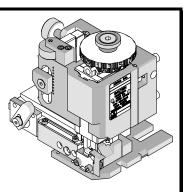
# FineAdjust Applicator Specification Sheet Order No. 63901-1600



# FEATURES

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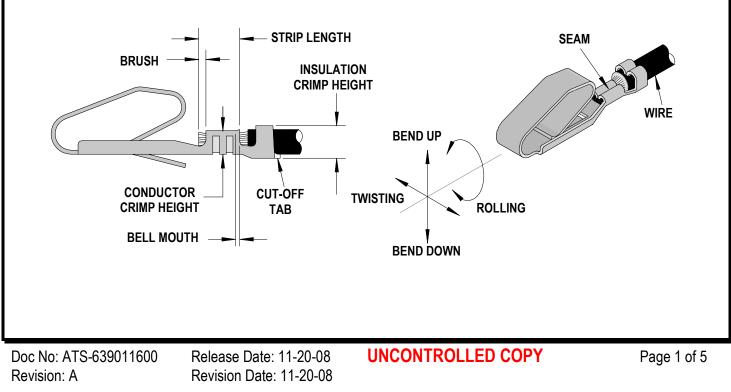
- Directly adapts to most automatic wire processing machines
- Quick punch removal with the push of a button for fast and easy tooling change
- Applicator designed to industry standard mounting and shut height 135.80mm (5.346")
- Quick set-up time; plus the crimp height, track and feed adjustments can 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	Terminal Wi		Sizo		Insulation	Strip Length			
Series No.	Order No.	Wire Size		IPC/WHMA-A620+				Terminal 🔶 🔶	
Series NO.	Order NO.	AWG	mm²	mm	In.	mm	In.	mm	In.
35438	35438-8000	0.50	0.50	1.80-2.80	.071110	1.80-2.80	.071110	3.00-3.60	.118142
33430	33430-0000	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 n	nouth	Cut-off Tal	o Maximum	Conductor Brush	
reminal Series NO.	mm	ln.	mm	In.	mm	ln.
35438	0.30-0.60	.012024	.50	.020	0.30-0.80	.012032

	Bend up Bend down		Twist Roll				lth mm (Ref)		Seam	
Terminal Series No.					Conductor		Insulation		Seam shall not be open	
	Degree	e (Max)	Degree	e (Max)	mm	In	mm	In	and no wire allowed out	
35438	3	3	3	5	1.90	.075	2.80	.110	of the crimping area	

After crimping, the conductor profile should measure the following.

Terminal		Actual mm <sup>2</sup>		Pull Force				
Series No.	Wire Size		Crimp	Height	Crimp Wi	Minimum		
Series NO.			mm	ln.	mm	ln.	Ν	Lb.
35438	0.50	0.50	1.00-1.10	.039043	1.90-2.10	.075083	58.9	13.2
55450	0.85	0.85	1.20-1.30	.047051	1.90-2.10	.075083	98.1	22.1

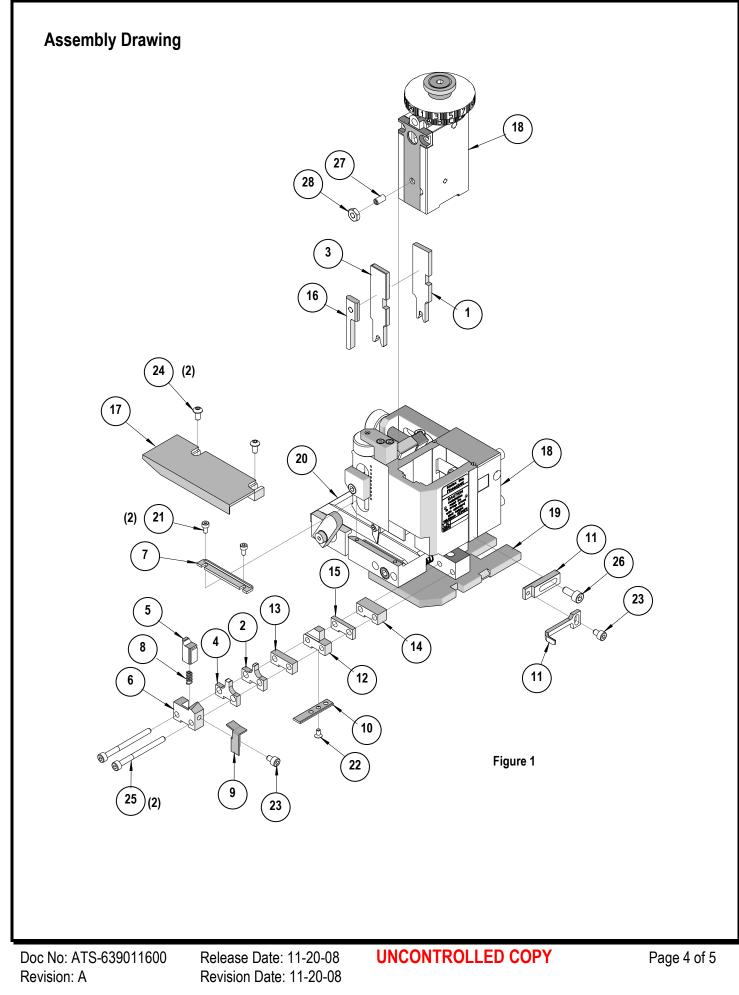
Terminel			Insulation					
Terminal Series No.	Wire Size	Actual mm <sup>2</sup>	Crimp He	ight (Ref.)	Crimp Width (Ref.)			
Series No.			mm	In.	mm	ln.		
35438	0.50	0.50	2.55	.100	2.70-2.90	.106114		
33430	0.85	0.85	2.60	.104	2.70-2.90	.106114		

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 63901-1600										
Item	Order No	Engineering No.	Description	Quantity						
	Perishable Tooling									
	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						
		Other Compo	onents(REF 011650)							
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						
			Frame							
18	63800-4901	63800-4901	Тор	1						
19	63801-3281	63801-3281	Base	1						
20	63801-4650	63801-4650	Track	1						
		Н	ardware							
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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