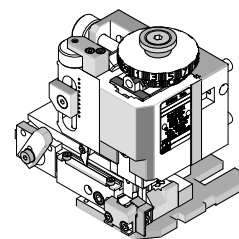




**FineAdjust  
Applicator**

**Application Tooling  
Specification Sheet**



**Order No. 63902-2900**

**FEATURES**

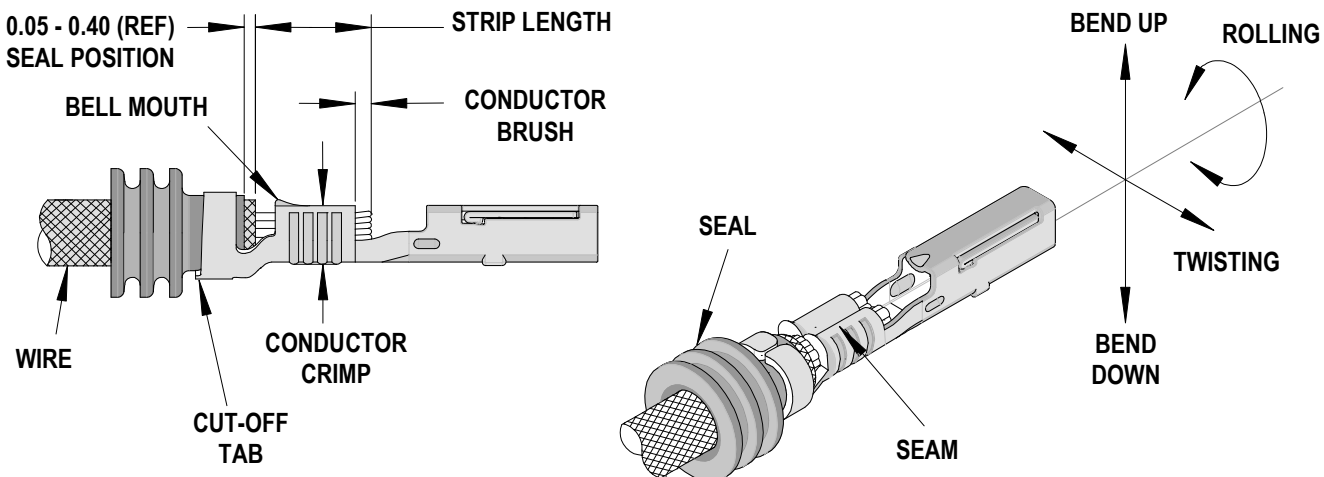
- Quick punch removal with the push of a button for fast and easy tooling change
- Applicator designed to industry standard mounting and shut height 135.80mm (5.346")
- Quick set-up time; plus the crimp height, track and feed adjustments can be set without removing the applicator from the press
- Fine 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: CTX150 SWS Receptacle Terminals 0.50 mm<sup>2</sup>, 0.75 mm<sup>2</sup>.

Terminal Series No.	Terminal Order No.	Wire Size		Insulation Diameter		Strip Length	
		Wire Type	mm <sup>2</sup>	mm	In.	mm	In.
502307	502307-3007 502307-3402	T3-ZHID	.75 mm <sup>2</sup>	1.60-1.80	.063-.071	4.50-5.00	.177-.197
34806	34806-3007 34806-3402	T3-ZHID	.75 mm <sup>2</sup>	1.60-1.80	.063-.071	4.50-5.00	.177-.197
502307	502307-3006 502307-3401	T3-ZHID	.50 mm <sup>2</sup>	1.40-1.60	.055-.063	4.50-5.00	.177-.197
34806	34806-3006 34806-3401	T3-ZHID	.50 mm <sup>2</sup>	1.40-1.60	.055-.063	4.50-5.00	.177-.197

**DEFINITION OF TERMS**



### CRIMP SPECIFICATION

Terminal Series No.	Bell mouth		Cut-off Tab Maximum		▶ Conductor Brush	
	mm	In.	mm	In.	mm	In.
502307	0.20-0.55	.008-.022	0.30	.012	0.20-1.20	.008-.047
34806						
▶ Wire brush must be flush or below top of Conductor Crimp.						

