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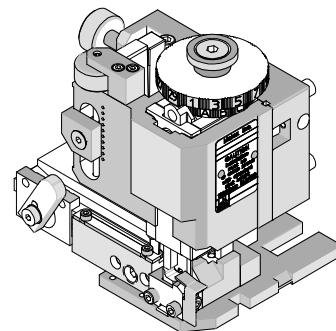
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# FineAdjust Applicator Specification Sheet Order No. 63901-1400



## 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

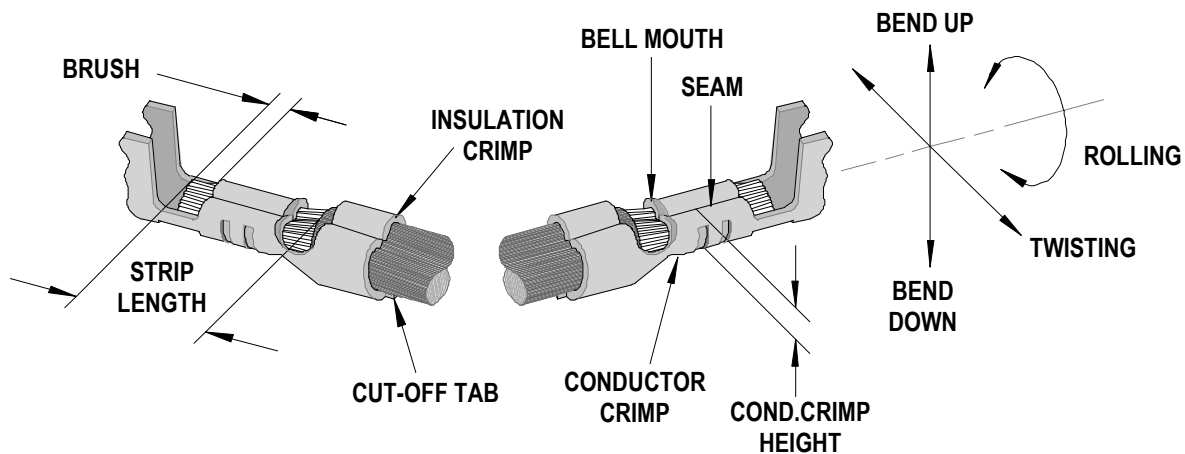
## SCOPE

Products: 1.75mm (.069") Pitch Wire-to-Board Crimp Terminal, 24-28 AWG (0.08 and 0.20mm<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.
502057	502057-1000	24-26	0.22-.0.12	1.00-1.27	.039-.050	0.85-1.27	.033-.050	1.50-1.80	.059-.071
		---	0.20	1.00-1.27	.039-.050	0.85-1.27	.033-.050		
		28	0.079	1.00-1.27	.039-.050	0.85-1.27	.033-.050		
		---	0.08	1.00-1.27	.039-.050	0.85-1.27	.033-.050		

♦ To achieve optimum IPC-A620 Class 2 insulation crimps, use this insulation OD range.  
♦♦ Overall insulation OD specification for terminal.

## 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.
502057	0.10-.035	.004-.014	0.10	.004	0.10-0.50	.004-.020

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
	Degree		Degree		Conductor		Insulation		
					mm	In	mm	In	
502057	3	2	3	5	1.00	.039	1.20	.047	

After crimping, the conductor profile should measure the following.

Terminal Series No.	Wire Size		Conductor Crimp Height		Insulation Crimp Height		Pull Force Minimum	
	AWG	mm <sup>2</sup>	mm	In.	mm	In.	N	Lb.
502057	24	0.22	0.60-0.65	.024-.026	1.55	.061	29.4	6.6
	---	0.02	0.60-0.65	.024-.026	1.60	.063	29.4	6.6
	26	0.12	0.59-0.64	.023-.025	1.50	.059	19.6	4.4
	28	0.079	0.56-0.61	.022-.024	1.40	.055	9.8	2.2
	---	0.08	0.56-0.61	.022-.024	1.40	.055	9.8	2.2

