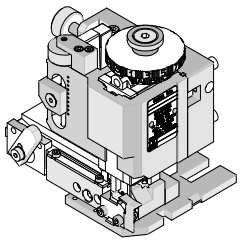
FineAdjust Applicator

Application Tooling Specification Sheet



Order No. 63902-7800

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

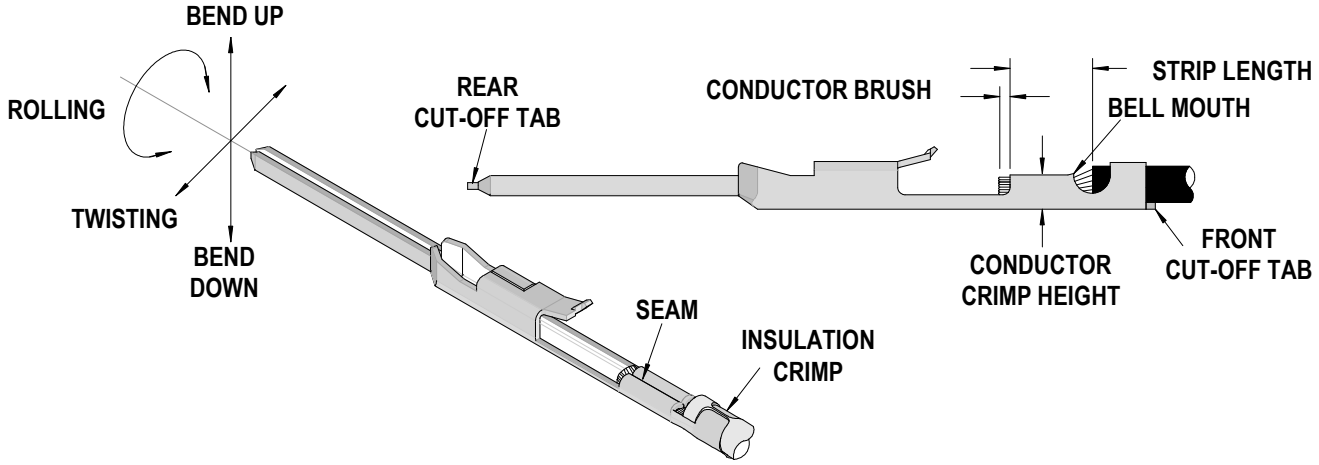
SCOPE

Products: SL™ Crimp Terminal, Male, 22-24 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.
50088	50088-8000	50088-8060		22-24	0.35-0.20	1.25-1.45	.049-.057	1.00-1.60	.039-.063	3.00-3.50	.118-.138
	50088-8014	50088-8099									
	50088-8028										
70021	16-02-0081	16-02-0116	70021-0021	22-24	0.35-0.20	1.25-1.45	.049-.057	1.40-1.63	.055-.064	3.17-3.56	.125-.140
	16-02-0093	40-08-0874	70021-0023								
	16-02-0107	70021-0019	70021-0081								

(1) To achieve optimum IPC-A620 Class 2 insulation crimp, use this insulation diameter
(2) Overall insulation diameter specification for terminal

DEFINITION OF TERMS



CRIMP SPECIFICATION

Terminal Series No.	Bell mouth		Cut-off Tab Maximum				Conductor Brush	
			Front		Rear			
	mm	In.	mm	In.	mm	In.	mm	In.
50088	0.20-0.50	.008-.020	0.15	.006	0.30	.012	0.00-1.00	.000-.039
70021	0.20-0.50	.008-.020	0.13	.005	0.13	.005	0.00-1.00	.000-.039

Terminal Series No.	Bend up	Bend down	Twist	Roll	Punch Width mm (Ref)				Seam
	Degree		Degree		Conductor		Insulation		
					mm	In	mm	In	
50088	3	3	3	8	1.40	.055	1.70	.067	Seam shall not be open and no wire allowed out of the crimping area
70021	3	3	3	8	1.40	.055	1.70	.067	

After crimping, the conductor profile should measure the following.

Terminal Series No.	Wire Size		Crimp Height		Pull Force Minimum	
	AWG	mm^2	mm	In.	N	Lb.
50088	22	0.35	0.84-0.89	.032-.035	39.1	8.8
	24	0.20	0.74-0.81	.029-.032	29.3	6.6
70021	22	0.35	0.84-0.89	.032-.035	35.6	8.0
	24	0.20	0.74-0.81	.029-.032	22.2	5.0

