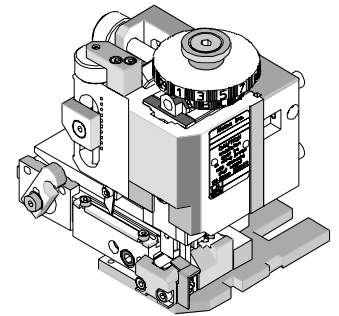




FineAdjust Applicator Specification Sheet Part No. 63866-7000



FEATURES

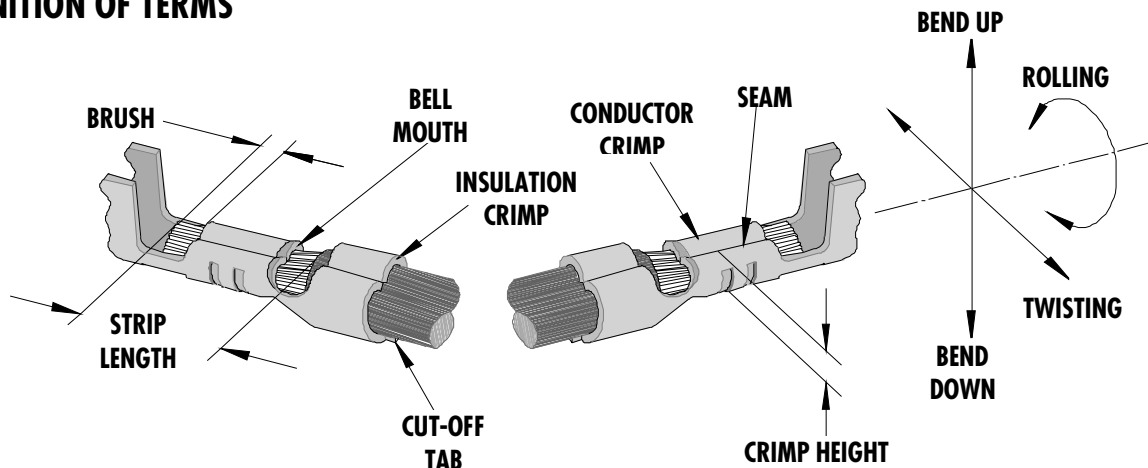
- Directly adapts to most automatic wire processing machines
- Quick punch removal with the push of a button for fast and easy tooling change
- Applicator designed to industry standard mounting and shut height 135.80mm (5.346")
- Quick set-up time; plus the crimp height, track and feed adjustments can 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: MOX 0.635mm (.025") Receptacle Crimp Terminal, .75 mm² wire.

Terminal Series No.	Terminal Order No.	Wire Size	Actual mm ²	Wire Type	Insulation Diameter		Strip Length	
					mm	In.	mm	In.
98658	98658-1212	0.75 mm ²	0.79	ID	1.60-1.80	.063-.071	3.35-3.65	.132-.144
	98658-1222							
	98658-1232							

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.
98658	0.20-0.50	.008-.020	0.30	.012	0.10-0.50	.004-.020

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			
98658	3	3	5	6	1.40	.055	2.10	.083	

After crimping, the conductor profile should measure the following.

Terminal Series No.	Wire Size	Actual mm ²	Wire Type	Conductor			
				Crimp Height		Crimp Width (Ref)	
				mm	In.	mm	In.
98658	0.75 mm ²	0.79	ID	1.02-1.08	.040-.043	1.40	.055

Terminal Series No.	Wire Size	Actual mm ²	Wire Type	Insulation				Pull Force Minimum	
				Crimp Height (Maximum)		Crimp Width (Ref)		N	Lb.
				mm	In.	mm	In.		
98658	0.75 mm ²	0.79	ID	2.11	.083	2.10	.083	100.0	22.5

Pull Force should be measured with no influence from the insulation crimp.

The above specifications are guidelines to an optimum crimp.

PARTS LIST

FineAdjust Applicator 63866-7000				
Item	Order No	Engineering No.	Description	Quantity
Perishable Tooling				
	63866-7070	63866-7070	Tool Kit (All "Y" Items)	REF
1	63457-0019	63457-0019	Conductor Punch	1 Y
2	63455-0019	63455-0019	Conductor Anvil	1 Y
3	63454-0029	63454-0029	Insulation Punch	1 Y
4	63456-0025	63456-0025	Insulation Anvil	1 Y
5	63443-0003	63443-0003	Front Cut-Off Plunger	1 Y
6	63443-0012	63443-0012	Front Plunger Retainer	1 Y
Other Components(REF 666050)				
7	11-18-4083	60707-8	Feed Guide	1
8	11-24-1067	4996-4	Cut-Off Plunger Spring	1
9	11-40-4039	8302-5	Plunger Striker	1
10	63443-0009	63443-0009	Front Scrap Chute	1
11	63443-0024	63443-0024	Key	1
12	63443-0092	63443-0092	Wire Stop	1
13	63443-1716	63443-1716	18.60mm Spacer	1
14	63443-2215	63443-2215	15.00mm Spacer	1
15	63443-2312	63443-2312	3.60mm Spacer	1
16	63443-6117	63443-6117	Rear Cover	1
Frame				
17	63800-4901	63800-4901	Top	1
18	63801-3281	63801-3281	Base	1
19	63801-4650	63801-4650	Track	1
Hardware				
20	N/A	N/A	M3 by 6 Long SHCS	2**
21	N/A	N/A	M3 by 6 Long FHCS	1**
22	N/A	N/A	M4 by 6 Long SHCS	2**
23	N/A	N/A	M4 by 12 Long BHCS	2**
24	N/A	N/A	M4 by 50 Long SHCS	2**
25	N/A	N/A	M5 by 12 Lg SHCS	1**
26	N/A	N/A	#10-32 by 3/8" Long Flat Point SSS	1**
27	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