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 63901-1400</b>				
<b>Item</b>	<b>Order No</b>	<b>Engineering No.</b>	<b>Description</b>	<b>Quantity</b>
<b>Perishable Tooling</b>				
	63901-1470	63901-1470	Tool Kit (All "Y" Items)	REF
1	63444-1007	63444-1007	Conductor Punch	1 Y
2	63445-1012	63445-1012	Conductor Anvil	1 Y
3	63446-1217	63446-1217	Insulation Punch	1 Y
4	63445-1235	63445-1235	Insulation Anvil	1 Y
5	63443-0002	63443-0002	Cut-Off Plunger	1 Y
6	63443-0012	63443-0012	Front Plunger Retainer	1 Y
<b>Other Components (REF 011450)</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	63443-1714	63443-1714	18.40mm Height Spacer	1
13	63443-2217	63443-2217	17.00mm Coarse Spacer	1
14	63443-2306	63443-2306	3.30mm Fine Spacer	1
15	63443-2801	63443-2801	Front Plunger Striker	1
16	63443-2906	63443-2906	Wire Hold Down Plunger	1
17	63443-6110	63443-6110	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 Long 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

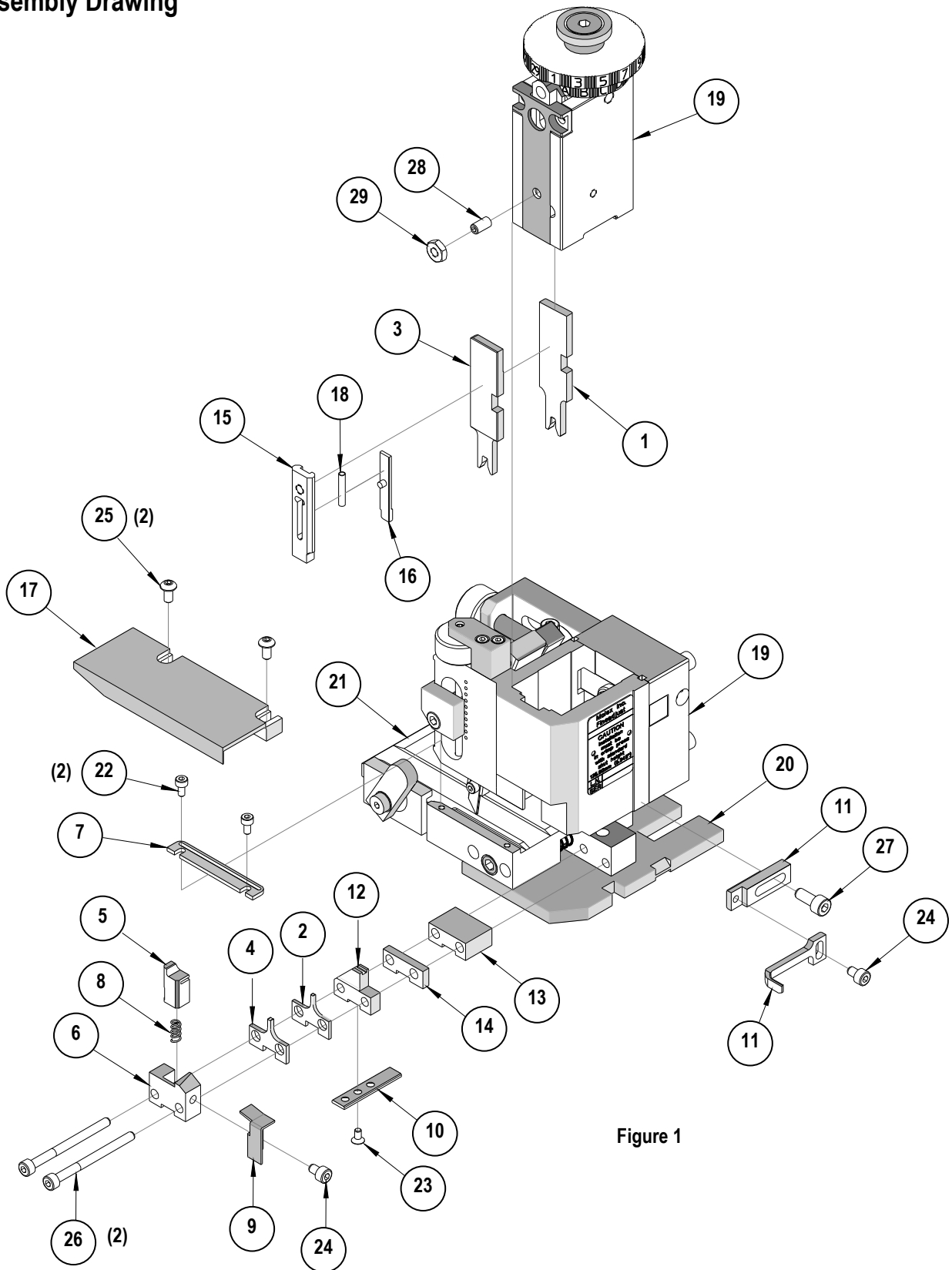


Figure 1

## 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 135.8 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.

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