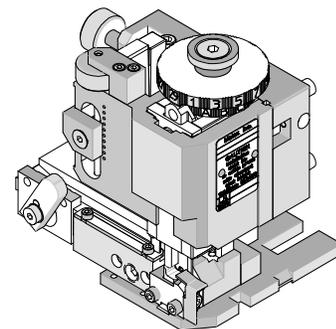




# FineAdjust Applicator Specification Sheet Order No. 63901-4100



## FEATURES

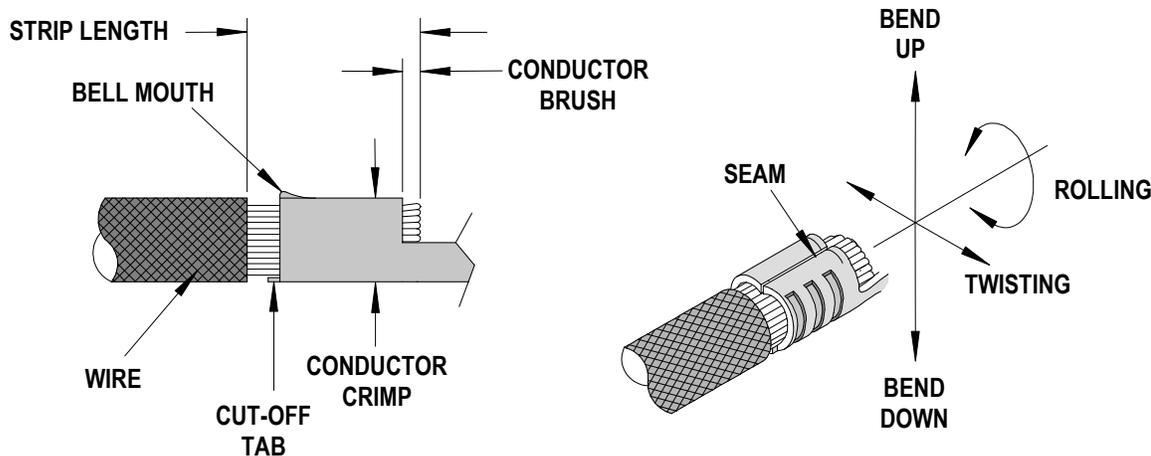
- Directly adapts to most automatic wire processing machines
- Quick punch removal with the push of a button for fast and easy tooling change
- Applicator designed to industry standard mounting and shut height 135.80mm (5.346")
- Quick set-up time; plus the crimp height, track and feed adjustments can 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: Projector Lamp Plug and Receptacle Terminal, 18-22 AWG.

Terminal Series No.	Terminal Order No.		Wire Size		Insulation Diameter		Strip Length	
			AWG	mm <sup>2</sup>	mm	In.	mm	In.
78036	78036-2001	78036-2005	18-22	0.80-0.35	2.06-3.85	.081-.152	3.00-4.00	.118-.158
78037	78037-2001	78037-2005	18-22	0.80-0.35	2.06-3.85	.081-.152	3.00-4.00	.118-.158

## DEFINITION OF TERMS



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

### CRIMP SPECIFICATION

Terminal Series No.	Bell mouth		Cut-off Tab Maximum		Conductor Brush	
	mm	In.	mm	In.	mm	In.
78036	0.05-0.30	.002-.012	0.15	.006	0.20-1.00	.008-.039
78037	0.05-0.30	.002-.012	0.15	.006	0.20-1.00	.008-.039

Terminal Series No.	Bend up	Bend down	Twist	Roll	Punch Width mm (Ref)		Seam Seam shall not be open and no wire allowed out of the crimping area
	Degree (Max)		Degree (Max)		Conductor		
	mm	In	mm	In	mm	In	
78036	3	3	3	5	2.00	.079	
78037	3	3	3	5	2.00	.079	

After crimping, the conductor profile should measure the following.

Terminal Series No.	Wire Size	Actual mm <sup>2</sup>	Conductor Crimp				Pull Force Minimum	
			Crimp Height		Crimp Width (Ref.)		N	Lb.
			mm	In.	mm	In.		
78036	18 AWG	0.80	1.30-1.40	.051-.055	2.00	.079	107.87	24.25
	20 AWG	0.50	1.15-1.22	.045-.048	2.00	.079	58.84	13.23
	22 AWG	0.35	1.07-1.15	.042-.045	2.00	.079	39.23	8.82
78037	18 AWG	0.80	1.30-1.40	.051-.055	2.00	.079	107.87	24.25
	20 AWG	0.50	1.15-1.22	.045-.048	2.00	.079	58.84	13.23
	22 AWG	0.35	1.07-1.15	.042-.045	2.00	.079	39.23	8.82

Tool Qualification Notes:

