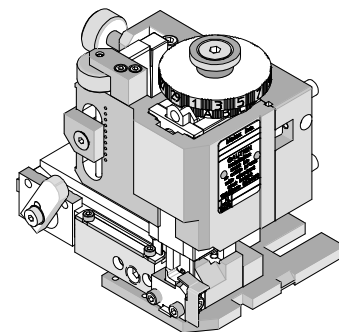




# FineAdjust Applicator Specification Sheet Order No. 63901-2000



## FEATURES

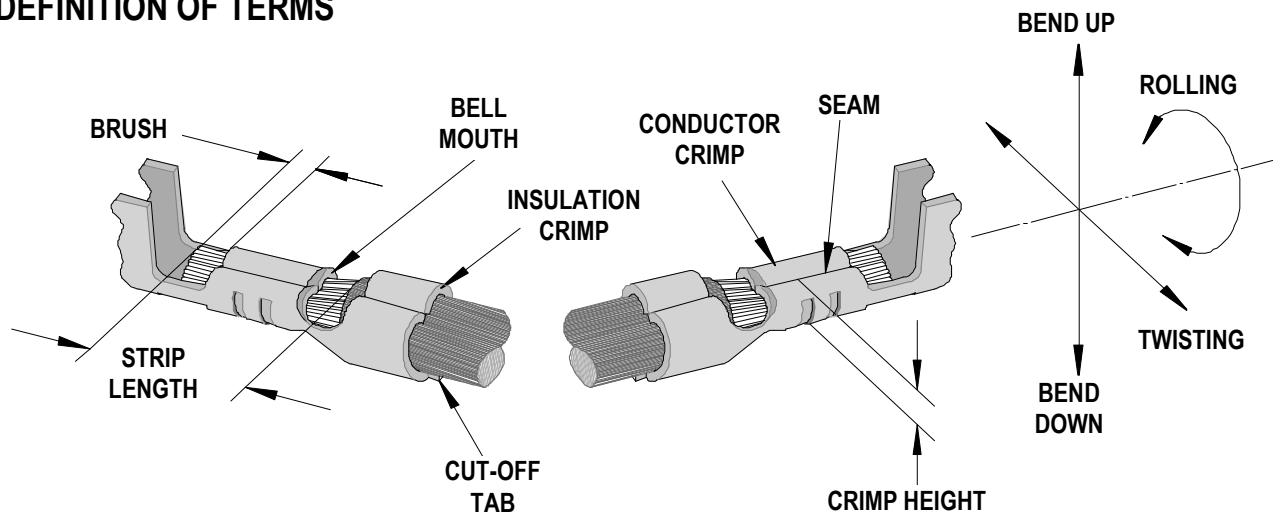
- Directly adapts to most automatic wire processing machines
- Quick punch removal with the push of a button for fast and easy tooling change
- Applicator designed to industry standard mounting and shut height 135.80mm (5.346")
- Quick set-up time; plus the crimp height, track and feed adjustments can 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: 2.00mm (.079") Pitch Wire-to-Board Crimp Terminal, 24-30 AWG.

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.
104440	104440-8041	24-30	0.20-0.05	0.80-1.45	.031-.057	0.80-1.45	.031-.057	1.00-1.30	.039-.051
◆ UL1007 wire recommended									

## 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.
104440	0.05-0.35	.002-.014	0.15	.006	0.00-0.50	.000-.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
					Conductor		Insulation		
	Degree	Degree	mm	In	mm	In			
104440	4	3	3	4	1.00	.039	1.50	.059	

After crimping, the conductor profile should measure the following.

Terminal Series No.	Wire Size		Conductor Crimp Height		Pull Force Minimum	
	AWG	mm <sup>2</sup>	mm	In.	N	Lb.
104440	24	0.20	0.60-0.65	.024-.026	29.3	6.60
	26	0.12	0.59-0.64	.023-.025	19.6	4.40
	28	0.08	0.56-0.61	.022-.024	9.8	2.20
	30	0.05	0.53-0.58	.021-.023	4.9	1.10

