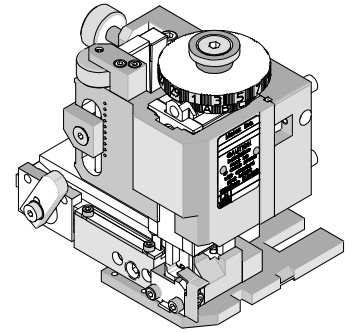




## FineAdjust Applicator Specification Sheet Part No. 63861-7100



### FEATURES

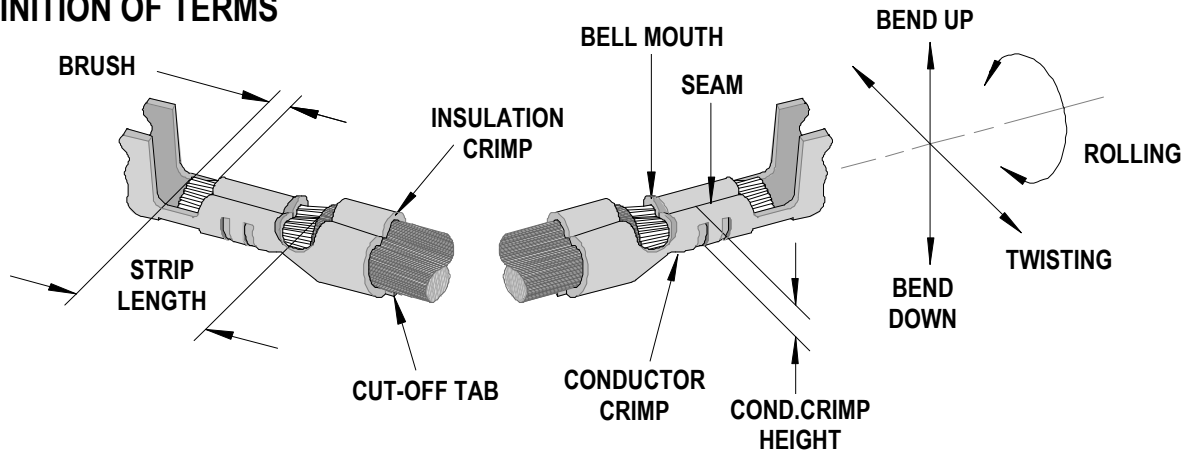
- Quick punch removal with the push of a button for fast and easy tooling change
- Applicator designed to industry standard mounting and shut height 135.80mm (5.346")
- Quick set-up time; plus the crimp height, track and feed adjustments can be set without removing the applicator from the press
- Fine 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: 2.5 Mini Splash Proof Wire-to-Wire Crimp Terminal 20-22 AWG.

Terminal Series No.	Terminal Order No.	Wire Size		Insulation Diameter		Strip Length	
		AWG	mm <sup>2</sup>	mm	In.	mm	In.
50147 50148	50147-8000 50148-8000	22	---	1.40-1.90	.075-.055	2.00-2.50	.078-.098
			AVSS-0.3				
			CAVS-0.3				
			CAVUS-0.3				
		20	---				
			AVSS-0.5				
	CAVS-0.5						
		CAVUS-0.5					

### 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.
50147	0.00-0.30	.000-.012	0.00-0.30	.000-.012	0.10-0.90	.004-.035
50148						

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	
50147	2	3	3	10	1.40	.055	1.60	.063	
50148									

After crimping, the crimp profiles should measure the following:

Terminal Series No.	Wire Size		Conductor		Insulation		Pull Force Minimum		
			Crimp Height		Crimp Height Maximum				
	AWG	mm <sup>2</sup>	mm	In.	mm	In.	N	Lb.	
50147 50148	22	---	0.94-0.99	.037-.039	1.70	.067	49.0	11.0	
		AVSS-0.3	0.94-0.99	.037-.039	1.70	.067	49.0	11.0	
		CAVS-0.3							
		20	---	0.96-1.06	.038-.042	1.80	.071	53.9	12.1
		AVSS-0.5	0.96-1.06	.038-.042	1.80	.071	53.9	12.1	
		CAVS-0.5							
		CAVUS-0.3	0.94-0.99	.037-.039	1.55	.061	49.0	11.0	
		CAVUS-0.5	0.96-1.06	.038-.042	1.80	.067	53.9	12.1	

