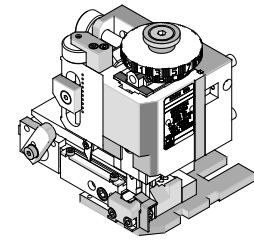


**FineAdjust  
Applicator**



**Application Tooling  
Specification Sheet**



**Order No. 63903-0100**

**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

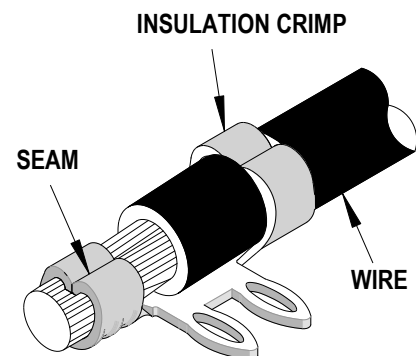
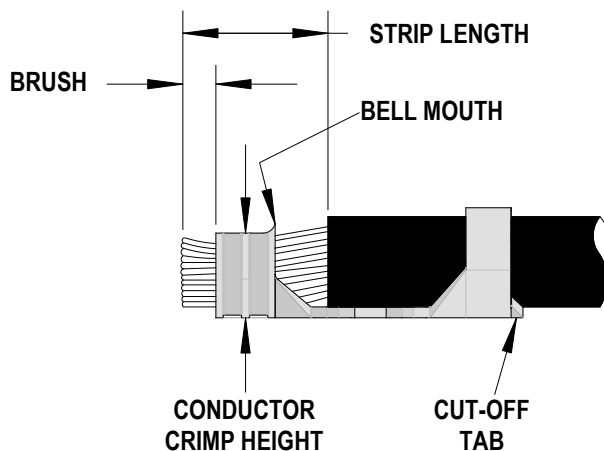
**SCOPE**

Products: Solder Right In-Board Terminals, 26-28AWG.

Terminal Series No.	Terminal Order No.	Wire Size		◆Insulation Diameter UL1007 Wire is Recommended				Strip Length	
				IPC/WHMA-A620 (1)		Terminal			
		AWG	mm <sup>2</sup>	mm	In.	mm	In.	mm	In.
172677	172677-0200	26-28	---	1.20-1.30	.047-.051	1.20-1.30	.047-.051	2.50-3.00	.098-.118

(1) To achieve optimum IPC-A620 Class 2 insulation crimps, use this insulation OD.  
**Note:** Oiler (Order No. 63801-7240) is required to crimp these terminals. See Fine Adjust Manual (Order no. 63800-4900).

**DEFINITION OF TERMS**



### CRIMP SPECIFICATION

Terminal Series No.	Bell mouth		Cut-off Tab Maximum		Conductor Brush	
	mm	In.	mm	In.	mm	In.
172677	0.20-0.40	.008-.016	0.50	.020	0.00-0.70	.000-.027

Terminal Series No.	Bend up Degree (Max)	Bend down Degree (Max)	Twist Degree (Max)	Roll Degree (Max)	Punch Width (Ref)				Seam Seam shall not be open and no wire allowed out of the crimping area
					Conductor		Insulation		
					mm	In	mm	In	
172677	3	3	5	5	1.00	.039	1.70	.067	

After crimping, the conductor profile should measure the following.

Terminal Series No.	Wire Size		Conductor				Pull Force Minimum	
			Crimp Height		Crimp Width (Ref.)		▶ See Tool Qualification Notes	
	AWG	mm <sup>2</sup>	mm	In.	mm	In.	N	Lb.
172677	26	---	0.85-0.90	.033-.035	1.00-1.10	.039-.043	13.4	3.0
	28	---	0.80-0.85	.031-.033	1.00-1.10	.039-.043	8.9	2.0

Terminal Series No.	Wire Size		Insulation			
			Crimp Height (Ref.)		Crimp Width (Ref.)	
	AWG	mm <sup>2</sup>	mm	In.	mm	In.
172677	26	---	1.30	.051	1.70	.067
	28	---	1.30	.051	1.70	.067

▶ **Tool Qualification Notes:**

The above specifications are guidelines to an optimum crimp.