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 63901-2000</b>				
<b>Item</b>	<b>Order No</b>	<b>Engineering No.</b>	<b>Description</b>	<b>Quantity</b>
<b>Perishable Tooling</b>				
	63901-2070	63901-2070	Tool Kit (All "Y" Items)	REF
1	63444-1003	63444-1003	Conductor Punch	1 Y
2	63445-1013	63445-1013	Conductor Anvil	1 Y
3	63454-1104	63454-1104	Insulation Punch	1 Y
4	63445-1576	63445-1576	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 012050)</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	63443-0024	63443-0024	Key	1
11	63443-0090	63443-0090	Wire Stop	1
12	63443-1703	63443-1703	17.30mm Height Spacer	1
13	63443-2217	63443-2217	17.00mm Coarse Spacer	1
14	63443-2308	63443-2308	3.40mm Fine Spacer	1
15	63443-2802	63443-2802	Front Plunger Striker	1
16	63443-2905	63443-2905	Wire Hold Down Plunger	1
17	63443-6111	63443-6111	Rear Cover	1
18	63600-0021	63600-0021	Wire Hold Down Spring	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
<b>Hardware</b>				
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	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

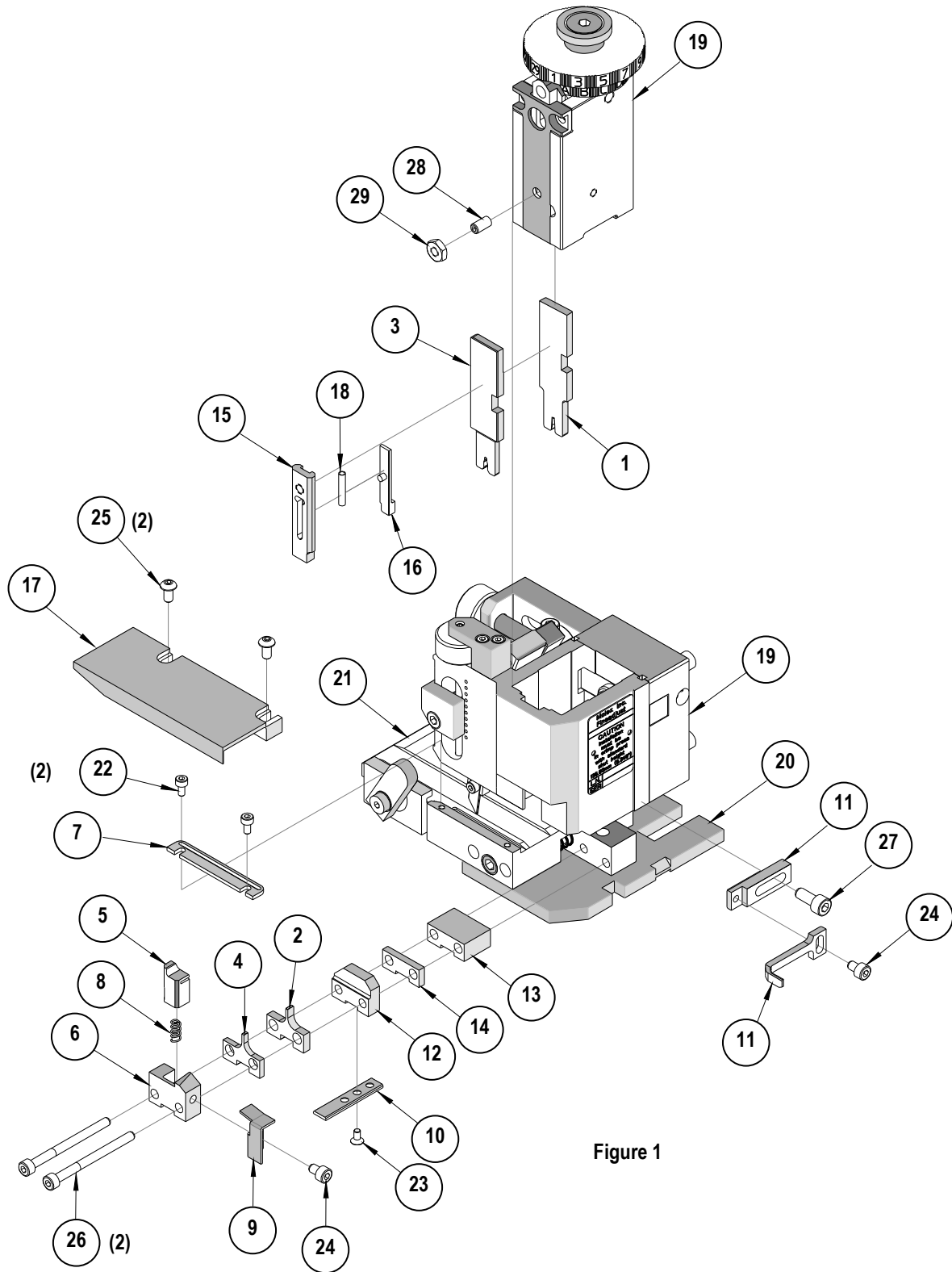


Figure 1

## 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.

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