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			
502307	1	1	2	3	1.60	.063	3.10	.122	
34806									

After crimping, the crimp profiles should measure the following:

Terminal Series No.	Wire Size		Conductor				Insulation				Pull Force Minimum	
			Crimp Height		Crimp Width Max.		Crimp Height +/- 0.05		Crimp Width +/- 0.10			
	Wire Type	mm <sup>2</sup>	mm	In.	mm	In.	mm	In.	mm	In.	N	Lb.
502307	T3-ZHID	.75 mm <sup>2</sup>	1.10-1.20	.043-.047	1.70	.067	3.13	.123	3.10	.122	115	25.9
34806	T3-ZHID	.75 mm <sup>2</sup>	1.10-1.20	.043-.047	1.70	.067	3.13	.123	3.10	.122	115	25.9
502307	T3-ZHID	.50 mm <sup>2</sup>	0.80-0.90	.031-.035	1.65	.065	2.77	.109	3.10	.122	80	18.0
34806	T3-ZHID	.50 mm <sup>2</sup>	0.80-0.90	.031-.035	1.65	.065	2.77	.109	3.10	.122	80	18.0

Terminal Series No.	Wire Size		Single Wire Seal		
	Wire Type	mm <sup>2</sup>	Order No.	Color	Seal Allowed Wire Ø
502307	T3-ZHID	.75 mm <sup>2</sup>	See Note 3	See Note 3	See Note 3
34806	T3-ZHID	.75 mm <sup>2</sup>			
502307	T3-ZHID	.50 mm <sup>2</sup>			
34806	T3-ZHID	.50 mm <sup>2</sup>			

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.
3. See Product Application Specification AS-502307-002 for applicable Seal number, Color and Seal Allowed Wire Diameter.

## PARTS LIST

FineAdjust Applicator 63902-2900				
Item	Order No	Engineering No.	Description	Quantity
<b>Perishable Tooling</b>				
	63902-2970	63902-2970	Tool Kit (All "Y" Items)	REF
1	63457-0088	63457-0088	Conductor Punch	1 Y
2	63455-0110	63455-0110	Conductor Anvil	1 Y
3	63454-0117	63454-0117	Insulation Punch	1 Y
4	63456-0080	63456-0080	Insulation Anvil	1 Y
5	63890-0077	63890-0077	Cut-Off Plunger	1 Y
6	63443-0038	63443-0038	Front Plunger Retainer	1 Y
<b>Other Components</b>				
7	11-18-4083	60707-8	Feed Guide	1
8	63443-0009	63443-0009	Scrap Chute	1
9	63443-0024	63443-0024	Key	1
10	63443-0090	63443-0090	Wire Stop	1
11	63443-2214	63443-2214	Coarse Spacer (14.00mm)	1
12	63443-3601	63443-3601	Front Plunger Striker	1
13	63443-3702	63443-3702	Striker Screw	1
14	63443-6121	63443-6121	Rear Cover	1
15	63700-0539	63700-0539	Cut-off Plunger Spring	1
16	63867-3007	63867-3007	Bottom Cap	1
17	63890-0066	63890-0066	Height Spacer	1
<b>Frame</b>				
18	63800-4901	63800-4901	Top	1
19	63801-3281	63801-3281	Base	1
20	63801-4650	63801-4650	Track	1
21	63459-0001	63459-0001	Terminal Track	1
<b>Hardware</b>				
22	N/A	N/A	M3 by 3 Long Flat Point SSS	2**
23	N/A	N/A	M3 by 6 Long SHCS	2**
24	N/A	N/A	M3 by 6 Long FHCS	1**
25	N/A	N/A	M4 by 6 Long SHCS	2**
26	N/A	N/A	M4 by 8 Long Brass Tip SSS	1**
27	N/A	N/A	M4 by 12 Long SHCS	2**
28	N/A	N/A	M4 by 12 Long BHCS	2**
29	N/A	N/A	M4 by 16 Long SHCS	1**
30	N/A	N/A	M4 by 50 Long SHCS	2**
31	N/A	N/A	M5 by 12 Long 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

