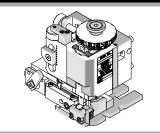


FineAdjust Applicator

Application Tooling Specification Sheet



Order No. 63900-6600

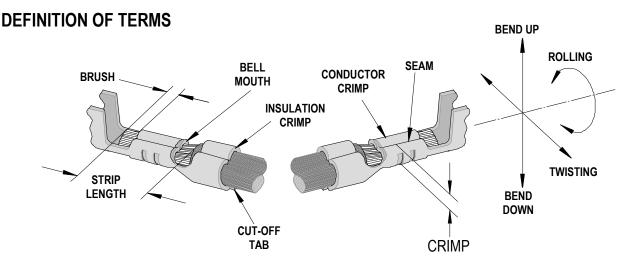
FEATURES

- 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: 1.25mm (.049") Pitch Wire-to-Board Connector Dual Plug Terminal, 26-28 AWG.

| Terminal Series No. | Terminal | Wire Size | | → Insulatio | n Diameter | Strip Length | | |
|---|-------------|-------------|-------|--------------------|------------|--------------|-----------|---------|
| Terminal Series No. | Terminai | AWG | mm² | mm | ln. | mm | ln. | |
| 501930 | 501930-0100 | 501930-1100 | 26-28 | .136079 | 0.80-1.00 | .031039 | 1.50-1.70 | .060067 |
| 502381 | 502381-0000 | 502381-0010 | 26-28 | .136079 | 0.80-1.00 | .031039 | 1.50-1.70 | .060067 |
| → This Applicator will not meet A-620 Class 1, 2, or 3 standards with insulation diameter range of 0.80-1.00mm. | | | | | | | | |



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

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CRIMP SPECIFICATION

| Terminal Series No. | Bell n | nouth | Cut-off Tab | Maximum | Conductor Brush | |
|---------------------|-----------|---------|-------------|---------|-----------------|---------|
| Terminal Series No. | Mm | ln. | mm | ln. | mm | ln. |
| 501930 | 0.10-0.30 | .004012 | 0.10 | .004 | 0.10-0.40 | .004016 |
| 502381 | 0.10-0.30 | .004012 | 0.10 | .004 | 0.10-0.40 | .004016 |

| | Bend up E | Twist Roll | | Punc | h Widt | h mm | (Ref) | Seam | |
|---------------------|-----------|------------|--------|-----------|--------|------------|-------|------|-------------------------|
| Terminal Series No. | Dellu up | | | Conductor | | Insulation | | | |
| | Degree | | Degree | | mm | ln | mm | ln | Seam shall not be open |
| 501930 | 3 | 3 | 4 | 6 | 0.80 | .031 | 0.80 | .031 | and no wire allowed out |
| 502381 | 3 | 3 | 4 | 6 | 0.80 | .031 | 0.80 | .031 | of the crimping area |

After crimping, the conductor profile should measure the following.

| | \A/iwa | C: | Conductor | | | | | |
|---------------------|--------|-----------------|-----------|---------|-------|-------------|--|--|
| Terminal Series No. | Wire | Size | Crimp | Height | Crimp | Width (Ref) | | |
| | AWG | mm ² | mm | ln. | mm | ln. | | |
| 501930 | 26 | .136 | 0.56-0.61 | .022024 | | | | |
| | 28 | .079 | 0.53-0.58 | .021023 | | | | |
| 502381 | 26 | .136 | 0.56-0.61 | .022024 | | | | |
| | 28 | .079 | 0.53-0.58 | .021023 | | | | |

| | Wire Size | | | Insulation (| Pull Force Minimum | | | |
|---------------------|-----------|-----------------|-----------|--------------|--------------------|-----|---------------------|------|
| Terminal Series No. | vviie | Size | Crimp | Height | Crimp Width | | Full Force Willimum | |
| | AWG | mm ² | mm | ln. | mm | ln. | N | Lb. |
| 501930 | 26 | .136 | 1.18-1.28 | .046050 | | | 9.8 | 2.20 |
| | 28 | .079 | 1.15-1.25 | .045049 | | | 9.8 | 2.20 |
| 502381 | 26 | .136 | 1.18-1.28 | .046050 | | | 9.8 | 2.20 |
| | 28 | .079 | 1.15-1.25 | .045049 | | | 9.8 | 2.20 |

Tool Qualification Notes:

