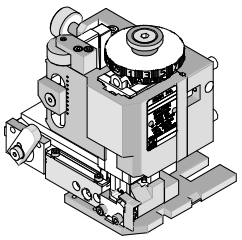
FineAdjust Applicator

molex

Application Tooling Specification Sheet



Order No. 63902-3400

FEATURES

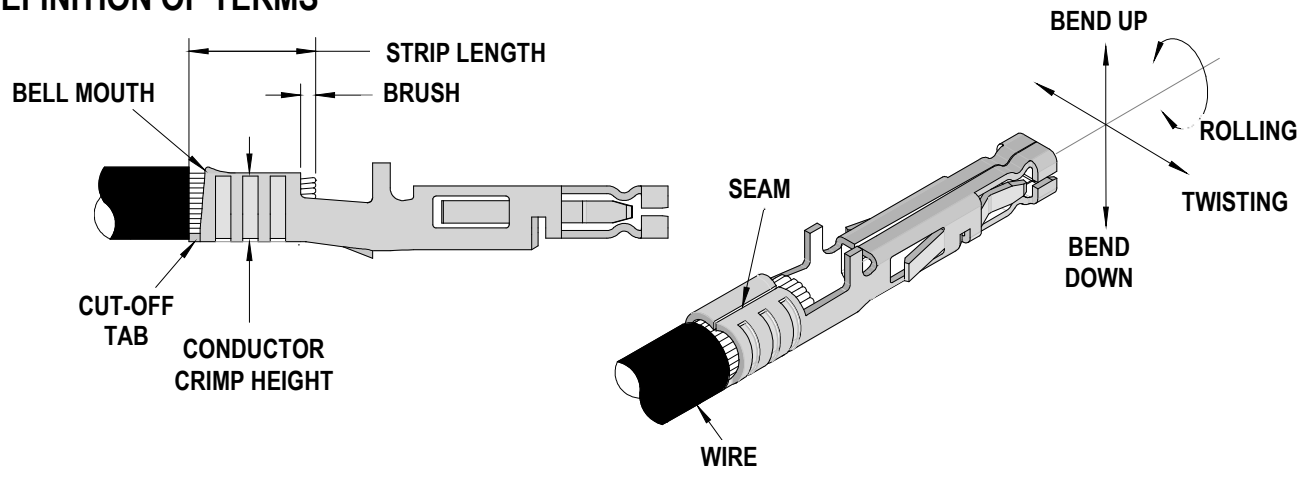
- Directly adapts to most automatic wire processing machines
- Quick punch removal with the push of a button for fast and easy tooling change
- Applicator designed to industry-standard mounting and shut height 135.80mm (5.346")
- Quick setup time; plus, the crimp height, track and feed adjustments can 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: Mega-Fit Female Terminals, 2.50mm², 4.00mm², 12 AWG.

Terminal Series No.	Terminal Order No.	Wire Size		Insulation Diameter Maximum (1)		Strip Length	
		AWG	mm²	mm	In.	mm	In.
76823	76823-0322	-	2.50	4.10	.161	5.50-6.00	0.22-0.24
		12	-				
		-	4.00				
172063	172063-0312 172063-1312	-	2.50	4.10	.161	5.50-6.00	0.22-0.24
		12	-				
		-	4.00				
(1) Overall insulation OD specification for terminal.							

DEFINITION OF TERMS



CRIMP SPECIFICATION

Terminal Series No.	Bell Mouth		Cut-Off Tab Maximum		Conductor Brush	
	mm	In.	mm	In.	mm	In.
76823	0.20-1.00	.008-.039	0.60	.024	0.10-0.76	.004-.030
172063	0.20-1.00	.008-.039	0.60	.024	0.10-0.76	.004-.030

Terminal Series No.	Bend Up	Bend Down	Twist	Roll	Punch Width (Ref) Conductor		Seam
	Degree (Max)		Degree (Max)		mm	In.	
76823	3	3	4	8	3.20	.126	Seam shall not be open and no wire allowed out of the crimping area
172063	3	3	4	8	3.20	.126	

After crimping, the conductor profile should measure the following:

Terminal Series No.	Wire Size	mm^2	Conductor Crimp				Pull Force Minimum	
			Crimp Height		Crimp Width (Ref.)			
			mm	In.	mm	In.	N	Lb.
76823	-	2.50	1.80-1.90	.071-.075	3.25	.128	220.0	49.46
	12	-	1.90-2.00	.075-.079	3.25	.128	220.0	49.46
	-	4.00	2.05-2.15	.081-.085	3.25	.128	220.0	49.46
172063	-	2.50	1.80-1.90	.071-.075	3.25	.128	220.0	49.46
	12	-	1.90-2.00	.075-.079	3.25	.128	220.0	49.46
	-	4.00	2.05-2.15	.081-.085	3.25	.128	220.0	49.46