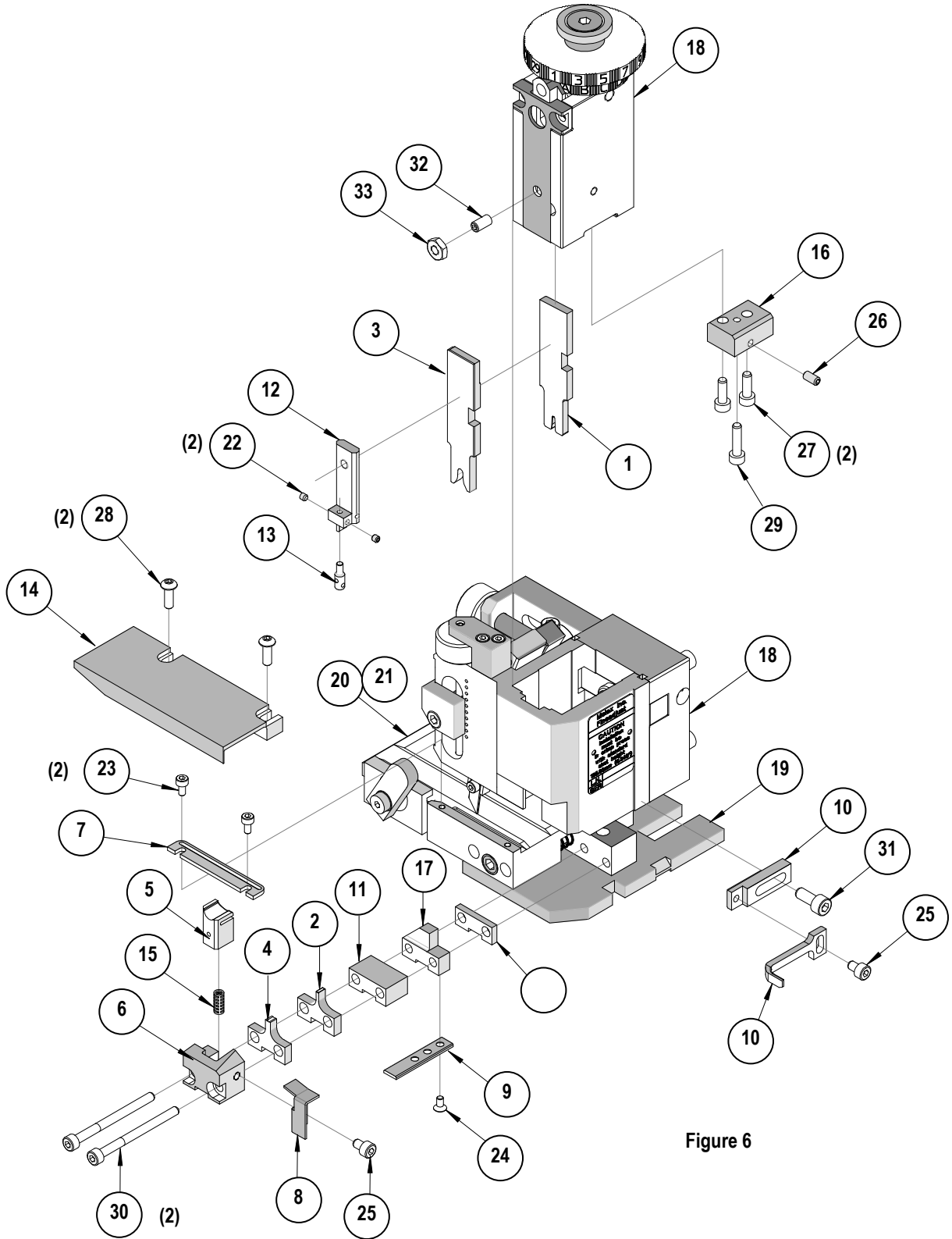


Figure 6

## 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.

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