spring	1
8	11-18-4083	60707-8	Front Cover	1
9	11-24-1067	4996-4	Cut-off Plunger Spring	1
10	63443-0009	63443-0009	Scrap Chute Front	1
11	63443-0024	63443-0024	Lower Tooling Key	1
12	63443-0090	63443-0090	Wire Stop	1
13	63443-0093	63443-0093	Shank	1
14	63443-1718	63443-1718	18.80mm Height Spacer	1
15	63443-2201	63443-2201	1.0mm Coarse Spacer	1
16	63443-2213	63443-2213	13.0mm Coarse Spacer	1
17	63443-2310	63443-2310	3.50mm Fine Spacer	1
18	63443-2805	63443-2805	Plunger Striker Front	1
19	63443-2912	63443-2912	Wire Hold-Down Plunger	1
20	63443-6123	63443-6123	Rear Cover	1
21	63600-1057	63600-1057	Wire Hold-Down Spring	1
22	63890-0094	63890-0094	Terminal Hold-Down	1
<b>Frame</b>				
23	63800-4901	63800-4901	Top	1
24	63801-3281	63801-3281	Base	1
25	63801-4650	63801-4650	Track	1
<b>Hardware</b>				
26	N/A	N/A	M3 by 6 Long FHCS	1**
27	N/A	N/A	M3 by 6 Long SHCS	2**
28	N/A	N/A	M3 by 8 Long SHCS	1**
29	N/A	N/A	M4 by 6 Long SHCS	2**
30	N/A	N/A	M4 by 12 Long BHCS	2**
31	N/A	N/A	M4 by 50 Long SHCS	2**
32	N/A	N/A	M5 by 12 Long SHCS	1**
33	N/A	N/A	#10-32 by 3/8" Long Flat Point SSS	1**
34	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

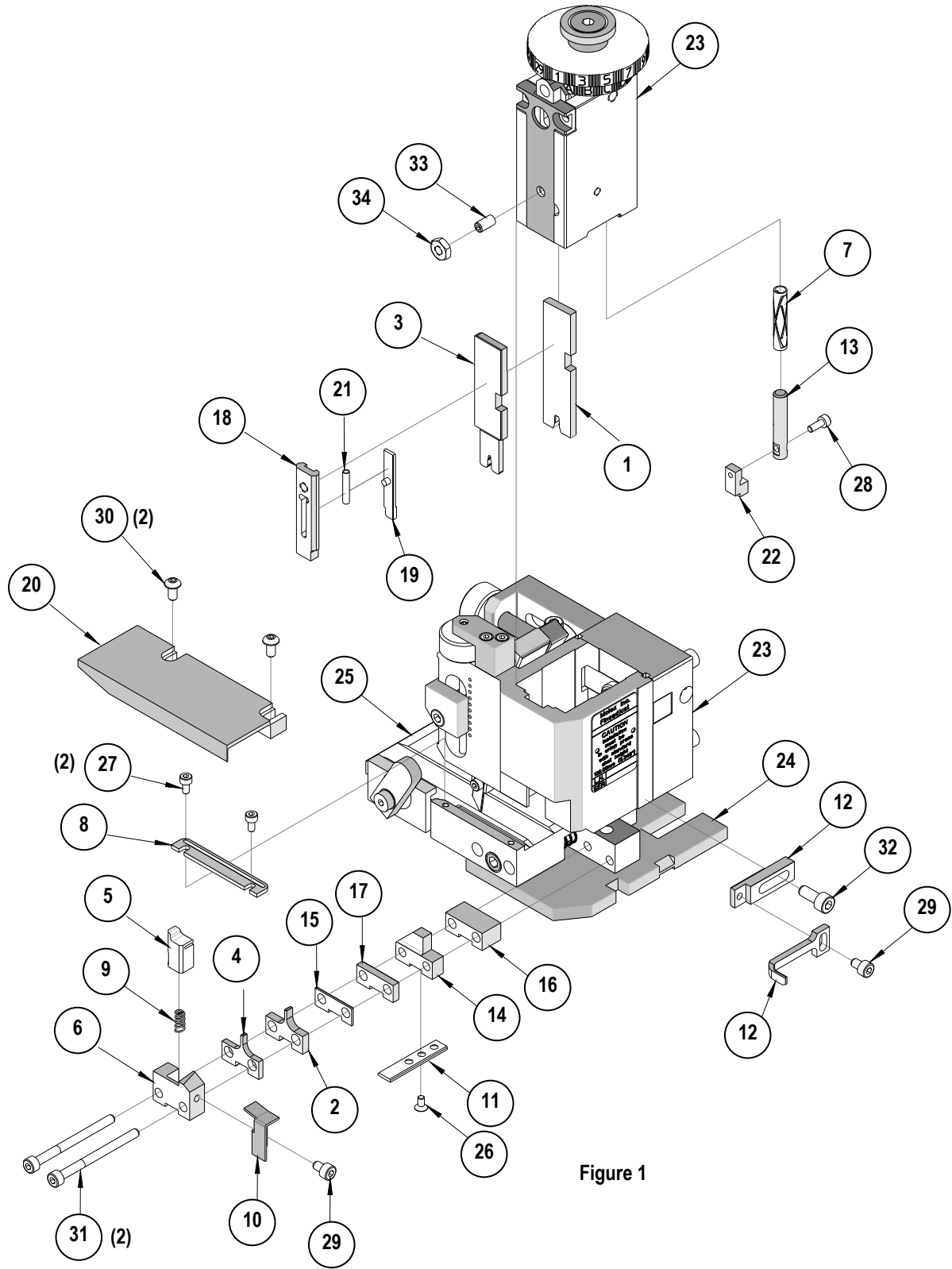


Figure 1

## 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 135.80 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>