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

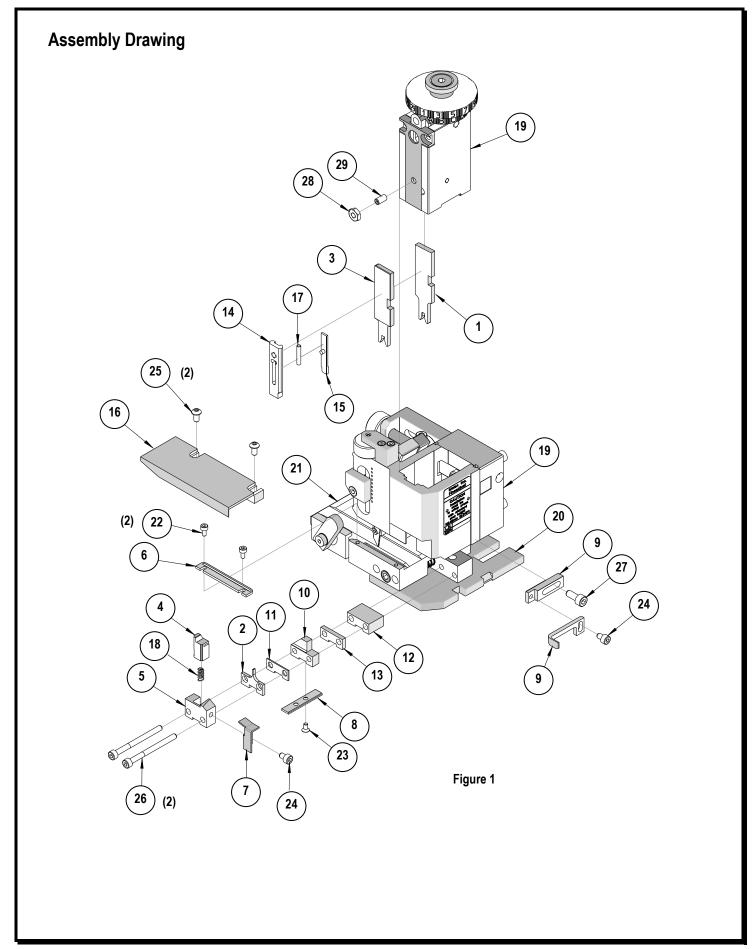
2. The above specifications are guidelines to an optimum crimp.

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PARTS LIST

| | FineAdjust Applicator 63900-6600 | | | | | | | | | |
|--------------------|--|------------|-----------------------------------|-----|--|--|--|--|--|--|
| Item | Order No Engineering No. Description | | | | | | | | | |
| Perishable Tooling | | | | | | | | | | |
| | 63900-6670 | 63900-6670 | Tool Kit (All "Y" Items) | REF | | | | | | |
| 1 | 63444-0804 | 63444-0804 | Conductor Punch | 1 Y | | | | | | |
| 2 | 63445-0821 | 63445-0821 | Anvil | 1 Y | | | | | | |
| 3 | 63446-0808 | 63446-0808 | Insulation Punch | 1 Y | | | | | | |
| 4 | 63443-0002 | 63443-0002 | Front Cut-Off Plunger | 1 Y | | | | | | |
| 5 | 63443-0012 | 63443-0012 | Front Plunger Retainer | 1 Y | | | | | | |
| | | | Components | | | | | | | |
| 6 | 11-18-4083 | 60707-8 | Feed Guide | 1 | | | | | | |
| 7 | 63443-0009 | 63443-0009 | Front Scrap Chute | 1 | | | | | | |
| 8 | 63443-0025 | 63443-0025 | Key | 1 | | | | | | |
| 9 | 63443-0090 | 63443-0090 | Wire Stop | 1 | | | | | | |
| 10 | 63443-1719 | 63443-1719 | Height Spacer (18.90mm) | 1 | | | | | | |
| 11 | 63443-2201 | 63443-2201 | Fine Spacer (1.00mm) | 1 | | | | | | |
| 12 | 63443-2216 | 63443-2216 | Coarse Spacer (16.00mm) | 1 | | | | | | |
| 13 | 63443-2310 | 63443-2310 | Fine Spacer (3.50mm) | 1 | | | | | | |
| 14 | 63443-2802 | 63443-2802 | Front Plunger Striker | 1 | | | | | | |
| 15 | 63443-2904 | 63443-2904 | Wire Hold Down Plunger | 1 | | | | | | |
| 16 | 63443-6109 | 63443-6109 | Rear Cover | 1 | | | | | | |
| 17 | 63600-0021 | 63600-0021 | Wire Hold Down Spring | 1 | | | | | | |
| 18 | 11-24-1067 | 4996-4 | Cut-Off Plunger Spring | 1 | | | | | | |
| | | | Frame | | | | | | | |
| 19 | 63800-4901 | 63800-4901 | Тор | 1 | | | | | | |
| 20 | 63801-3281 | 63801-3281 | Base | 1 | | | | | | |
| 21 | 63801-4650 | 63801-4650 | Track | 1 | | | | | | |
| | | | lardware | | | | | | | |
| 22 | N/A | N/A | M3 by 6 Long SHCS | 2** | | | | | | |
| 23 | N/A | N/A | M3 by 6 Long FHCS | 1** | | | | | | |
| 24 | N/A | N/A | M4 by 6 Long SHCS | 2** | | | | | | |
| 25 | N/A | N/A | M4 by 12 Long BHCS | 2** | | | | | | |
| 26 | N/A | N/A | M4 by 50 Long SHCS | 2** | | | | | | |
| 27 | N/A | N/A | M5 by 12 Lg SHCS | 1** | | | | | | |
| 28 | N/A | N/A | #10-32 by 3/8"Long Flat Point SSS | 1** | | | | | | |
| 29 | | | | | | | | | | |
| *: | ** Available from an industrial supply company such as MSC (1-800-645-7270). | | | | | | | | | |

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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.

Application Tooling Support

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