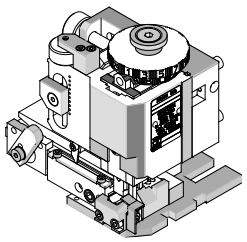
FineAdjust Applicator

Application Tooling Specification Sheet



Order No. 63903-6700

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 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

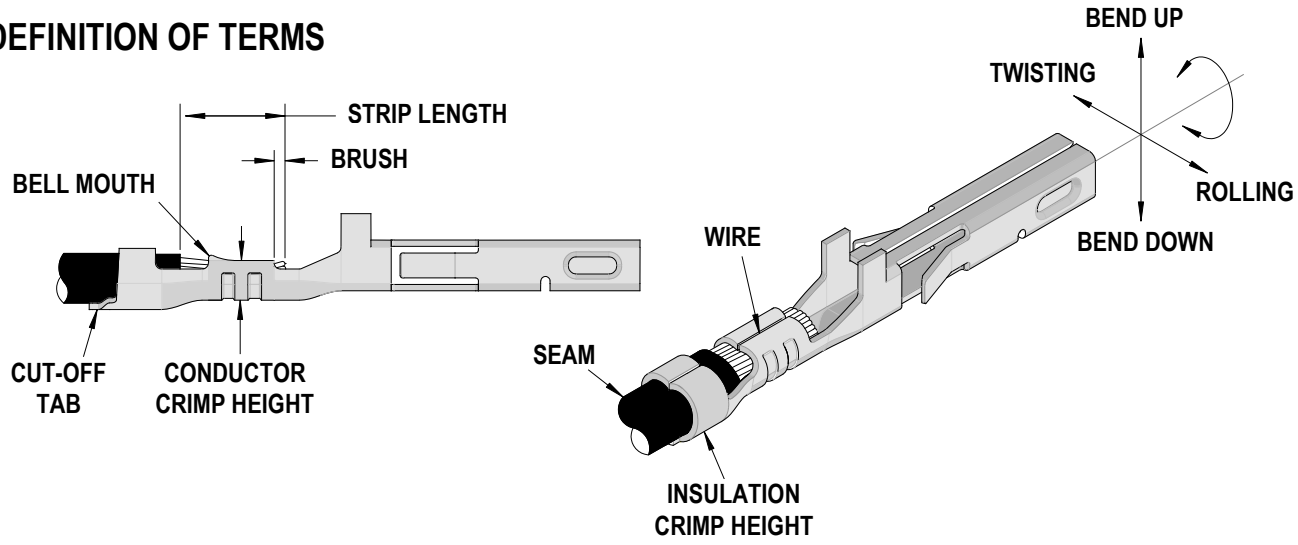
SCOPE

Products: Mini-Fit TPA 2.0 Crimp Terminals, 16 AWG wires.

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.
172718	172718-1111	16	---	1.98-2.55	.078-.100	1.98-2.55	.078-.100	3.20-3.80	.126-.150
	172718-1121								
172765	172765-1111								
	172765-1121								

(1) To achieve optimum IPC-A620 insulation crimps, use this insulation OD range.
(2) 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.
172718 172765	0.20-0.70	.008-.028	.30	.012	0.20-0.80	.008-.032

Terminal Series No.	Bend up Bend down		Twist Roll		Punch Width (Ref)				Seam
					Conductor		Insulation		
	Degree (Max)		Degree (Max)		mm	In	mm	In	
172718 172765	3	3	3	5	1.80	.071	2.50	.098	Seam shall not be open and no wire allowed out of the crimping area

After crimping, the conductor profile 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.
172718 172765	16	---	1.18-1.28	.046-.050	1.80	.071	133.5	30.0

Terminal Series No.	Wire Size		Insulation			
			Crimp Height (Ref)		Crimp Width (Ref)	
	AWG	mm^2	mm	In.	Mm	In.
172718 172765	16	---	2.50	.098	2.60	.102

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 63903-6700				
Item	**Order No**	**Engineering No.**	**Description**	**Quantity**
Perishable Tooling				
	63903-6770	63903-6770	Tool Kit (All "Y" Items)	REF
1	63457-1803	63457-1803	Conductor Punch	1 Y
2	63455-1802	63455-1802	Conductor Anvil	1 Y
3	63446-2525	63446-2525	Insulation Punch	1 Y
4	63445-2541	63445-2541	Insulation Anvil	1 Y
5	63443-0005	63443-0005	Front 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	Front 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	63443-1722	63443-1722	Height Spacer (19.20mm)	1
15	63443-2215	63443-2215	Spacer (15.0mm)	1
16	63443-2307	63443-2307	Spacer (3.35mm)	1
17	63443-2806	63443-2806	Front Plunger Striker	1
18	63443-2911	63443-2911	Striker Plunger	1
19	63443-6117	63443-6117	Rear Cover	1
20	63903-6905	63903-6905	Terminal Hold Down	1
21	63600-1057	63600-1057	Striker Plunger 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 50 Long SHCS	2**
31	N/A	N/A	M5 by 12 Lg 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

