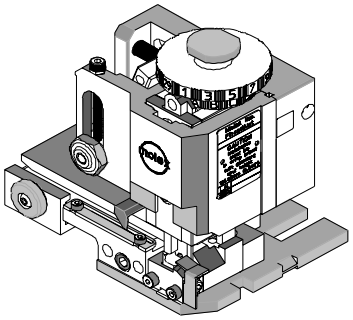
FineAdjust Applicator Specification Sheet Part No. 63867-6000



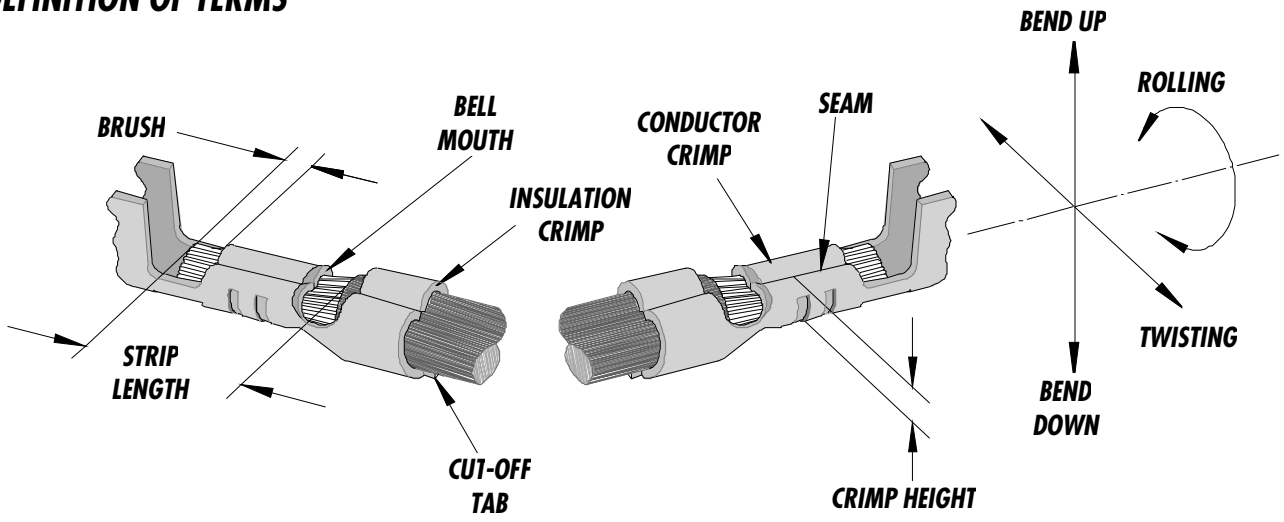
FEATURES

- 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
- Directly adapts to most automatic wire processing machines

SCOPE

Terminal Series No.	Wire Size		Insulation Diameter		Strip Length	
	AWG	mm^2	mm	In.	mm	In.
35452-9802	16-18	1.31-0.82	3.60 Max	.142 Max	4.80-5.20	.189-.205
35453-9802	16-18	1.31-0.82	3.60 Max	.142 Max	4.80-5.20	.189-.205

DEFINITION OF TERMS



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

CRIMP SPECIFICATION

Terminal Series No.	Bell mouth		Cut-off Tab Max.		Conductor Brush	
	mm	In.	mm	In.	mm	In.
35452-9802	0.30-0.60	.012-.024	0.50	.020	0.30-0.80	.012-.032
35453-9802	0.30-0.60	.012-.024	0.50	.020	0.30-0.80	.012-.032

Terminal Series No.	Bend up	Bend down	Twist	Roll	Punch Width (Ref)				Seam
					Conductor		Insulation		
					mm	In	mm	In	
35452-9802	3°	3°	3°	5°	2.70	.106	4.00	.157	Seam shall not be open and no wire allowed out of the crimping area
35453-9802	3°	3°	3°	5°	2.70	.106	4.00	.157	

After crimping, the crimp profiles should measure the following:

Terminal Series No.	Wire Size		Conductor				Insulation				Pull Force Min.	
			Crimp Height		Crimp Width		Crimp Height Max.		Crimp Width			
	AWG	mm^2	mm	In.	mm	In.	mm	In.	mm	In.	N	Lb.
35452-9802	16	1.31	1.60-1.80	.063-.071	2.69-2.91	.106-.115	4.40	.173	4.00	.157	176.4	39.7
35452-9802	18	0.82	1.30-1.50	.051-.059	2.69-2.91	.106-.115	4.40	.173	4.00	.157	122.6	27.6
35453-9802	16	1.31	1.60-1.80	.063-.071	2.69-2.91	.106-.115	4.40	.173	4.00	.157	176.4	39.7
35453-9802	18	0.82	1.30-1.50	.051-.059	2.69-2.91	.106-.115	4.40	.173	4.00	.157	122.6	27.6

✶ ***Tool Qualification Notes:***

1. **This Applicator was qualified to the above specifications with UL1015 wire.**
2. **Pull Force should be measured with no influence from the insulation crimp.**
3. **The above specifications are guidelines to an optimum crimp.**

