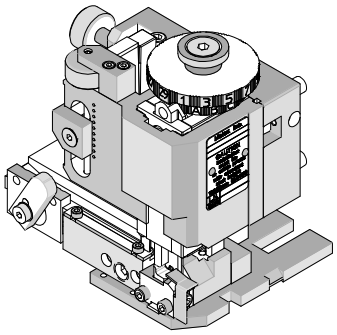
FineAdjust Applicator
Applicator Tooling Specification Sheet
Order No. 63901-3900



FEATURES

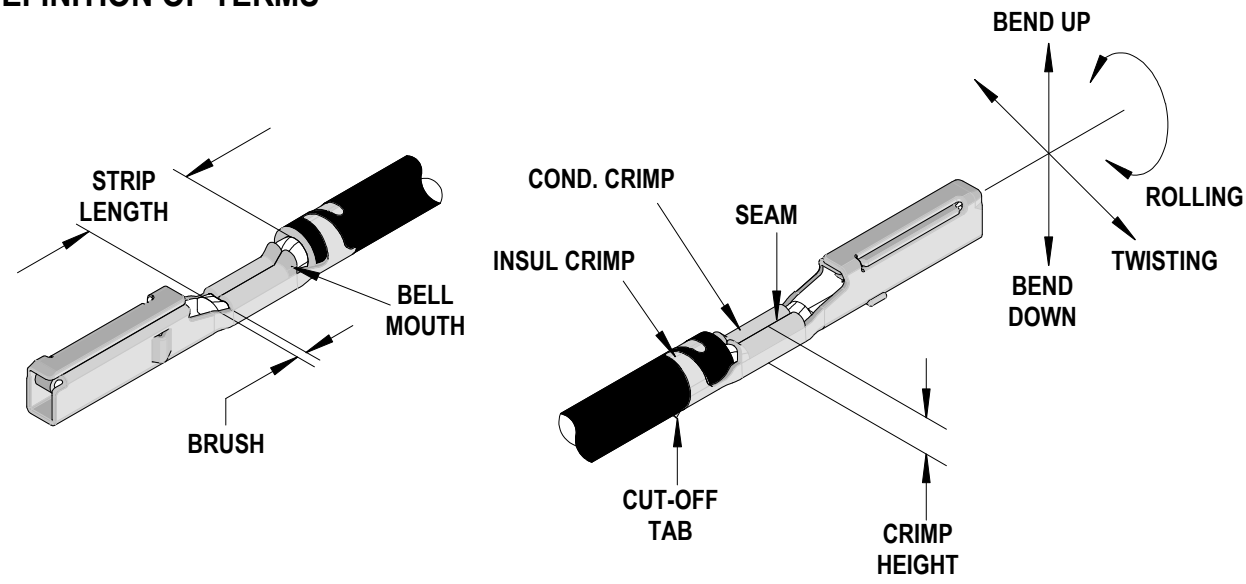
- Quick punch removal with the push of a button for fast and easy tooling change
- Applicator designed to industry standard mounting and shut height 135.80mm (5.346")
- Quick set-up time; plus the crimp height, track and feed adjustments can be set without removing the applicator from the press
- Fine 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: NSCC 1.5 Receptacle Terminals: 0.50-1.00mm² metric.

Terminal Series No.	Terminal Order No.	Wire Size & Type		✖Insulation Diameter		Strip Length	
		Type	mm²	mm	In.	mm	In.
98897	98897-1119	ID	0.50	1.35-1.50	.053-.059	4.30-4.70	.169-.185
		IR	0.60	1.75-1.90	.069-.075	4.30-4.70	.169-.185
		ID	0.75	1.60-1.80	.063-.071	4.30-4.70	.169-.185
		IR	1.00	1.85-2.00	.073-.079	4.30-4.70	.169-.185
✖Insulation crimp to meet IPC/WHMA-A-620 Class 2 compliance.							