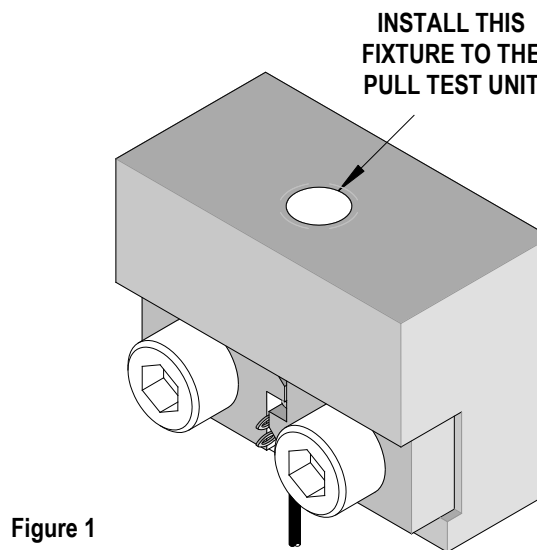
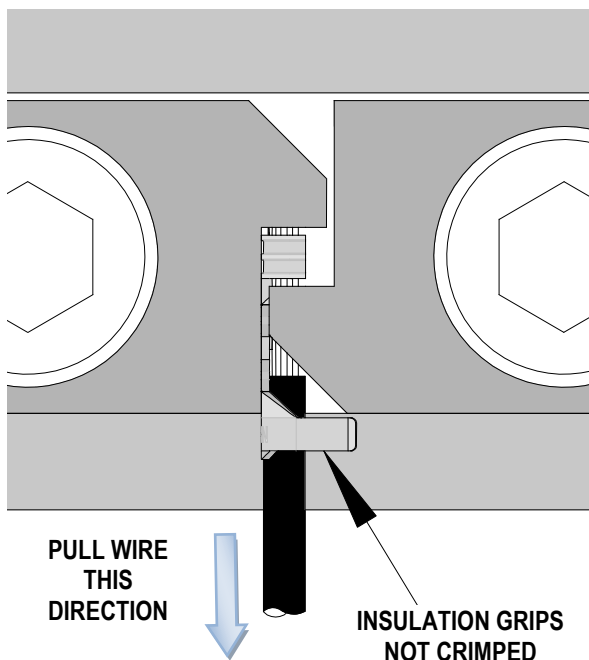


Figure 1

**PARTS LIST**

<b>FineAdjust Applicator 63903-0100</b>				
<b>Item</b>	<b>Order No</b>	<b>Engineering No.</b>	<b>Description</b>	<b>Quantity</b>
<b>Perishable Tooling</b>				
	63903-0170	63903-0170	Tool Kit (All "Y" Items)	REF
1	63457-1001	63457-1001	Conductor Punch	1 Y
2	63445-1127	63445-1127	Conductor Anvil	1 Y
3	63454-1701	63454-1701	Insulation Punch	1 Y
4	63445-1735	63445-1735	Insulation Anvil	1 Y
5	63456-4001	63456-4001	Anvil	1 Y
6	63443-0005	63443-0005	Front Cut-Off Plunger	1 Y
7	63443-0012	63443-0012	Front Plunger Retainer	1 Y
<b>Other Components</b>				
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	Front Scrap Chute	1
11	63443-0024	63443-0024	Key	1
12	63443-2806	63443-2806	Front Plunger Striker	1
13	63443-2917	63443-2917	Wire Hold-Down Plunger	1
14	63443-6109	63443-6109	Rear Cover	1
15	63600-1057	63600-1057	Compression Spring	1
16	63903-0151	63903-0151	Anvil Mount	1
17	63903-0152	63903-0152	Wire Stop	1
18	63903-0153	63903-0153	Terminal Stripper	1
<b>Frame</b>				
19	63800-4901	63800-4901	Top	1
20	63801-3281	63801-3281	Base	1
21	63801-4650	63801-4650	Track	1
22	63860-2015	63860-2015	Drag Frame	1
<b>Hardware</b>				
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	3**
26	N/A	N/A	M4 by 12 Long BHCS	2**
27	N/A	N/A	M4 by 50 Long SHCS	2**
28	N/A	N/A	#10-32 by 3/8" Long Flat Point SSS	1**
29	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