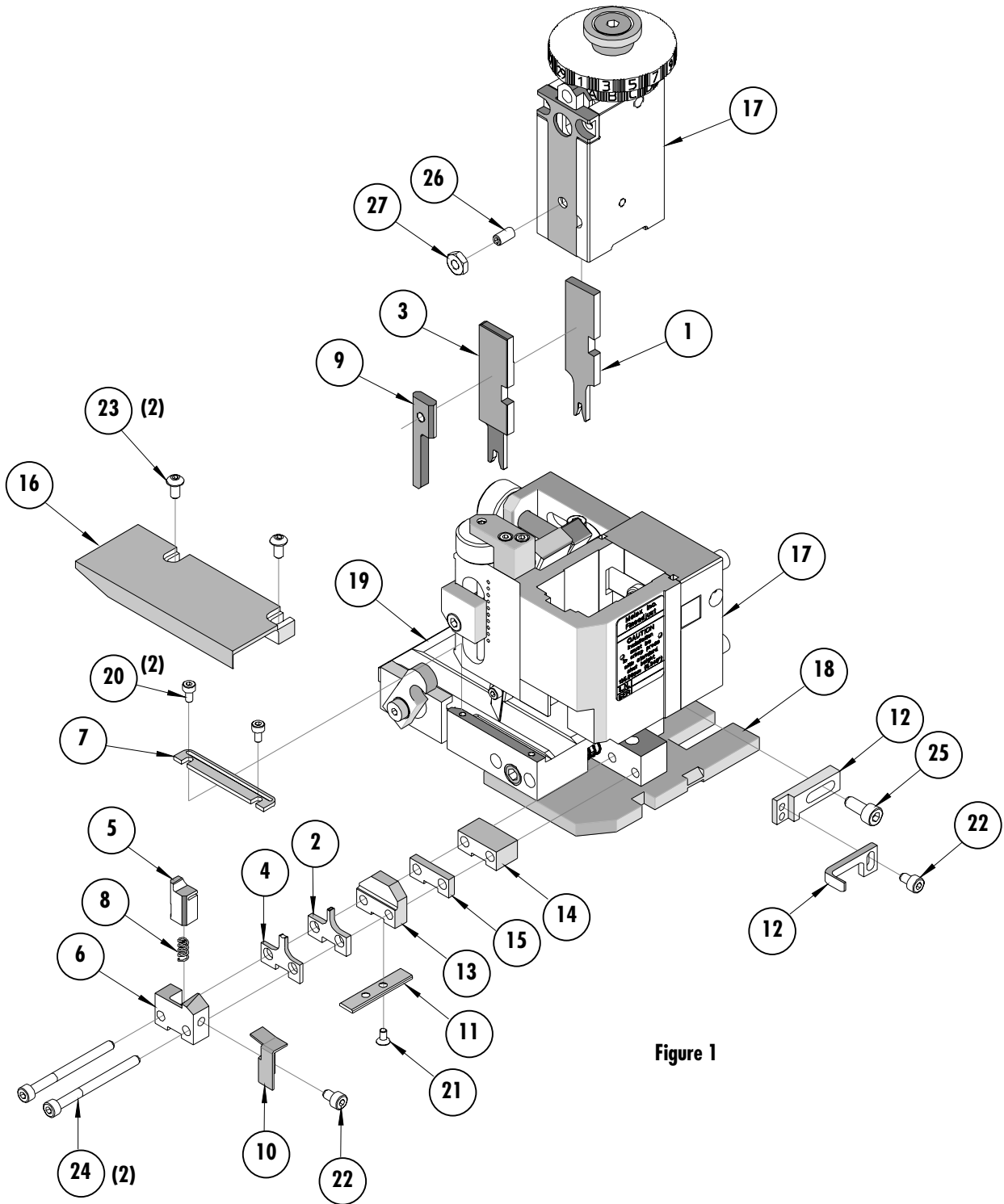


Figure 1

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.

Americas Headquarters

Lisle, Illinois 60532 U.S.A.
1-800-78MOLEX
amerinfo@molex.com

Far East North Headquarters

Yamato, Kanagawa, Japan
81-462-65-2324
feninfo@molex.com

Far East South Headquarters

Jurong, Singapore
65-6-268-6868
fesinfo@molex.com

European Headquarters

Munich, Germany
49-89-413092-0
eurinfo@molex.com

Corporate Headquarters

2222 Wellington Ct.
Lisle, IL 60532 U.S.A.
630-969-4550
Fax: 630-969-1352

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