1. The above specifications are guidelines to an optimum crimp.

**PARTS LIST**

<b>FineAdjust Applicator 63901-4100</b>				
<b>Item</b>	<b>Order No</b>	<b>Engineering No.</b>	<b>Description</b>	<b>Quantity</b>
<b>Perishable Tooling</b>				
	63901-4170	63901-4170	Tool Kit (All "Y" Items)	REF
1	63444-2017	63444-2017	Conductor Punch	1 Y
2	63455-0084	63455-0084	Conductor Anvil	1 Y
3	63443-0035	63443-0035	Front Cut-Off Plunger	1 Y
4	63443-0036	63443-0036	Front Plunger Retainer	1 Y
<b>Other Components</b>				
5	11-18-4083	60707-8	Feed Guide	1
6	63443-3160	63443-3160	Front Plunger Striker	1
7	63443-0009	63443-0009	Front Scrap Chute	1
8	63443-0024	63443-0024	Key	1
9	63443-0090	63443-0090	Wire Stop	1
10	63443-1718	63443-1718	18.80mm Height Spacer	1
11	63443-2215	63443-2215	15.00mm Coarse Spacer	1
12	63443-2314	63443-2314	3.70mm Fine Spacer	1
13	63443-6004	63443-6004	Rear Cover	1
14	63454-0101	63454-0101	Punch Spacer	1
15	63700-0539	63700-0539	Cut-Off Plunger Spring	1
<b>Frame</b>				
16	63800-4901	63800-4901	Top	1
17	63801-3281	63801-3281	Base	1
18	63801-4650	63801-4650	Track	1
<b>Hardware</b>				
19	N/A	N/A	M3 by 6 Long SHCS	2**
20	N/A	N/A	M3 by 6 Long FHCS	1**
21	N/A	N/A	M4 by 6 Long SHCS	2**
22	N/A	N/A	M4 by 12 Long BHCS	2**
23	N/A	N/A	M4 by 50 Long SHCS	2**
24	N/A	N/A	M5 by 12 Lg SHCS	1**
25	N/A	N/A	#10-32 by 3/8" Long Flat Point SSS	1**
26	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

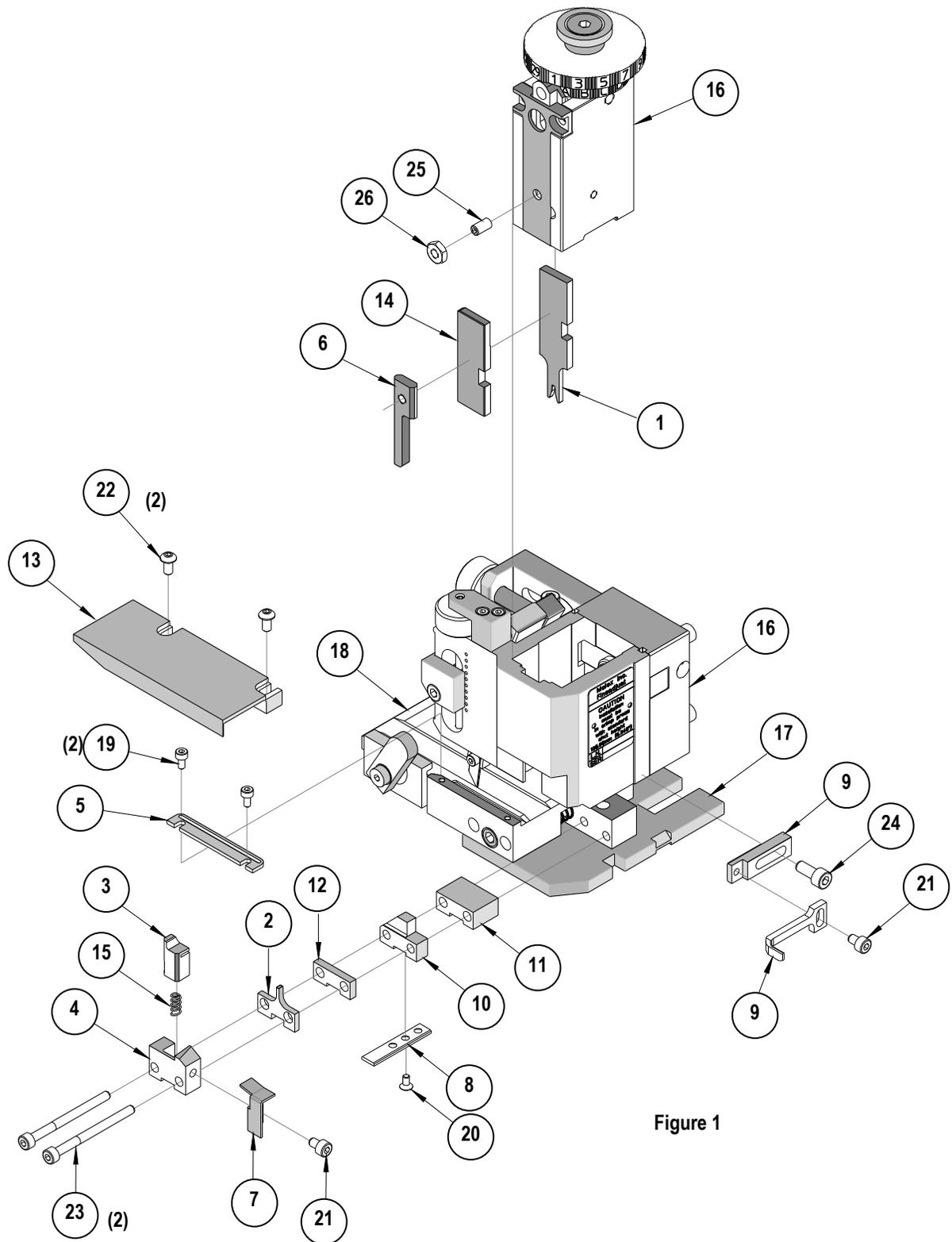


Figure 1

## 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.

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