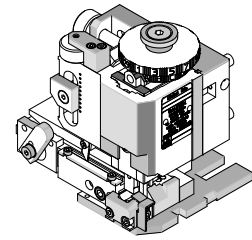


**FineAdjust
Applicator**



**Application Tooling
Specification Sheet**



Order No. 63901-3200

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

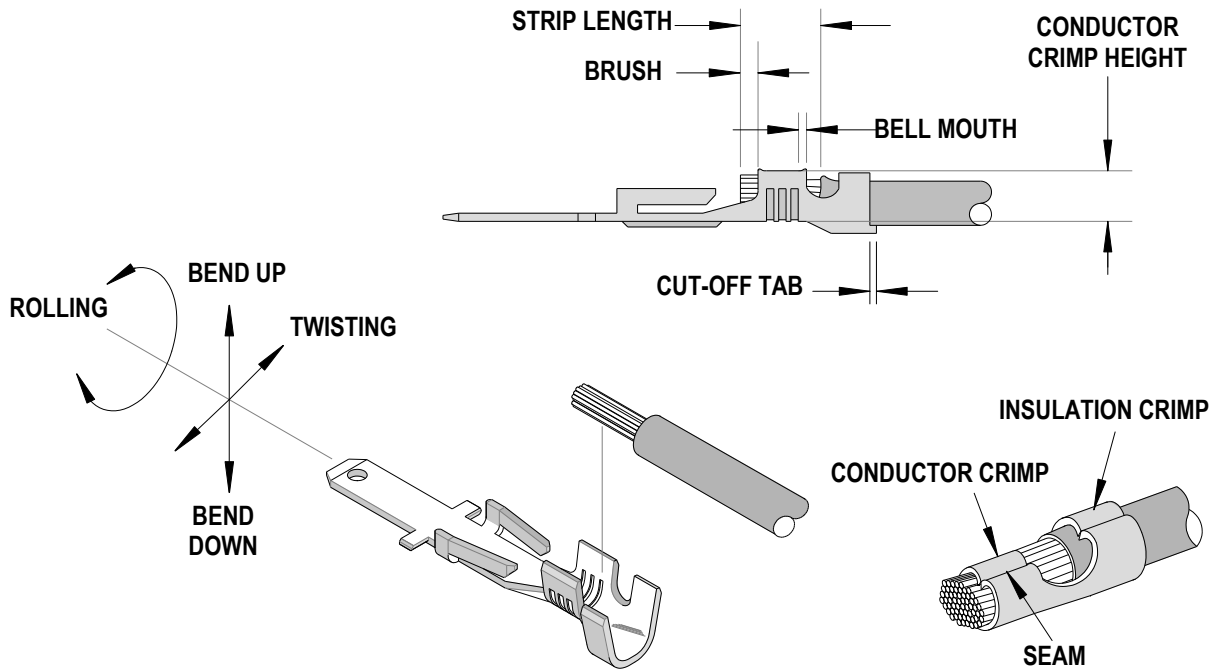
SCOPE

Products: Sabre™ Male Flat Blade Crimp Terminal, 14-16 AWG (UL1007).

Terminal Series No.	Terminal Order No.	Wire Size and Type			Insulation Diameter				Strip Length	
					IPC/WHMA-A620 ♦		Terminal ♦♦			
		AWG	mm ²	Type	mm	In.	mm	In.	mm	In.
43178	43178-2001	14	2.00	UL1007	2.79	.110	2.79	.110	3.96-5.54	.156-.218
	43178-2002									
	43178-6001	16	1.30	UL1007	2.34	.092	2.34	.092		
	43178-6002									

♦ To achieve optimum IPC-A620 insulation crimps, use this insulation OD range.
♦♦ 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.
43178	0.25-1.00	.010-.039	0.50	.019	1.50	.059

Terminal Series No.	Bend up	Bend down	Twist	Roll	Punch Width (Ref)				Seam
					Conductor		Insulation		
	Degree	Degree	mm	In	mm	In			
43178	3	3	4	8	3.40	.133	3.40	.133	Seam shall not be open and no wire allowed out of the crimping area

After crimping, the conductor profile should measure the following.