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.
98897	0.40-0.80	.016-.032	0.20	.008	0.20-1.00	.008-.039

Terminal Series No.	Bend up	Bend down	Twist	Roll	Punch Width (Ref)				Seam
					Conductor		Insulation		
	Degree		Degree		mm	In	mm	In	
98897	2	2	2	6	2.10	.083	2.50	.098	Seam shall not be open and no wire allowed out of the crimping area

After crimping, the crimp profiles should measure the following:

Terminal Series No.	Wire Size and Type		Conductor				Insulation				Pull Force Minimum	
			Crimp Height		Crimp Width		Crimp Height		Crimp Width			
	Type	mm^2	mm	In.	mm	In.	mm	In.	mm	In.	N	Lb.
98897	ID	0.50	1.02-1.12	.040-.044	2.00-2.20	.079-.087	2.05-2.25	.081-.089	2.40-2.60	.094-.102	70.0	15.7
	IR	0.60	1.04-1.14	.041-.045	2.00-2.20	.079-.087	2.10-2.30	.083-.091	2.40-2.60	.094-.102	80.0	18.0
	ID	0.75	1.05-1.15	.041-.045	2.00-2.20	.079-.087	2.15-2.35	.085-.093	2.40-2.60	.094-.102	90.0	20.2
	IR	1.00	1.13-1.23	.044-.048	2.00-2.20	.079-.087	2.30-2.50	.091-.098	2.40-2.60	.094-.102	115.0	25.9

- 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 63901-3900				
Item	**Order No**	**Engineering No.**	**Description**	**Quantity**
Perishable Tooling				
	63901-3970	63901-3970	Tool Kit (All "Y" Items)	REF
1	63457-0051	63457-0051	Conductor Punch	1 Y
2	63455-0068	63455-0068	Conductor Anvil	1 Y
3	63454-0084	63454-0084	Insulation Punch	1 Y
4	63456-0062	63456-0062	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	11-17-0022	1739-21	Hold Down Spring	1
8	11-18-4083	60707-8	Feed Guide	1
9	11-24-1067	4996-4	Cut-off Plunger Spring	1
10	63443-0009	63443-0009	Scrap Chute	1
11	63443-0024	63443-0024	Key	1
12	63443-0090	63443-0090	Wire Stop	1
13	63443-0093	63443-0093	Shank	1
14	63443-1716	63443-1716	18.60mm Height Spacer	1
15	63443-2202	63443-2202	2.00mm Coarse Spacer	1
16	63443-2212	63443-2212	12.00mm Coarse Spacer	1
17	63443-2313	63443-2313	3.65mm Fine Spacer	1
18	63443-2804	63443-2804	Front Plunger Striker	1
19	63443-2911	63443-2911	Wire Hold-Down Plunger	1
20	63443-6121	63443-6121	Rear Cover	1
21	63600-1057	63600-1057	Striker Plunger Spring	1
22	63443-7107	63443-7107	Terminal Hold Down	1
Frame				
23	63800-4901	63800-4901	Top	1
24	63801-3281	63801-3281	Base	1
25	63801-4650	63801-4650	Track	1
Hardware				
26	N/A	N/A	M3 by 6 Long SHCS	2**
27	N/A	N/A	M3 by 6 Long FHCS	1**
28	N/A	N/A	M3 by 8 Long SHCS	1**
29	N/A	N/A	M4 by 6 Long SHCS	2**
30	N/A	N/A	M4 by 12 Long BHCS	2**
31	N/A	N/A	M4 by 50 Long SHCS	2**
32	N/A	N/A	M5 by 12 Long SHCS	1**
33	N/A	N/A	#10-32 by 3/8"Long Flat Point SSS	1**
34	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