■ 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 63861-7100</b>				
<b>Item</b>	<b>Order No</b>	<b>Engineering No.</b>	<b>Description</b>	<b>Quantity</b>
<b>Perishable Tooling</b>				
	63861-7170	63861-7170	Tool Kit (All "Y" Items)	REF
1	63444-1407	63444-1407	Conductor Punch	1 Y
2	63445-1430	63445-1430	Conductor Anvil	1 Y
3	63454-1601	63454-1601	Insulation Punch	1 Y
4	63445-1615	63445-1615	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 (17150)</b>				
7	11-18-4083	60707-8	Front Cover	1
8	11-24-1067	4996-4	Cut-off Plunger Spring	1
9	11-40-4039	8302-5	Plunger Striker Front	1
10	63443-0009	63443-0009	Scrap Chute Front	1
11	63443-0021	63443-0021	Lower Tooling Key	1
12	63443-2405	63443-2405	Anvil Mount	1
13	63443-4005	63443-4005	Wire Stop	1
14	63443-6003	63443-6003	Rear Cover	1
<b>Frame</b>				
15	63800-4901	63800-4901	Top	1
16	63801-3281	63801-3281	Base	1
17	63801-4650	63801-4650	Track	1
<b>Hardware</b>				
18	N/A	N/A	M3 by 6 Long SHCS	2**
19	N/A	N/A	M3 by 6 Long FHCS	1**
20	N/A	N/A	M4 by 6 Long SHCS	1**
21	N/A	N/A	M4 by 12 Long BHCS	2**
22	N/A	N/A	M4 by 16 Long SHCS	1**
23	N/A	N/A	M4 by 20 Long SHCS	1**
24	N/A	N/A	M4 by 50 Long 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

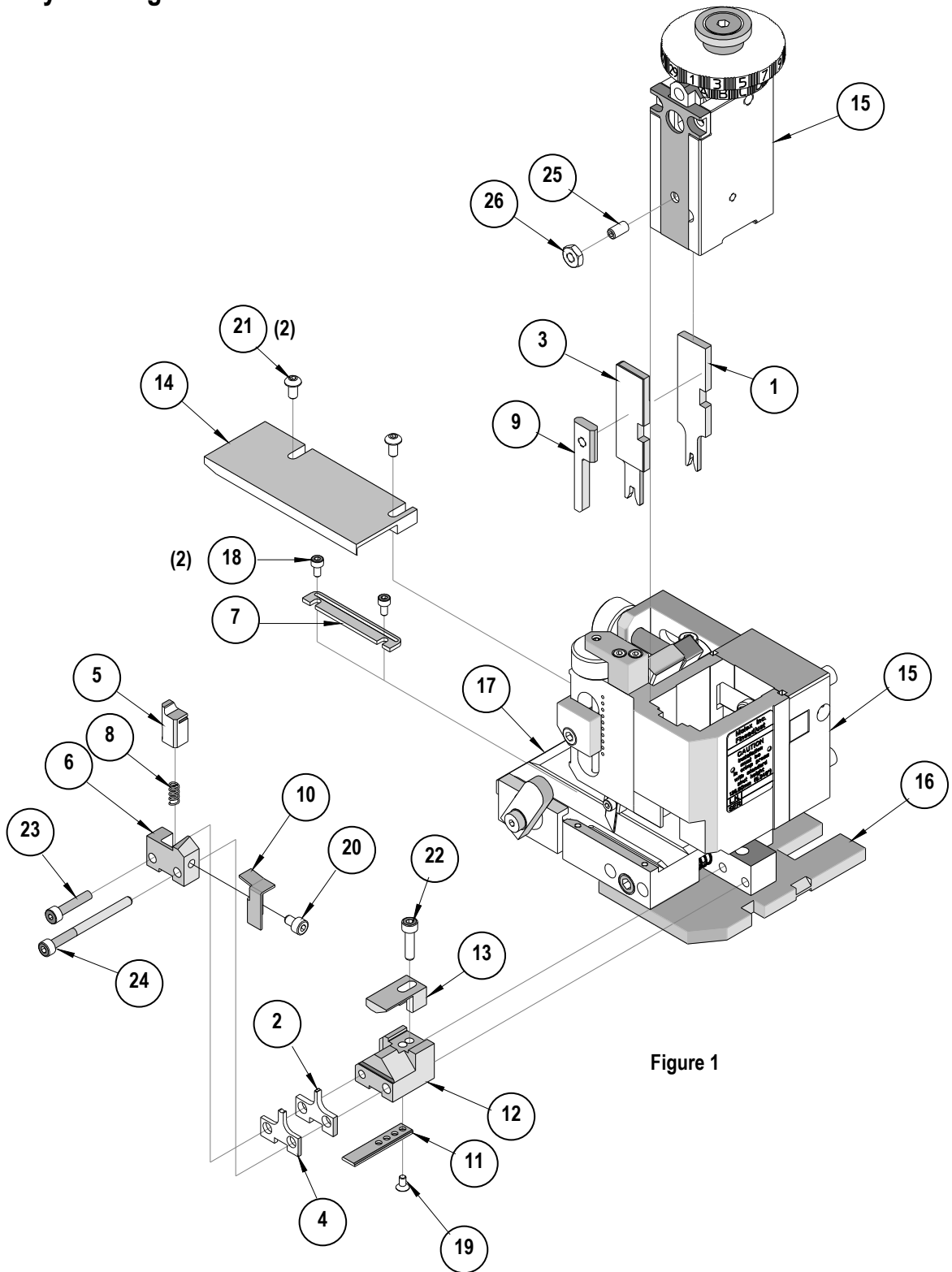


Figure 1

## 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 135.80 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.

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