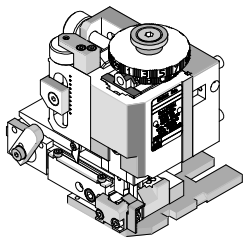
FineAdjust Applicator

Application Tooling Specification Sheet



Order No. 63902-6700

FEATURES

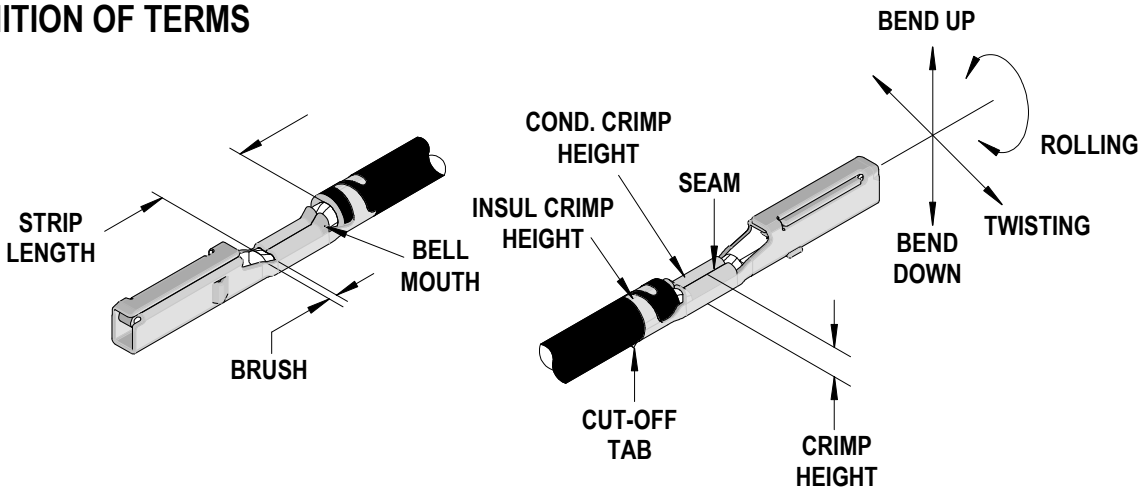
- Quick punch removal with the push of a button for fast and easy tooling change
- Applicator designed to industry standard mounting and shut height 135.80mm (5.346")
- Quick set-up time; plus the crimp height, track and feed adjustments can be set without removing the applicator from the press
- Fine 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: MX120G Mat Seal Receptacle Terminals, 0.75mm² wires.

Terminal Series No.	Terminal Order No.	Wire Size		Insulation Diameter		Strip Length (Ref.)	
		Wire Type	mm²	mm	In.	mm	In.
36799	36799-0001	FLRY-B	0.75 mm2	1.60-1.90	.063-.075	4.50-5.50	.177-.217

DEFINITION OF TERMS



CRIMP SPECIFICATION

Terminal Series No.	Bell mouth		Cut-off Tab Maximum		✷Conductor Brush	
	mm	In.	mm	In.	mm	In.
36799	0.25-0.50	.010-.020	0.30	.012	0.20-1.20	.008-.047
✷ Wire brush must be flush or below top of Conductor Crimp.						

Terminal Series No.	Bend up	Bend down	Twist	Roll	Punch Width (Ref)				Seam
					Conductor		Insulation		
	Degree Max.		Degree Max.		mm	In	mm	In	
36799	1.5	1.5	4	6	1.60	.063	2.30	.091	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		Conductor				Insulation				Pull Force Minimum	
			Crimp Height		Crimp Width (Ref)		Crimp Height Max.		Crimp Width (Ref)			
	Wire Type	mm²	mm	In.	mm	In.	mm	In.	mm	In.	N	Lb.
36799	FLRY-B	0.75 mm2	1.10-1.20	.043-.047	1.60	.063	2.35	.093	2.30	.091	115	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 63902-6700				
Item	**Order No**	**Engineering No.**	**Description**	**Quantity**
Perishable Tooling				
	63902-6770	63902-6770	Tool Kit (All "Y" Items)	REF
1	63457-0094	63457-0094	Conductor Punch	1 Y
2	63455-0057	63455-0057	Conductor Anvil	1 Y
3	63454-0078	63454-0078	Insulation Punch	1 Y
4	63456-0052	63456-0052	Insulation Anvil	1 Y
5	63443-0003	63443-0003	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	Scrap Chute	1
10	63443-0024	63443-0024	Key	1
11	63443-0090	63443-0090	Wire Stop	1
12	63443-1709	63443-1709	Height Spacer	1
13	63443-2214	63443-2214	Coarse Spacer (14.00mm)	1
14	63443-2302	63443-2302	Fine Spacer (3.10mm)	1
15	63443-2804	63443-2804	Front Plunger Striker	1
16	63443-2915	63443-2915	Striker Plunger	1
17	63443-6119	63443-6119	Rear Cover	1
18	63600-0021	63600-0021	Striker Plunger Spring	1
19	63867-3007	63867-3007	Bottom Cap	1
Frame				
20	63800-4901	63800-4901	Top	1
21	63801-3281	63801-3281	Base	1
22	63801-4650	63801-4650	Track	1
Hardware				
23	N/A	N/A	M3 by 6 Long SHCS	2**
24	N/A	N/A	M3 by 6 Long FHCS	1**
25	N/A	N/A	M4 by 6 Long SHCS	2**
26	N/A	N/A	M4 by 8 Long Brass Tip SSS	1**
27	N/A	N/A	M4 by 12 Long SHCS	2**
28	N/A	N/A	M4 by 12 Long BHCS	2**
29	N/A	N/A	M4 by 16 Long SHCS	1**
30	N/A	N/A	M4 by 50 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