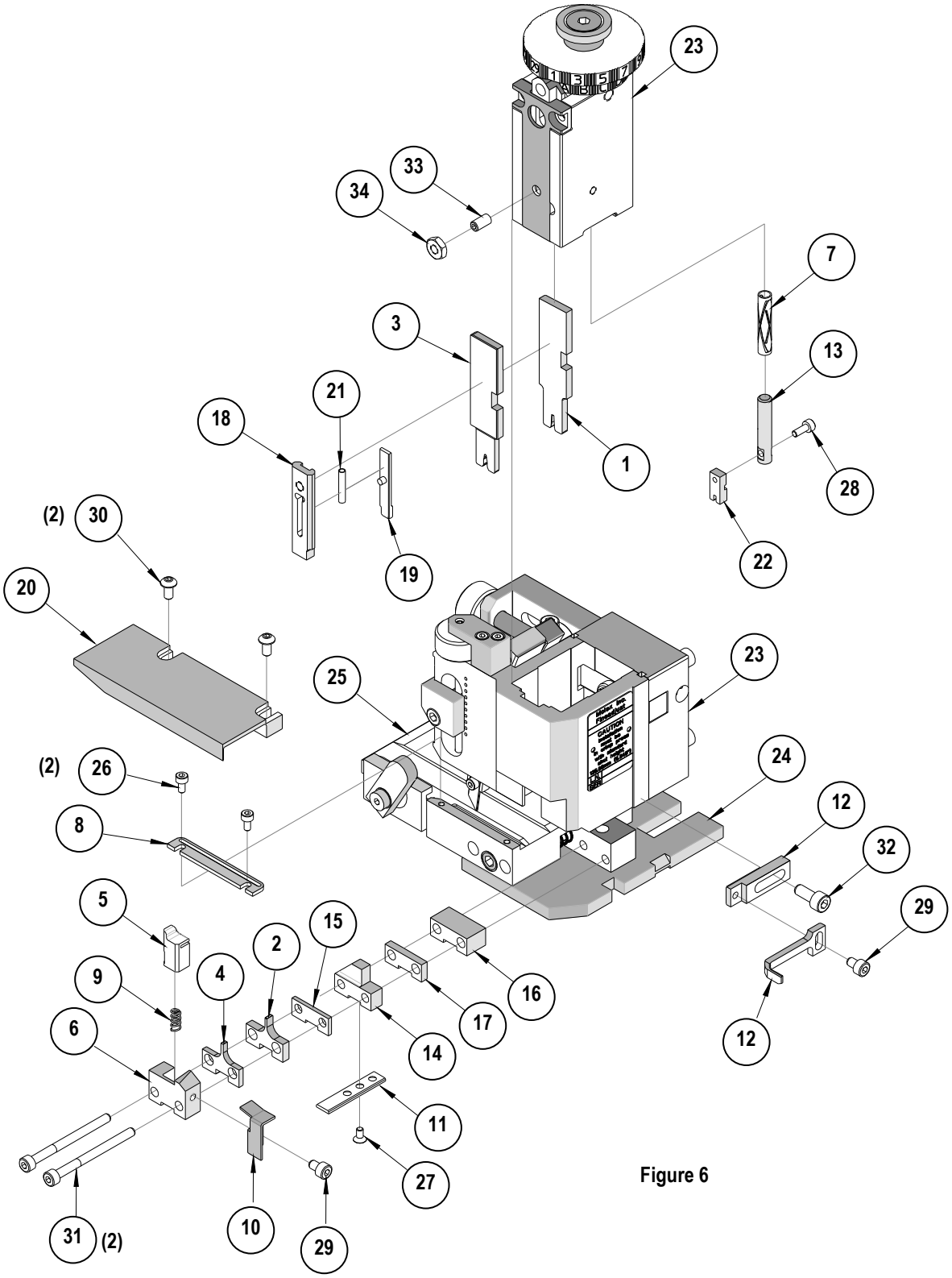


Figure 6

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.

Americas Headquarters
Lisle, Illinois 60532 U.S.A.
1-800-78MOLEX
amerinfo@molex.com

Far East North Headquarters
Yamato, Kanagawa, Japan
81-462-65-2324
feninfo@molex.com

Far East South Headquarters
Jurong, Singapore
65-6-268-6868
fesinfo@molex.com

European Headquarters
Munich, Germany
49-89-413092-0
eurinfo@molex.com

Corporate Headquarters
2222 Wellington Ct.
Lisle, IL 60532 U.S.A.
630-969-4550
Fax: 630-969-1352

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