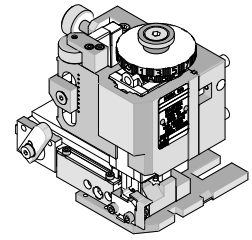


**FineAdjust  
Applicator  
(Overlap Insulation  
Crimp)**



**Application Tooling  
Specification Sheet**



**Order No. 63902-4600**

**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

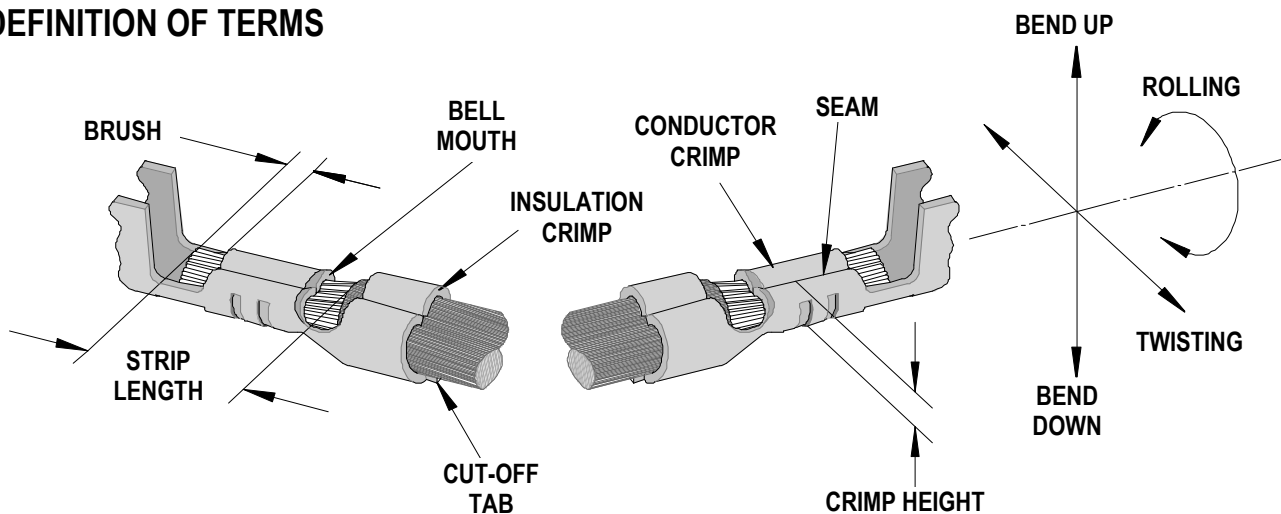
**SCOPE**

Products: Standard .093" (2.63mm) Pin and Socket Crimp Terminal

Terminal Series No.	Terminal Order No.	Wire Size		Insulation Diameter		Strip Length	
		AWG	mm <sup>2</sup>	mm	In.	mm	In.
42477	02-09-1615	16-18	0.81-1.30	2.36-3.20	.093-.126	3.96-5.33	.156-.218
42478	02-09-2611	16-18	0.81-1.30	2.36-3.20	.093-.126	3.96-5.33	.156-.218
	02-09-2612						

For 14AWG 2.79mm (.110") -3.56mm (.140") insulation diameter, use 63902-4700 applicator.

**DEFINITION OF TERMS**



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

### CRIMP SPECIFICATION

Terminal Series No.	Bell mouth		Cut-off Tab Maximum		Conductor Brush	
	mm	In.	mm	In.	mm	In.
42477	0.25-0.58	.010-.023	0.25	.010	0.13-0.55	.005-.022
42478	0.25-0.58	.010-.023	0.25	.010	0.13-0.55	.005-.022

Terminal Series No.	Bend up	Bend down	Twist	Roll	Punch Width mm (Ref)				Seam Seam shall not be open and no wire allowed out of the crimping area
	Degree		Degree		Conductor		Insulation		
					mm	In	mm	In	
42477	3	3	4	8	2.30	.090	3.60	.141	
42478	3	3	4	8	2.30	.090	3.60	.141	

After crimping, the conductor profile should measure the following.

Terminal Series No.	Wire Size		Crimp Height		Pull Force Minimum	
	AWG	mm <sup>2</sup>	mm	In.	N	Lb.
42477	16	1.31	1.70-1.60	.067-.063	177.9	40.00
	18	0.81	1.55-1.47	.061-.058	115.6	26.00
42478	16	1.31	1.70-1.60	.067-.063	177.9	40.00
	18	0.81	1.55-1.47	.061-.058	115.6	26.00

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

The above specifications are guidelines to an optimum crimp.

**PARTS LIST**

<b>FineAdjust Applicator 63902-4600</b>				
<b>Item</b>	<b>Order No</b>	<b>Engineering No.</b>	<b>Description</b>	<b>Quantity</b>
<b>Perishable Tooling</b>				
	63902-4670	63902-4670	Tool Kit (All "Y" Items)	REF
1	63444-2325	63444-2325	Conductor Punch	1 Y
2	63445-2348	63445-2348	Conductor Anvil	1 Y
3	63454-0066	63454-0066	Insulation Punch-Overlap	1 Y
4	63445-3614	63445-3614	Insulation Anvil	1 Y
5	63443-0035	63443-0035	Cut-Off Plunger Front	1 Y
6	63443-0036	63443-0036	Plunger Retainer Front	1 Y
<b>Other Components</b>				
7	11-18-4083	60707-8	Feed Guide	1
8	11-24-1067	4996-4	Cut-Off Plunger Spring	1
9	63443-3160	63443-3160	Plunger Striker	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	63443-1719	63443-1719	18.90mm Height Spacer	1
14	63443-2214	63443-2214	14.00mm Coarse Spacer	1
15	63443-2308	63443-2308	3.40mm Fine Spacer	1
16	63443-6119	63443-6119	Rear Cover	1
<b>Frame</b>				
17	63800-4901	63800-4901	Top	1
18	63801-3281	63801-3281	Base	1
19	63801-4650	63801-4650	Track	1
<b>Hardware</b>				
20	N/A	N/A	M3 by 6 Long SHCS	2**
21	N/A	N/A	M3 by 6 Long FHCS	1**
22	N/A	N/A	M4 by 6 Long SHCS	2**
23	N/A	N/A	M4 by 12 Long BHCS	2**
24	N/A	N/A	M4 by 50 Long SHCS	2**
25	N/A	N/A	M5 by 12 Long SHCS	1**
26	N/A	N/A	#10-32 by 3/8" Long Flat Point SSS	1**
27	N/A	N/A	#10-32 Hex Jam Nut	1**
** Available from an industrial supply company such as MSC (1-800-645-7270).				



## 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 135.8 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.

<http://www.molex.com>

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