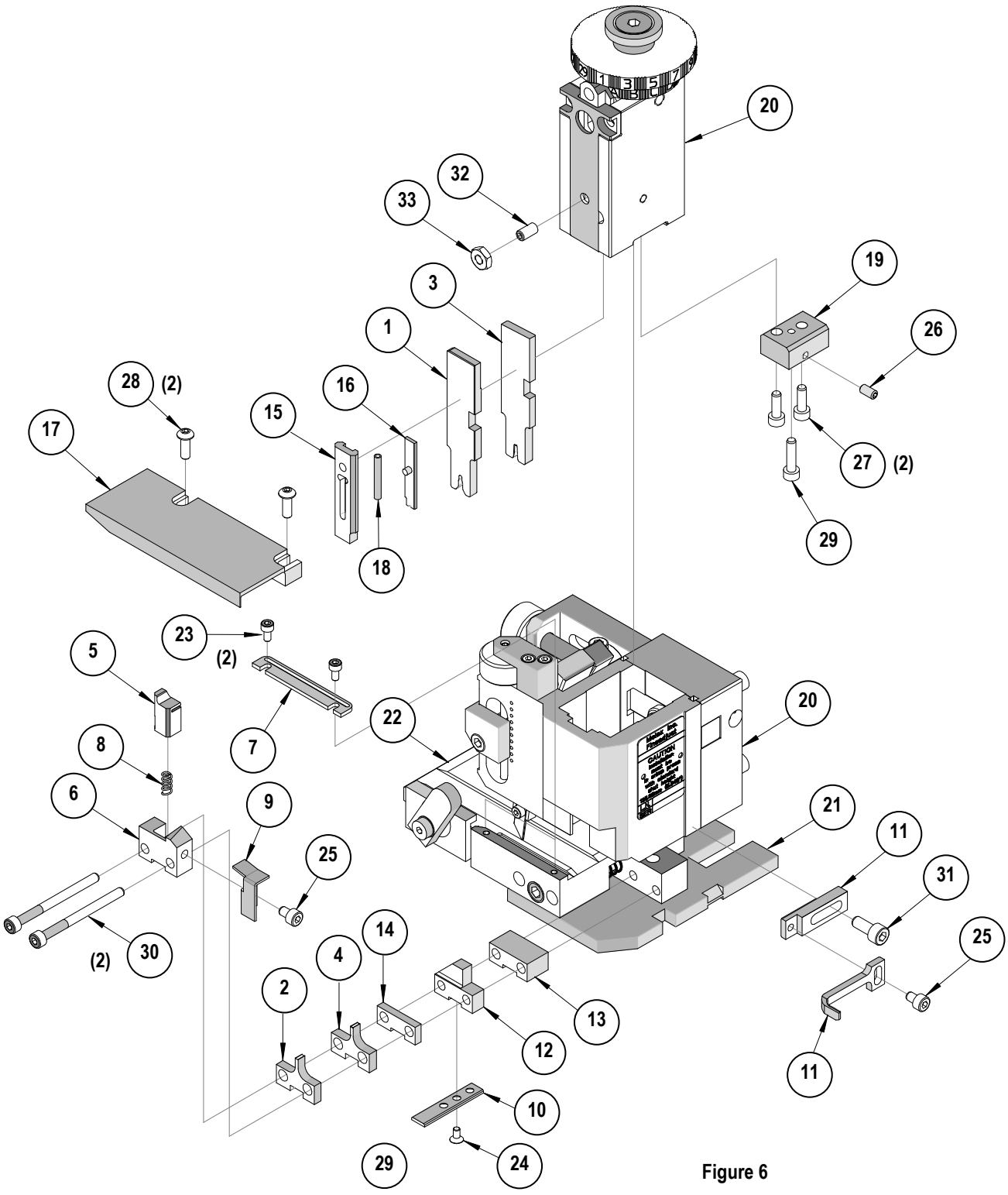


Figure 6

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.

Contact Information

For more information on Molex application tooling please contact Molex at 1-800-786-6539.

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