PARTS LIST

Item	Order No	Engineering No.	Description	Quantity
	63867-6000	63867-6000	FineAdjust Applicator (Fig. 1)	REF
1	63444-2725	63444-2725	Conductor Punch	1 Y
2	63445-2778	63445-2778	Conductor Anvil	1 Y
3	63446-4025	63446-4025	Insulation Punch	1 Y
4	63445-4048	63445-4048	Insulation Anvil	1 Y
5	63443-0035	63443-0035	Cut-Off Plunger Front	1 Y
6	63443-0036	63443-0036	Plunger Retainer Front	1 Y
7	63700-0539	63700-0539	Cut-off Plunger Spring	1
8	63443-3160	63443-3160	Plunger Striker Front	1
9	63443-0021	63443-0021	Lower Tooling Key	1
10	63443-6013	63443-6013	Rear Cover	1
11	11-18-4083	60707-8	Front Cover	1
12	63443-2506	63443-2506	Anvil Mount	1
13	11-18-4080	60707-5	Wire Stop	1
14	63443-0009	63443-0009	Scrap Chute Front	1
15	63801-3100	63801-3100	Wide Track Fine Adjust Frame	1
16	N/A	N/A	M3 by 6Lg. SHCS	2**
17	N/A	N/A	M4 by 6Lg. SHCS	1**
18	N/A	N/A	M4 by 12Lg. BHCS	2**
19	N/A	N/A	M4 by 50Lg. SHCS	2**
20	N/A	N/A	M5 by 12Lg. SHCS	1**
21	N/A	N/A	3MM by 6Lg. Roll Pin	1**
22	N/A	N/A	#10-32 by 1/4"Lg. BHCS	1**
	63867-6070	63867-6070	Tool Kit (All Y Items)	REF

** The following purchased parts are available from an Industrial supply company such as MSC (1-800-645-7270).

Assembly Drawing

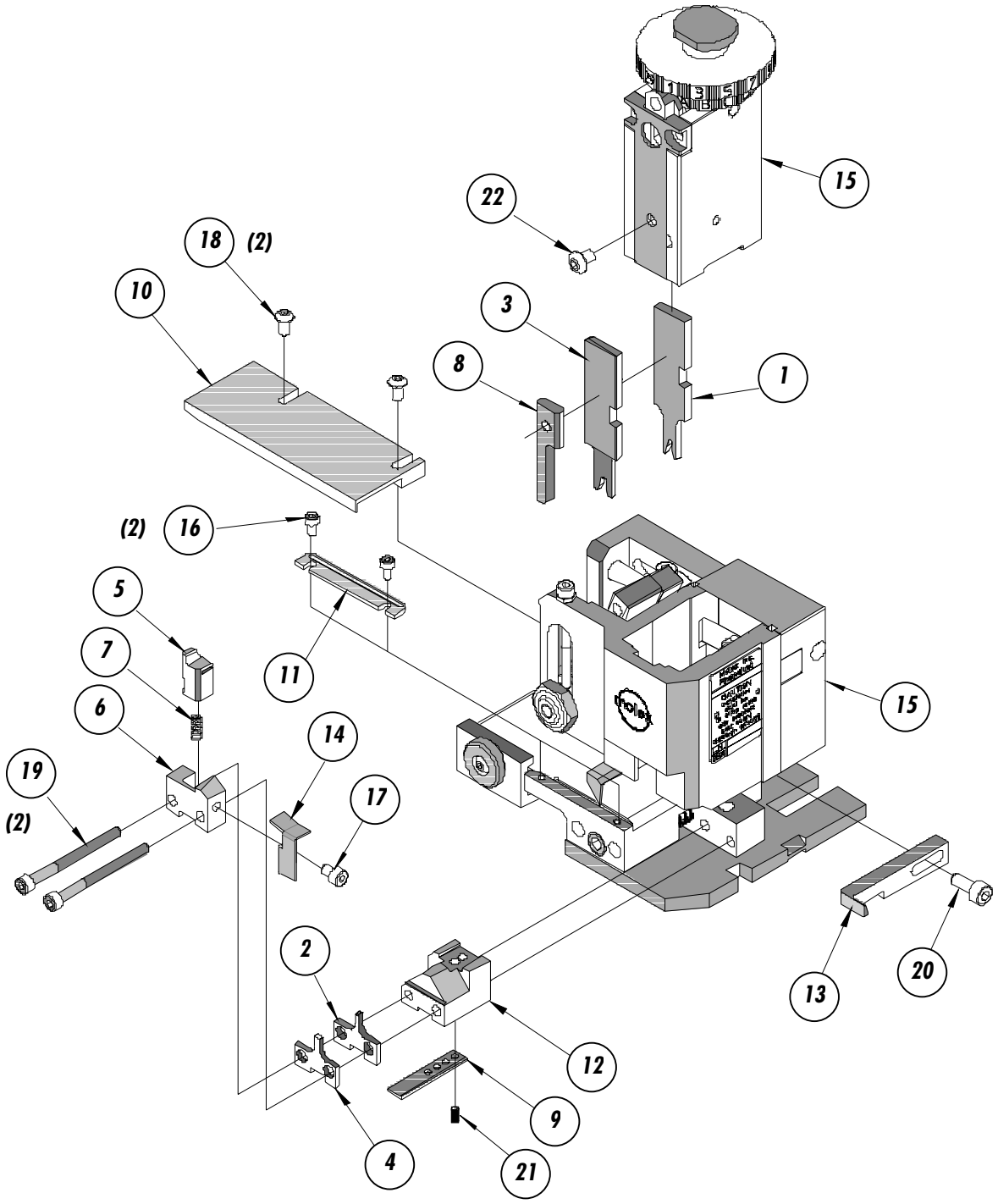


Figure 1

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 135.80 mm (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.

Molex Application Tooling Group
1150 E. Diehl Road
Naperville, IL 60563
Tel: (630) 969-4550
Fax: (630) 505-0049

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