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 63902-3400				
Item	**Order No.**	**Engineering No.**	**Description**	**Quantity**
Perishable Tooling				
	63902-3470	63902-3470	Tool Kit (All "Y" Items)	REF
1	63457-0097	63457-0097	Conductor Punch	1 Y
2	63455-0124	63455-0124	Conductor Anvil	1 Y
3	63443-0002	63443-0002	Cut-Off Plunger	1 Y
4	63443-0012	63443-0012	Front Plunger Retainer	1 Y
Other Components				
5	11-17-0022	1739-21	Nose Hold Down Spring	1
6	11-18-4083	60707-8	Feed Guide	1
7	11-24-1067	4996-4	Cut-off Plunger Spring	1
8	63443-0009	63443-0009	Scrap Chute	1
9	63443-0024	63443-0024	Key	1
10	63443-0090	63443-0090	Wire Stop	1
11	63443-0093	63443-0093	Shank	1
12	63443-1718	63443-1718	18.80mm (Height Spacer)	1
13	63443-2205	63443-2205	5.00mm (Coarse Spacer)	1
14	63443-2208	63443-2208	8.00mm (Coarse Spacer)	1
15	63443-2314	63443-2314	3.70mm (Fine Spacer)	1
16	63443-2802	63443-2802	Front Plunger Striker	1
17	63443-2903	63443-2903	Wire Hold Down Plunger	1
18	63443-6123	63443-6123	Rear Cover	1
19	63443-7119	63443-7119	Terminal Hold Down	1
20	63454-0101	63454-0101	Punch Spacer	1
21	63600-0021	63600-0021	Compression Spring	1
Frame				
22	63800-4901	63800-4901	Top	1
23	63801-3281	63801-3281	Base	1
24	63801-4650	63801-4650	Track	1
Hardware				
25	N/A	N/A	M3 by 6 Long SHCS	2**
26	N/A	N/A	M3 by 6 Long FHCS	1**
27	N/A	N/A	M3 by 8 Long SHCS	1**
28	N/A	N/A	M4 by 6 Long SHCS	2**
29	N/A	N/A	M4 by 12 Long BHCS	2**
30	N/A	N/A	M4 by 45 Long SHCS	2**
31	N/A	N/A	M5 by 12 Long SHCS	1**
32	N/A	N/A	#10-32 by 3/8"Long Flat Point SSS	1**
33	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

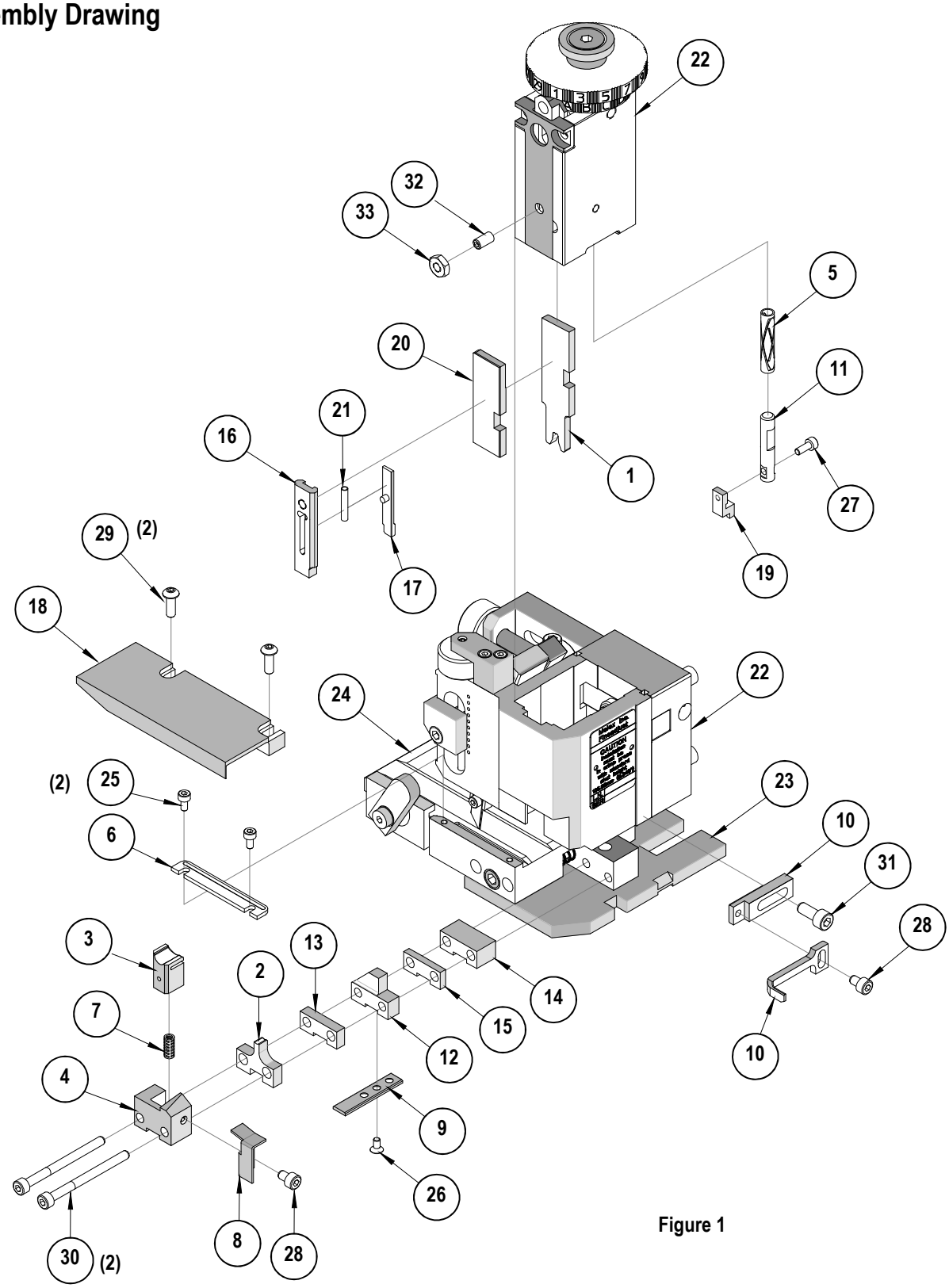


Figure 1

NOTES

1. Molex recommends that 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 the 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.

Application Tooling Support

Phone: (402) 458-TOOL (8665)
E-Mail: applicationtooling@molex.com
Website: www.molex.com/applicationtooling

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