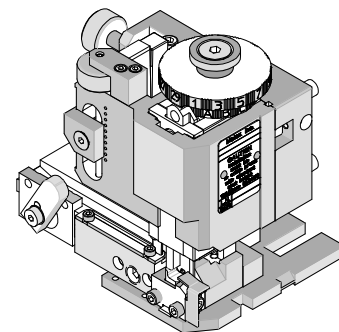




# FineAdjust Applicator Specification Sheet Order No. 63901-1600



## 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

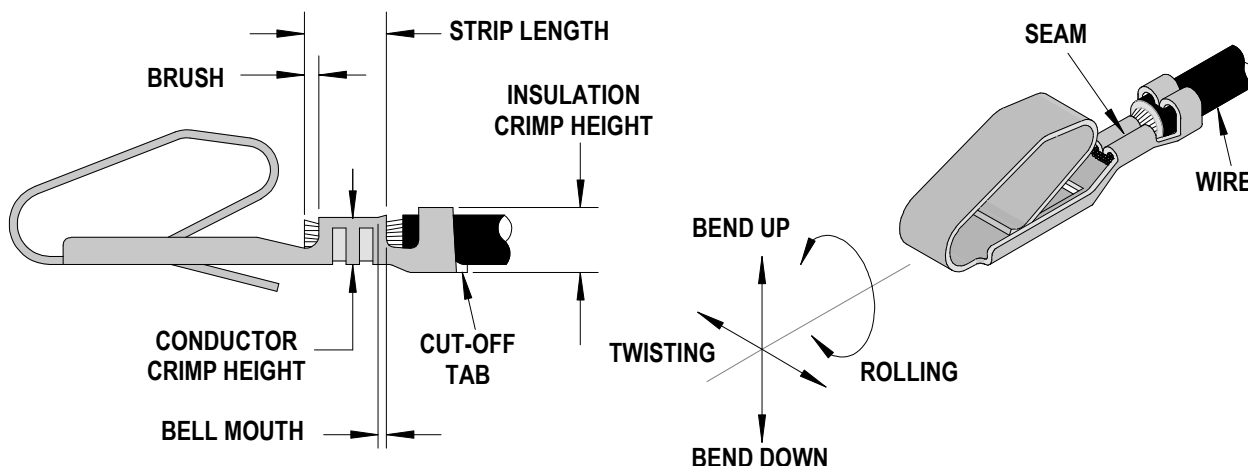
## SCOPE

Products: Bulb Socket Contact Terminal, 0.50-0.85mm<sup>2</sup>.

Terminal Series No.	Terminal Order No.	Wire Size		Insulation Diameter				Strip Length	
				IPC/WHMA-A620 ♦		Terminal ♦♦			
		AWG	mm <sup>2</sup>	mm	In.	mm	In.	mm	In.
35438	35438-8000	0.50	0.50	1.80-2.80	.071-.110	1.80-2.80	.071-.110	3.00-3.60	.118-.142
		0.85	0.85						

♦ To achieve optimum IPC-A620 insulation crimps, use this insulation OD range.  
♦♦ Overall insulation OD specification for terminal.

## DEFINITION OF TERMS



### CRIMP SPECIFICATION

Terminal Series No.	Bell mouth		Cut-off Tab Maximum		Conductor Brush	
	mm	In.	mm	In.	mm	In.
35438	0.30-0.60	.012-.024	.50	.020	0.30-0.80	.012-.032

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
					Conductor		Insulation		
	Degree (Max)		Degree (Max)		mm	In	mm	In	
35438	3	3	3	5	1.90	.075	2.80	.110	

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.		
35438	0.50	0.50	1.00-1.10	.039-.043	1.90-2.10	.075-.083	58.9	13.2
	0.85	0.85	1.20-1.30	.047-.051	1.90-2.10	.075-.083	98.1	22.1

Terminal Series No.	Wire Size	Actual mm <sup>2</sup>	Insulation			
			Crimp Height (Ref.)		Crimp Width (Ref.)	
			mm	In.	mm	In.
35438	0.50	0.50	2.55	.100	2.70-2.90	.106-.114
	0.85	0.85	2.60	.104	2.70-2.90	.106-.114

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

The above specifications are guidelines to an optimum crimp.

**PARTS LIST**

<b>FineAdjust Applicator 63901-1600</b>				
<b>Item</b>	<b>Order No</b>	<b>Engineering No.</b>	<b>Description</b>	<b>Quantity</b>
<b>Perishable Tooling</b>				
	63901-1670	63901-1670	Tool Kit (All "Y" Items)	REF
1	63444-1917	63444-1917	Conductor Punch	1 Y
2	63445-1955	63445-1955	Conductor Anvil	1 Y
3	63446-2821	63446-2821	Insulation Punch	1 Y
4	63445-2823	63445-2823	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
<b>Other Components(REF 011650)</b>				
7	11-18-4083	60707-8	Feed Guide	1
8	11-24-1067	4996-4	Cut-Off Plunger Spring	1
9	63443-0009	63443-0009	Front Scrap Chute	1
10	63443-0025	63443-0025	Key	1
11	63443-0090	63443-0090	Wire Stop	1
12	63443-1719	63443-1719	18.90mm Height Spacer	1
13	63443-2205	63443-2205	3.00mm Coarse Spacer	1
14	63443-2210	63443-2210	10.00mm Coarse Spacer	1
15	63443-2312	63443-2312	3.60mm Fine Spacer	1
16	11-40-4039	8302-5	Front Plunger Striker	1
17	63443-6112	63443-6112	Rear Cover	1
<b>Frame</b>				
18	63800-4901	63800-4901	Top	1
19	63801-3281	63801-3281	Base	1
20	63801-4650	63801-4650	Track	1
<b>Hardware</b>				
21	N/A	N/A	M3 by 6 Long SHCS	2**
22	N/A	N/A	M3 by 6 Long FHCS	1**
23	N/A	N/A	M4 by 6 Long SHCS	2**
24	N/A	N/A	M4 by 12 Long BHCS	2**
25	N/A	N/A	M4 by 50 Long SHCS	2**
26	N/A	N/A	M5 by 12 Lg SHCS	1**
27	N/A	N/A	#10-32 by 3/8" Long Flat Point SSS	1**
28	N/A	N/A	#10-32 Hex Jam Nut	1**
** Available from an industrial supply company such as MSC (1-800-645-7270).				



## 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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