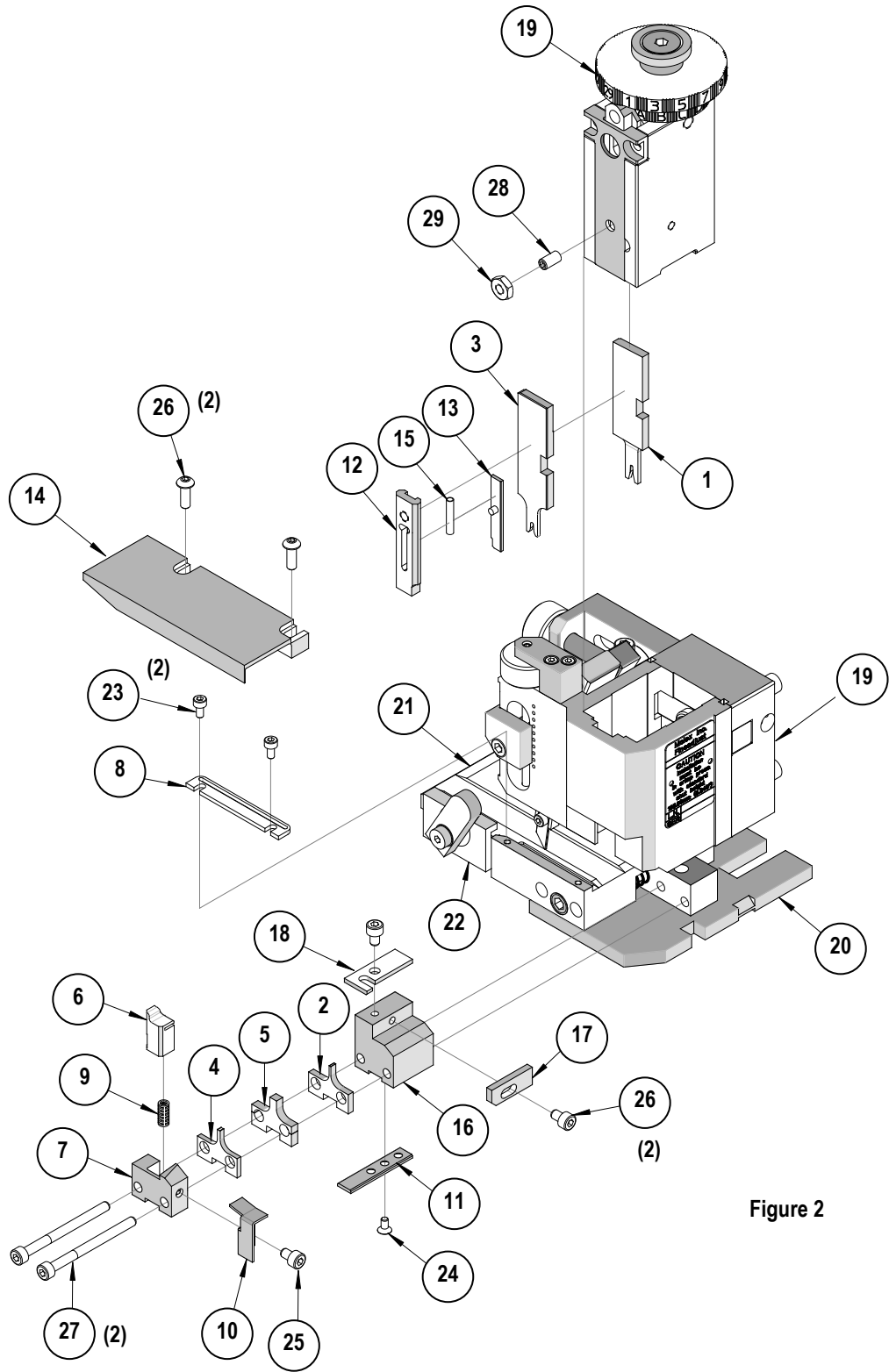


Figure 2

## 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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