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 63902-7800				
Item	**Order No**	**Engineering No.**	**Description**	**Quantity**
Perishable Tooling				
	63902-7870	63902-7870	Tool Kit (All "Y" Items)	REF
1	63444-1417	63444-1417	Conductor Punch	1 Y
2	63445-1446	63445-1446	Conductor Anvil	1 Y
3	63454-0123	63454-0123	Insulation Punch	1 Y
4	63445-1730	63445-1730	Insulation Anvil	1 Y
5	63443-0003	63443-0003	Cut-Off Plunger	1 Y
6	63443-0012	63443-0012	Front Plunger Retainer	1 Y
7	63443-1401	63443-1401	Cut-off Die Blade	1 Y
8	63466-0201	63466-0201	Rear Cut-Off Plunger	1 Y
9	63466-0301	63466-0301	Rear Plunger Retainer	1 Y
Other Components				
10	11-18-4083	60707-8	Feed Guide	1
11	11-24-1067	4996-4	Cut-Off Plunger Spring	2
12	63443-0009	63443-0009	Scrape Chute	1
13	63443-0024	63443-0024	Key	1
14	63443-0090	63443-0090	Wire Stop	1
15	63443-1720	63443-1720	Height Spacer	1
16	63443-2204	63443-2204	Coarse Spacer (4.00mm)	1
17	63443-2310	63443-2310	Fine Spacer(3.50mm)	1
18	63443-2802	63443-2802	Plunger Striker	1
19	63443-2907	63443-2907	Plunger	1
20	63443-3060	63443-3060	Rear Plunger Striker	1
21	63443-6111	63443-6111	Rear Cover	1
22	63600-1057	63600-1057	Compression Spring	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	M4 by 6 Long SHCS	2**
29	N/A	N/A	M4 by 8 Long SHCS	1**
30	N/A	N/A	M4 by 10 Long SHCS	2**
31	N/A	N/A	M4 by 12 Long BHCS	2**
32	N/A	N/A	M4 by 50 Long SHCS	2**
33	N/A	N/A	M5 by 12 Long SHCS	1**
34	N/A	N/A	#10-32 by 3/8"Long Flat Point SSS	1**
35	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

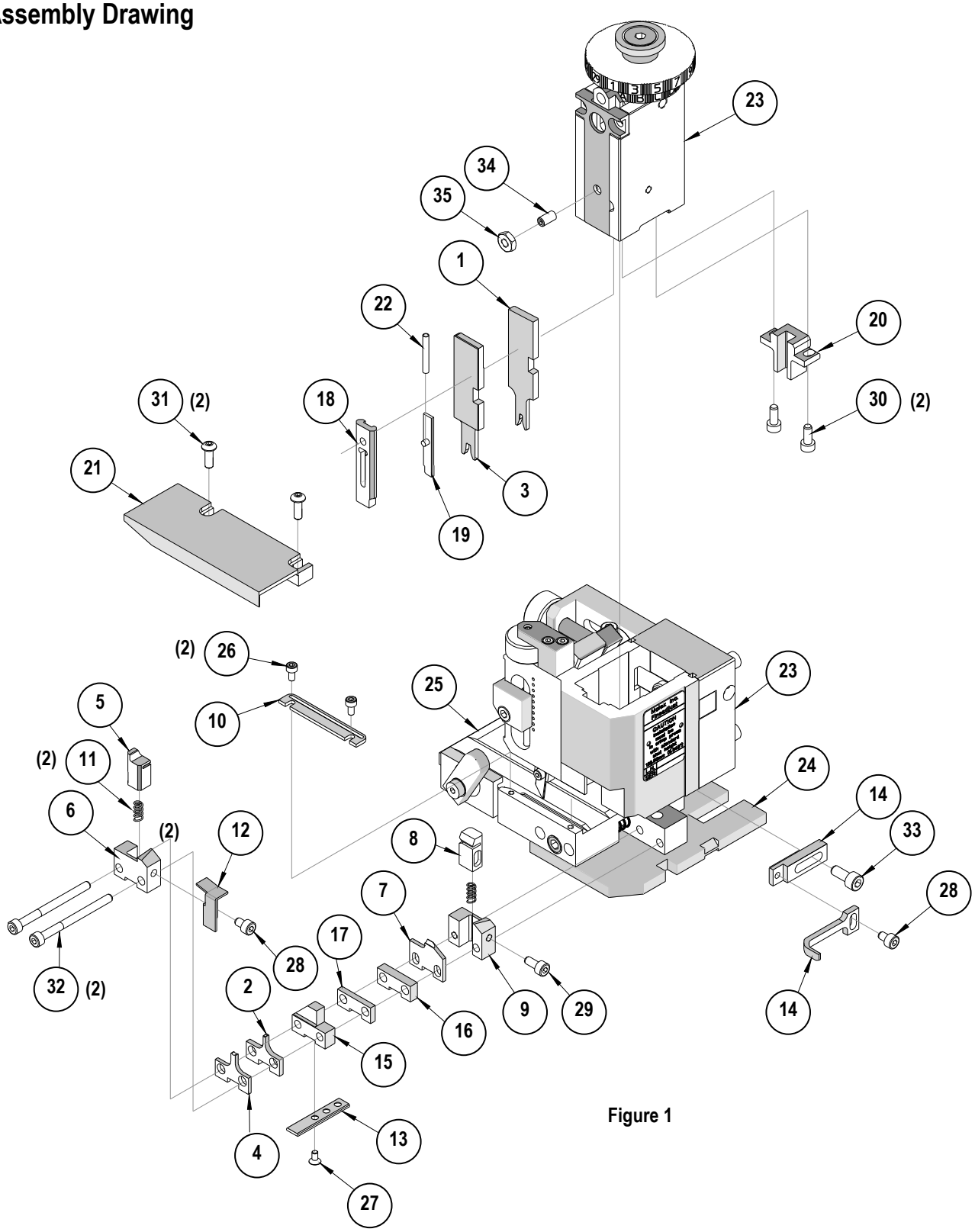


Figure 1

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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