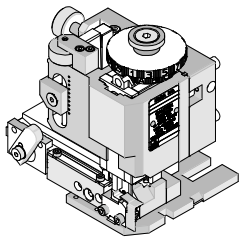
FineAdjust Applicator

molex

Application Tooling Specification Sheet



Order No. 63900-2700

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

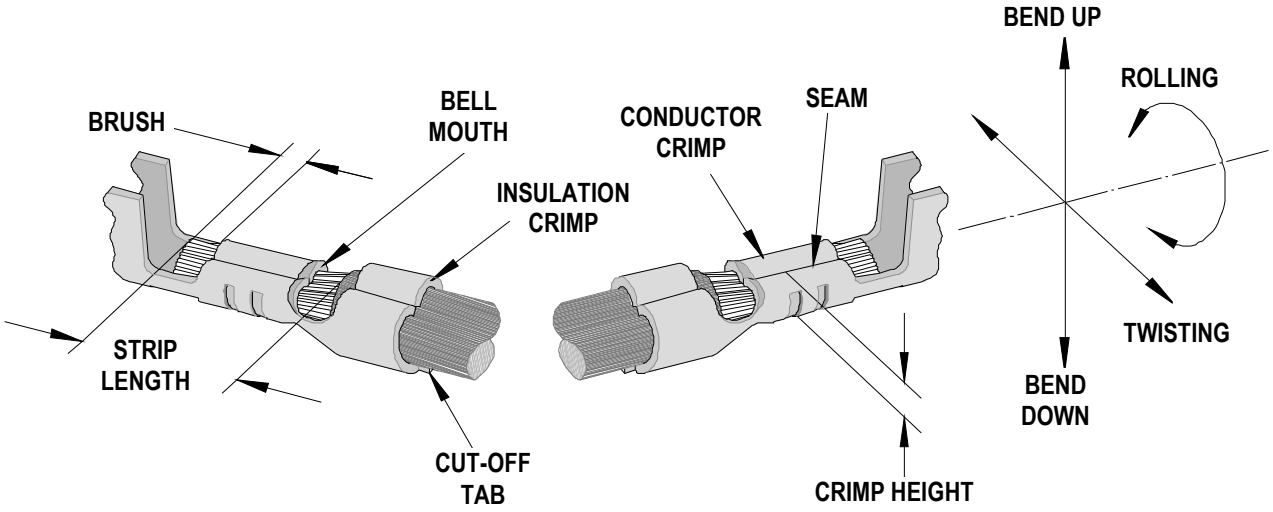
SCOPE

Products: Mini-Fit Jr. ™, and Mini-Fit Plus™ Crimp Terminal 22-28 AWG.

Terminal Series No.	Terminal Order No.			Wire Size		Insulation Diameter				Strip Length	
						IPC/WHMA-A620(1)		Terminal(2)			
				AWG	mm²	mm	In.	mm	In.	mm	In.
5556	39-00-0046	39-00-0139	39-00-0196	22-28	0.35-0.08	1.30-1.50	.051-.059	0.90-1.80	.035-.071	2.80-3.30	.110-.130
	39-00-0065	39-00-0155	39-00-0202								
	39-00-0085	39-00-0165	39-00-0209								
	39-00-0091	39-00-0171	39-00-0215								
	39-00-0110	39-00-0177	39-00-0231								
	39-00-0116	39-00-0183	39-00-0434								
5558	39-00-0048	39-00-0128	40-01-0854	22-28	0.35-0.08	1.30-1.50	.051-.059	0.90-1.80	.035-.071	2.80-3.30	.110-.130
	39-00-0067	39-00-0145	98-00-0175								
	39-00-0087	39-00-0221									
	39-00-0097	39-00-0432									
44485	44485-2211	44485-2311	44485-2411	22-28	0.35-0.08	1.30-1.50	.051-.059	0.90-1.80	.035-.071	2.80-3.30	.110-.130
45750	45750-2211			22-24	0.35-0.20	1.30-1.50	.051-.059	1.80 Max.	.071 Max.	2.80-3.30	.110-.130
46018	46018-2541			22-24	0.35-0.20	1.30-1.50	.051-.059	1.80 Max.	.071 Max.	2.80-3.30	.110-.130
46083	46083-2111	46083-2211		22-24	0.35-0.20	1.30-1.50	.051-.059	1.80 Max.	.071 Max.	2.80-3.30	.110-.130
	46083-2121	46083-2221									
46134	46134-2111	46134-2211		22-24	0.35-0.20	1.30-1.50	.051-.059	1.80 Max.	.071 Max.	2.80-3.30	.110-.130
	46134-2121	46134-2221									

(1)To achieve optimum IPC-A620 insulation crimps, use this insulation OD range.
(2)Overall insulation OD specification for terminal.
Applicator 63902-0200 should be used for insulation OD 1.10-1.30mm.
Applicator 63902-3800 should be used for insulation OD 0.95-1.08mm.

