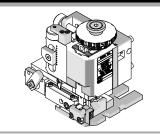


FineAdjust Applicator

Application Tooling Specification Sheet



Order No. 63900-6600

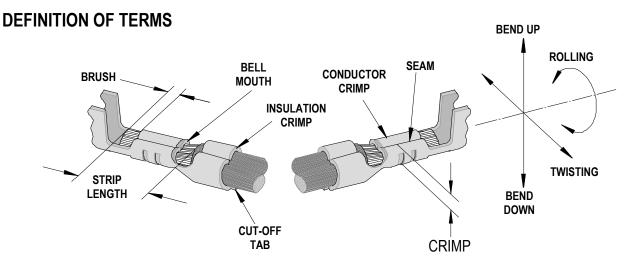
FEATURES

- 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: 1.25mm (.049") Pitch Wire-to-Board Connector Dual Plug Terminal, 26-28 AWG.

Terminal Series No.	Terminal	Wii	re Size	→Insulatio	n Diameter	Strip Length			
Terminal Series No.	Terrifica	Order No.	AWG	mm²	mm	ln.	mm	ln.	
501930	501930-0100	501930-1100	26-28	.136079	0.80-1.00	.031039	1.50-1.70	.060067	
502381	502381-0000	502381-0010	26-28	.136079	0.80-1.00	.031039	1.50-1.70	.060067	
→ This Applicator will not meet A-620 Class 1, 2, or 3 standards with insulation diameter range of 0.80-1.00mm.									



The above terminal drawing is a generic terminal representation. It is not an image of a terminal listed in the scope.

Doc. No: ATS-639006600 Release Date: 02-20-08 UNCONTROLLED COPY Page 1 of 5

Revision Date: 09-06-16

Revision: C

CRIMP SPECIFICATION

Terminal Series No.	Bell n	nouth	Cut-off Tab	Maximum	Conductor Brush	
Terminal Series No.	Mm	ln.	mm	ln.	mm	ln.
501930	0.10-0.30	.004012	0.10	.004	0.10-0.40	.004016
502381	0.10-0.30	.004012	0.10	.004	0.10-0.40	.004016

	Bend up E	Twist	Roll	Punc	h Widt	h mm	(Ref)	Seam	
Terminal Series No.	Dellu up	i wist	Koli	Conductor		Insulation			
	Degree		Degree		mm	ln	mm	ln	Seam shall not be open
501930	3	3	4	6	0.80	.031	0.80	.031	and no wire allowed out
502381	3	3	4	6	0.80	.031	0.80	.031	of the crimping area

After crimping, the conductor profile should measure the following.

	\A/iwa	C:	Conductor						
Terminal Series No.	Wire	Size	Crimp	Height	Crimp	Width (Ref)			
	AWG	mm ²	mm	ln.	mm	ln.			
501930	26	.136	0.56-0.61	.022024					
	28	.079	0.53-0.58	.021023					
502381	26	.136	0.56-0.61	.022024					
302361	28	.079	0.53-0.58	.021023					

	Wire	Ci-c		Insulation (Pull Force Minimum			
Terminal Series No.	vviie	Size	Crimp	Crimp Width				
	AWG	mm ²	mm	ln.	mm	ln.	N	Lb.
501930	26	.136	1.18-1.28	.046050			9.8	2.20
	28	.079	1.15-1.25	.045049			9.8	2.20
502381	26	.136	1.18-1.28	.046050			9.8	2.20
	28	.079	1.15-1.25	.045049			9.8	2.20

Tool Qualification Notes:

1. Pull Force should be measured with no influence from the insulation crimp.

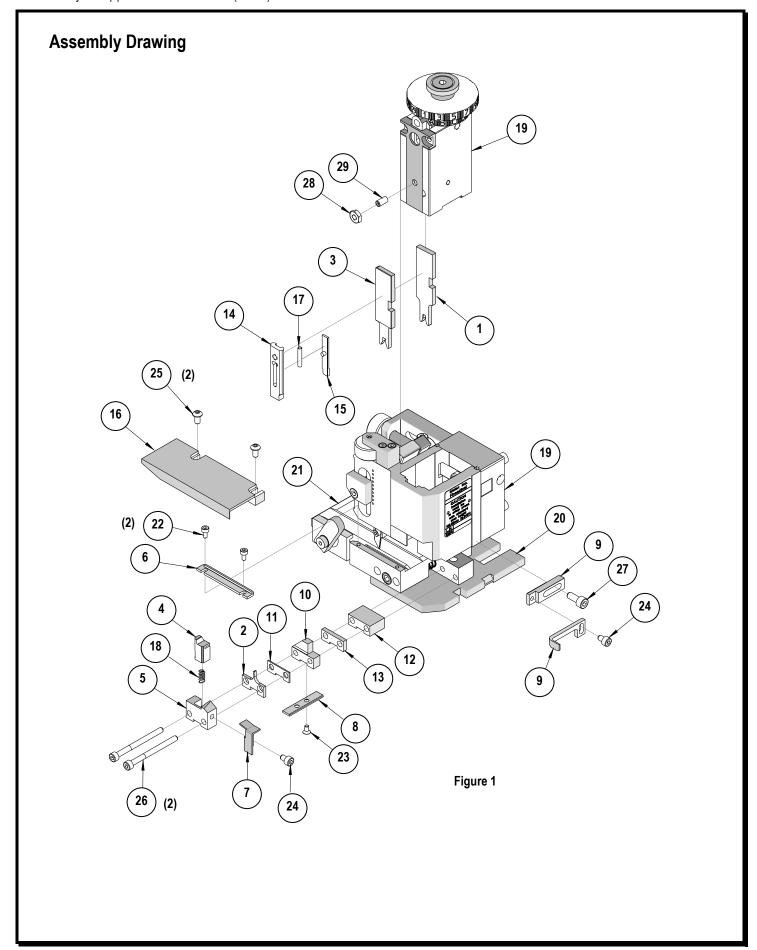
2. The above specifications are guidelines to an optimum crimp.

Doc. No: ATS-639006600 Page 2 of 5 Release Date: 02-20-08 **UNCONTROLLED COPY**

PARTS LIST

	FineAdjust Applicator 63900-6600									
Item	Order No Engineering No. Description									
Perishable Tooling										
	63900-6670	63900-6670	Tool Kit (All "Y" Items)	REF						
1	63444-0804	63444-0804	Conductor Punch	1 Y						
2	63445-0821	63445-0821	Anvil	1 Y						
3	63446-0808	63446-0808	Insulation Punch	1 Y						
4	63443-0002	63443-0002	Front Cut-Off Plunger	1 Y						
5	63443-0012	63443-0012	Front Plunger Retainer	1 Y						
		Other	Components							
6	11-18-4083	60707-8	Feed Guide	1						
7	63443-0009	63443-0009	Front Scrap Chute	1						
8	63443-0025	63443-0025	Key	1						
9	63443-0090	63443-0090	Wire Stop	1						
10	63443-1719	63443-1719	Height Spacer (18.90mm)	1						
11	63443-2201	63443-2201	Fine Spacer (1.00mm)	1						
12	63443-2216	63443-2216	Coarse Spacer (16.00mm)	1						
13	63443-2310	63443-2310	Fine Spacer (3.50mm)	1						
14	63443-2802	63443-2802	Front Plunger Striker	1						
15	63443-2904	63443-2904	Wire Hold Down Plunger	1						
16	63443-6109	63443-6109	Rear Cover	1						
17	63600-0021	63600-0021	Wire Hold Down Spring	1						
18	11-24-1067	4996-4	Cut-Off Plunger Spring	1						
			Frame							
19	63800-4901	63800-4901	Тор	1						
20	63801-3281	63801-3281	Base	1						
21	63801-4650	63801-4650	Track	1						
		Н	ardware							
22	N/A	N/A	M3 by 6 Long SHCS	2**						
23	N/A	N/A	M3 by 6 Long FHCS	1**						
24	N/A	N/A	M4 by 6 Long SHCS	2**						
25	N/A	N/A	M4 by 12 Long BHCS	2**						
26	N/A	N/A	M4 by 50 Long SHCS	2**						
27	N/A	N/A	M5 by 12 Lg SHCS	1**						
28	N/A	N/A	#10-32 by 3/8"Long Flat Point SSS	1**						
29	N/A	N/A	#10-32 Hex Jam Nut	1**						
*:	** Available from an industrial supply company such as MSC (1-800-645-7270).									

Doc. No: ATS-639006600 Release Date: 02-20-08 **UNCONTROLLED COPY** Page 3 of 5 Revision: C Revision Date: 09-06-16



Doc. No: ATS-639006600 Revision: C

Release Date: 02-20-08 Revision Date: 09-06-16

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.

Application Tooling Support

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Doc. No: ATS-639006600 Release Date: 02-20-08 **UNCONTROLLED COPY** Page 5 of 5 Revision: C Revision Date: 09-06-16