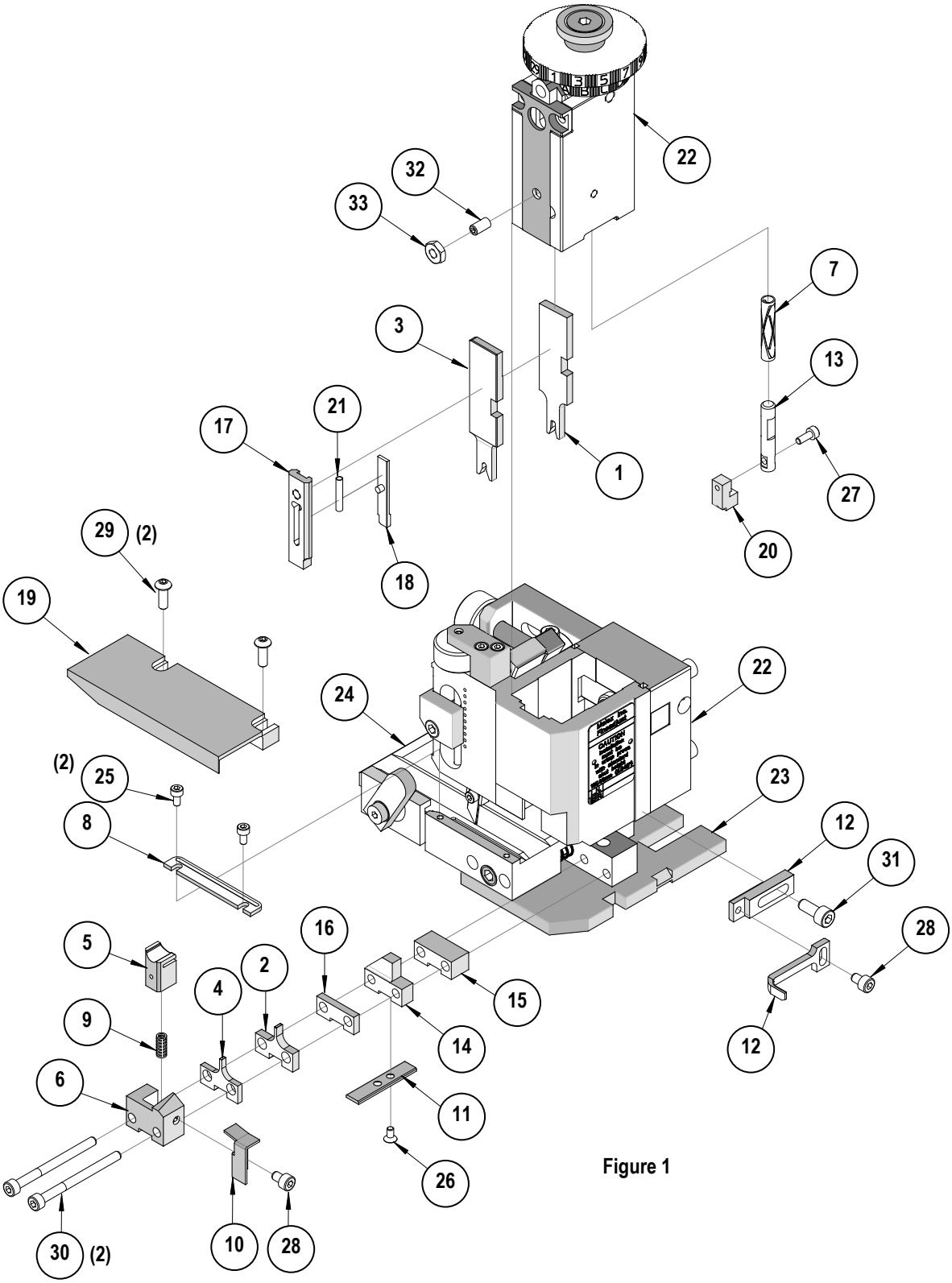


Figure 1

NOTES

1. Molex recommends 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 135.8mm (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.

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