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.
5556	0.20-0.50	.008-.020	0.30	.012	0.00-1.00	.000-.039
5558	0.20-0.50	.008-.020	0.30	.012	0.00-1.00	.000-.039
44485	0.20-0.50	.008-.020	0.30	.012	0.00-1.00	.000-.039
45750	0.20-0.50	.008-.020	0.30	.012	0.00-1.00	.000-.039
46018	0.20-0.50	.008-.020	0.30	.012	0.00-1.00	.000-.039
46083	0.20-0.50	.008-.020	0.30	.012	0.00-1.00	.000-.039
46134	0.20-0.50	.008-.020	0.30	.012	0.00-1.00	.000-.039

Terminal Series No.	Bend up	Bend down	Twist	Roll	Punch Width (Ref)				Seam
					Conductor		Insulation		
	Degree		Degree		mm	In.	mm	In.	
5556	5	2	5	17	1.40	.055	1.80	.071	Seam shall not be open And no wire allowed out of the crimping area
5558	5	2	5	17	1.40	.055	1.80	.071	
44485	5	2	5	17	1.40	.055	1.80	.071	
45750	5	2	5	17	1.40	.055	1.80	.071	
46018	5	2	5	17	1.40	.055	1.80	.071	
46083	5	2	5	17	1.40	.055	1.80	.071	
46134	5	2	5	17	1.40	.055	1.80	.071	

After crimping, the crimp profiles should measure the following:

Terminal Series No.	Wire Size		Conductor				Pull Force Minimum	
			Crimp Height		Crimp Width (Ref)			
	AWG	mm^2	mm	In.	mm	In.	N	Lb.
5556	22	0.35	0.76-0.83	.030-.033			39.1	8.80
	24	0.20	0.70-0.77	.028-.030			29.3	6.60
	26	0.12	0.66-0.72	.026-.028			19.6	4.40
	28	0.08	0.63-0.69	.025-.027			9.8	2.20
5558	22	0.35	0.76-0.83	.030-.033			39.1	8.80
	24	0.20	0.70-0.77	.028-.030			29.3	6.60
	26	0.12	0.66-0.72	.026-.028			19.6	4.40
	28	0.08	0.63-0.69	.025-.027			9.8	2.20
44485	22	0.35	0.76-0.83	.030-.033			39.1	8.80
	24	0.20	0.70-0.77	.028-.030			29.3	6.60
	26	0.12	0.66-0.72	.026-.028			19.6	4.40
	28	0.08	0.63-0.69	.025-.027			9.8	2.20
45750	22	0.35	0.76-0.83	.030-.033			39.1	8.80
	24	0.20	0.70-0.77	.028-.030			29.3	6.60
46018	22	0.35	0.76-0.83	.030-.033			39.1	8.80
	24	0.20	0.70-0.77	.028-.030			29.3	6.60
46083	22	0.35	0.76-0.83	.030-.033			39.1	8.80
	24	0.20	0.70-0.77	.028-.030			29.3	6.60
46134	22	0.35	0.76-0.83	.030-.033			39.1	8.80
	24	0.20	0.70-0.77	.028-.030			29.3	6.60

✳ 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.

PARTS LIST

FineAdjust Applicator 63900-2700				
Item	**Order No**	**Engineering No.**	**Description**	**Quantity**
Perishable Tooling				
	63900-2770	63900-2770	Tool Kit (All "Y" Items)	REF
1	63444-1421	63444-1421	Conductor Punch	1 Y
2	63445-1441	63445-1441	Conductor Anvil	1 Y
3	63446-1816	63446-1816	Insulation Punch	1 Y
4	63445-1819	63445-1819	Insulation Anvil	1 Y
5	63443-0002	63443-0002	Cut-Off Plunger	1 Y
6	63443-0012	63443-0012	Front Plunger Retainer	1 Y
Other Components				
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	63443-1717	63443-1717	Height Spacer1 (8.70mm)	1
13	63443-2216	63443-2216	Coarse Spacer (16.00mm)	1
14	63443-2302	63443-2302	Fine Spacer (3.10mm)	1
15	63443-2802	63443-2802	Front Plunger Striker	1
16	63443-2908	63443-2908	Wire Hold Down Plunger	1
17	63443-6111	63443-6111	Rear Cover	1
18	63600-0021	63600-0021	Compression Spring	1
Frame				
19	63800-4901	63800-4901	Top	1
20	63801-3281	63801-3281	Base	1
21	63801-4650	63801-4650	Track	1
Hardware				
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