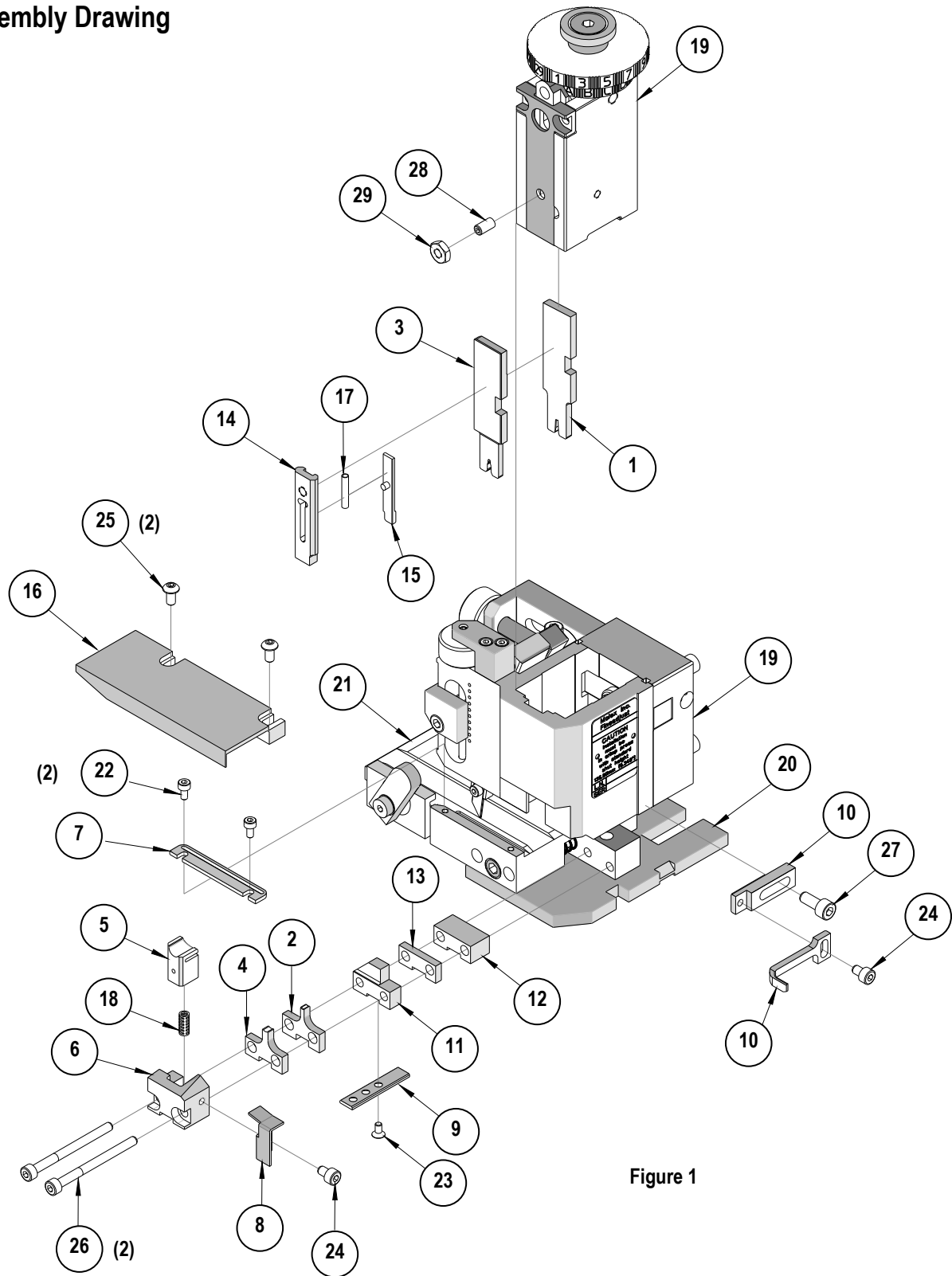
Terminal Series No.	Wire Size		Crimp Height		Pull Force Minimum	
	AWG	mm ²	mm	In.	N	Lb.
43178	14	2.00	1.95-2.05	.077-.081	222.0	50
	16	1.30	1.80-1.90	.071-.075	133.0	30

Pull Force should be measured with no influence from the insulation crimp. The above specifications are guidelines to an optimum crimp.

PARTS LIST

FineAdjust Applicator 63901-3200				
Item	Order No	Engineering No.	Description	Quantity
Perishable Tooling				
	63901-3270	63901-3270	Tool Kit (All "Y" Items)	REF
1	63457-3401	63457-3401	Conductor Punch	1 Y
2	63445-3443	63445-3443	Conductor Anvil	1 Y
3	63454-3401	63454-3401	Insulation Punch	1 Y
4	63445-3444	63445-3444	Insulation Anvil	1 Y
5	63443-0037	63443-0037	Front Cut-Off Plunger	1 Y
6	63443-0038	63443-0038	Front Plunger Retainer	1 Y
Other Components				
7	11-18-4083	60707-8	Feed Guide	1
8	63443-0009	63443-0009	Front Scrap Chute	1
9	63443-0024	63443-0024	Key	1
10	63443-0090	63443-0090	Wire Stop	1
11	63443-1712	63443-1712	18.20mm Height Spacer	1
12	63443-2215	63443-2215	15.00mm Spacer	1
13	63443-2301	63443-2301	3.05mm Spacer	1
14	63443-2801	63443-2801	Front Plunger Striker	1
15	63443-2916	63443-2916	Wire Hold Down Plunger	1
16	63443-6121	63443-6121	Rear Cover	1
17	63600-1057	63600-1057	Wire Hold Down Spring	1
18	63700-0539	63700-0539	Compression Spring	1
Frame				
19	63800-4901	63800-4901	Top	1
20	63801-3281	63801-3281	Base	1
21	63801-4650	63801-4650	Track	1
Hardware				
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).				

Assembly Drawing



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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