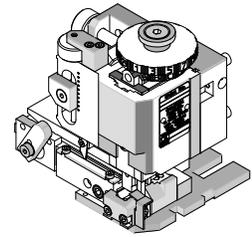




**FineAdjust  
Applicator**

**Application Tooling  
Specification Sheet**



**Order No. 63901-4800**

**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

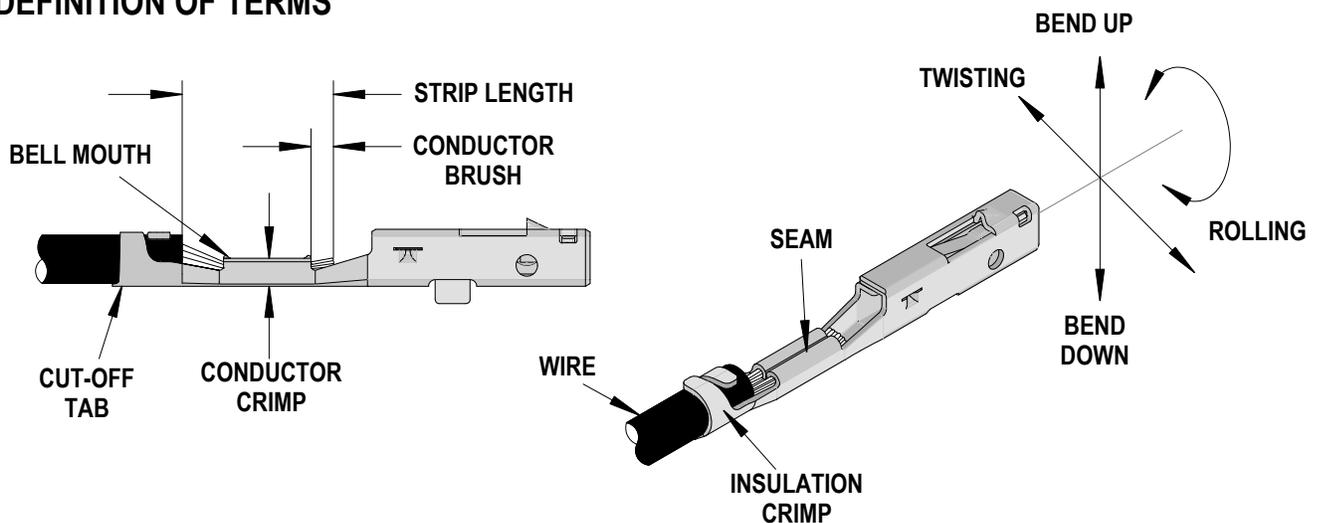
**SCOPE**

Products: CTX50 Receptacle Terminal Unsealed, 0.08-0.13mm<sup>2</sup>.

Terminal Series No.	Terminal Order No.	Wire Size and Type		Insulation Diameter ♦		Strip Length	
		mm <sup>2</sup>	Type	mm	In.	mm	In.
560023	560023-0422	0.08	CHFUS	0.75-0.85	.030-.034	3.00-3.20	.118-.126
		0.13	CHFUS	0.85-0.95	.033-.037	2.80-3.00	.110-.118

♦ To achieve optimum IPC-A620 insulation crimps, use this insulation OD range.  
Oiler (63801-7240) Required to crimp terminals. See 63800-4900 FineAdjust Manual.

**DEFINITION OF TERMS**



## CRIMP SPECIFICATION

Terminal Series No.	Bell mouth		Cut-off Tab Maximum		▶ Conductor Brush Maximum	
	mm	In.	mm	In.	mm	In.
560023	N/A	N/A	0.50	.020	0.55	.022

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	
560023	1	1	1	1	0.80	.032	1.00	.039	

After crimping, the crimp profiles should measure the following:

Terminal Series No.	Wire Size	Conductor				Pull Force Minimum	
		Crimp Height		Crimp Width (Ref.)		N	Lb.
		mm	In.	mm	In.		
560023	0.08	0.50-0.56	.020-.022	0.83	.033	10.0	2.25
	0.13	0.56-0.62	.022-.024	0.83	.033	20.0	4.50

Terminal Series No.	Wire Size	Insulation Diameter		Insulation			
				Crimp Height		Crimp Width (Ref.)	
		mm <sup>2</sup>	mm	In.	Mm	In.	mm
560023	0.08	0.75-0.85	.030-.034	0.95-1.05	.037-.041	0.98-1.08	.039-.043
	0.13	0.85-0.95	.033-.037	1.12-1.22	.044-.048	0.98-1.08	.039-.043

▶ Tool Qualification Notes:

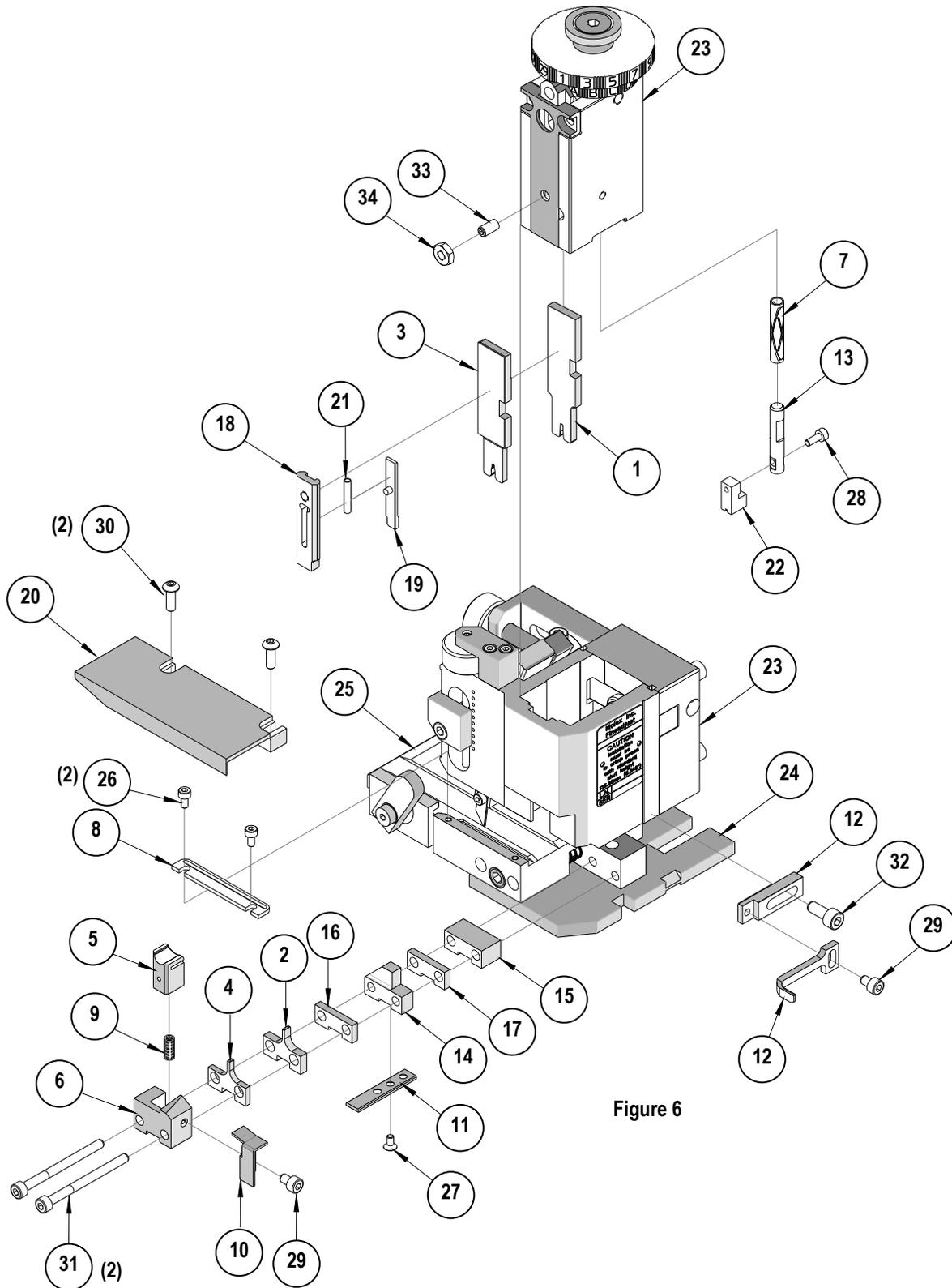
1. Pull Force should be measured with no influence from the insulation crimp.
2. The above specifications are guidelines to an optimum crimp.

**PARTS LIST**

<b>FineAdjust Applicator 63901-4800</b>				
<b>Item</b>	<b>Order No</b>	<b>Engineering No.</b>	<b>Description</b>	<b>Quantity</b>
<b>Perishable Tooling</b>				
	63901-4870	63901-4870	Tool Kit (All "Y" Items)	REF
1	63457-0054	63457-0054	Conductor Punch	1 Y
2	63455-0076	63455-0076	Conductor Anvil	1 Y
3	63454-0098	63454-0098	Insulation Punch	1 Y
4	63445-1021	63445-1021	Insulation Anvil	1 Y
5	63443-0005	63443-0005	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	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	63443-1720	63443-1720	19.00mm Height Spacer	1
15	63443-2212	63443-2212	12.00mm Coarse Spacer	1
16	63443-2306	63443-2306	3.30mm Fine Spacer	1
17	63443-2308	63443-2308	3.40mm Fine Spacer	1
18	63443-2802	63443-2802	Front Plunger Striker	1
19	63443-2908	63443-2908	Wire Hold-Down Plunger	1
20	63443-6001	63443-6001	Rear Cover	1
21	63600-0021	63600-0021	Striker Plunger Spring	1
22	63901-4804	63901-4804	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 SHCS	2**
27	N/A	N/A	M3 by 6 Long FHCS	1**
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



## 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>