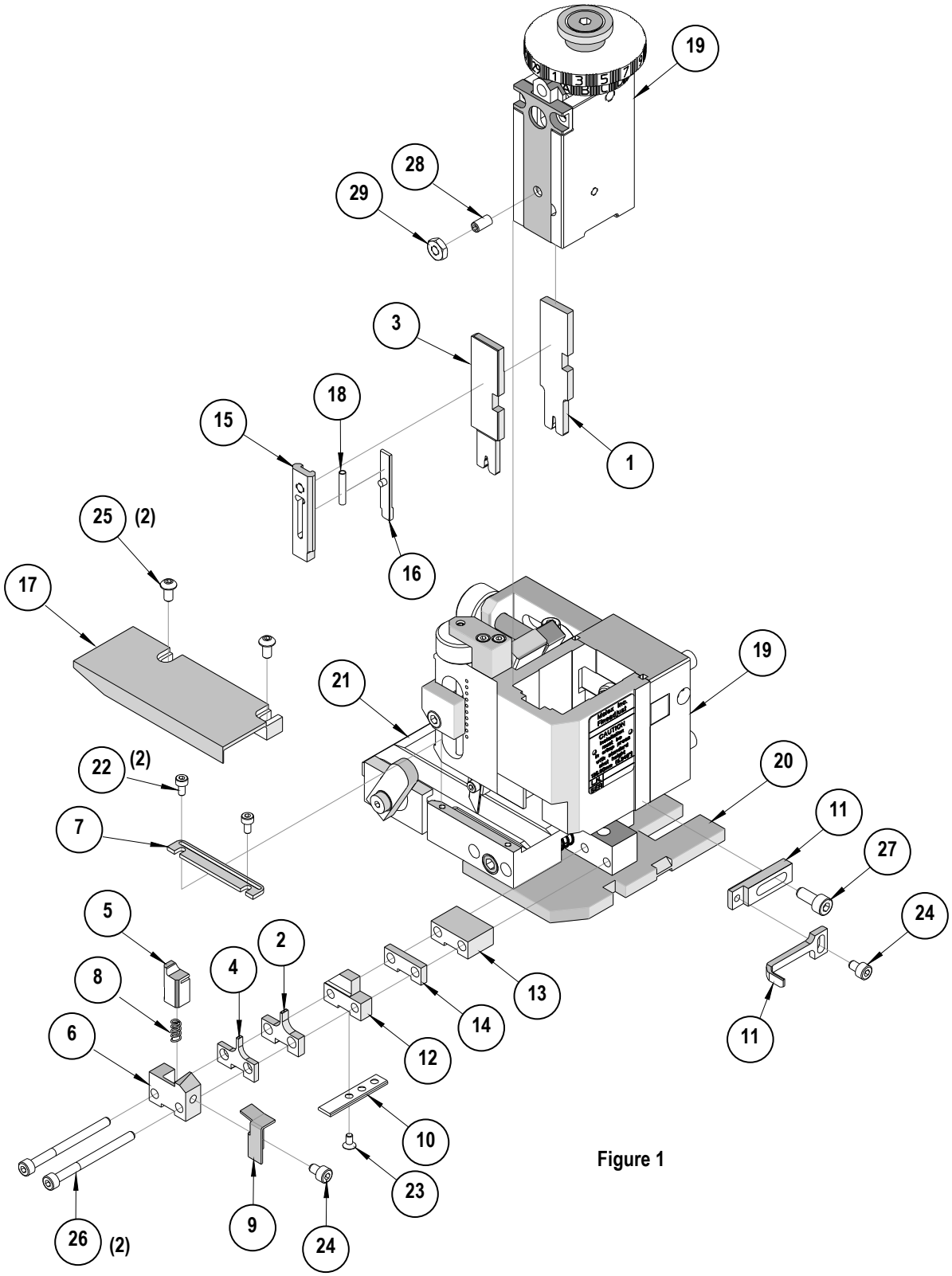


Figure 1

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 135.80 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.

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