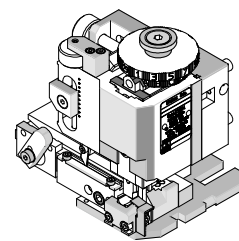




**FineAdjust  
Applicator**

**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

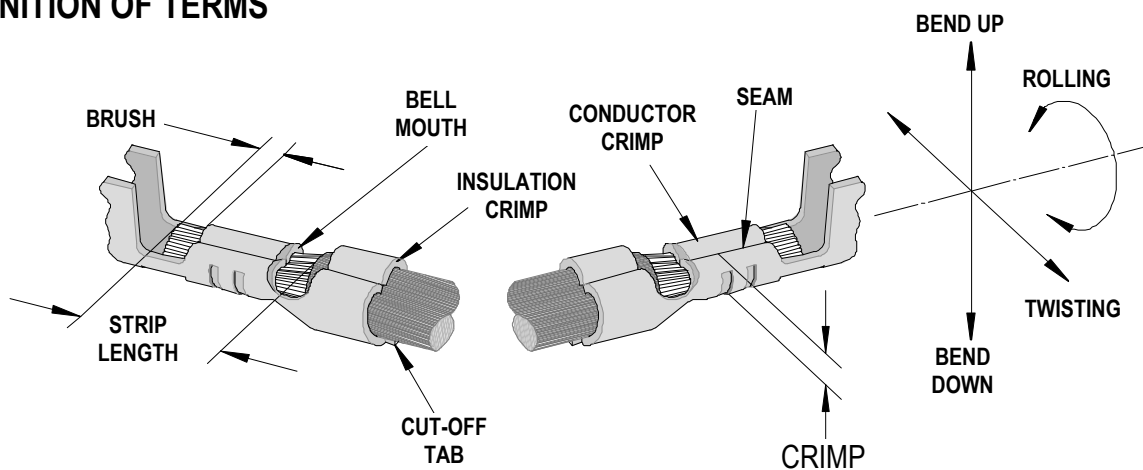
**SCOPE**

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

Terminal Series No.	Terminal Order No.		Wire Size		Insulation Diameter		Strip Length	
			AWG	mm <sup>2</sup>	mm	In.	mm	In.
501930	501930-0100	501930-1100	26-28	.136-.079	0.80-1.00	.031-.039	1.50-1.70	.060-.067
502381	502381-0000	502381-0010	26-28	.136-.079	0.80-1.00	.031-.039	1.50-1.70	.060-.067

♦ This Applicator will not meet A-620 Class 1, 2, or 3 standards with insulation diameter range of 0.80-1.00mm.

**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.
501930	0.10-0.30	.004-.012	0.10	.004	0.10-0.40	.004-.016
502381	0.10-0.30	.004-.012	0.10	.004	0.10-0.40	.004-.016

Terminal Series No.	Bend up	Bend down	Twist	Roll	Punch Width mm (Ref)				Seam
	Degree		Degree		Conductor		Insulation		
					mm	In	mm	In	
501930	3	3	4	6	0.80	.031	0.80	.031	Seam shall not be open and no wire allowed out of the crimping area
502381	3	3	4	6	0.80	.031	0.80	.031	

After crimping, the conductor profile should measure the following.

Terminal Series No.	Wire Size		Conductor			
	AWG	mm <sup>2</sup>	Crimp Height		Crimp Width (Ref)	
			mm	In.	mm	In.
501930	26	.136	0.56-0.61	.022-.024		
	28	.079	0.53-0.58	.021-.023		
502381	26	.136	0.56-0.61	.022-.024		
	28	.079	0.53-0.58	.021-.023		

Terminal Series No.	Wire Size		Insulation (Ref)				Pull Force Minimum	
	AWG	mm <sup>2</sup>	Crimp Height		Crimp Width		N	Lb.
			mm	In.	mm	In.		
501930	26	.136	1.18-1.28	.046-.050			9.8	2.20
	28	.079	1.15-1.25	.045-.049			9.8	2.20
502381	26	.136	1.18-1.28	.046-.050			9.8	2.20
	28	.079	1.15-1.25	.045-.049			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.

**PARTS LIST**

<b>FineAdjust Applicator 63900-6600</b>				
<b>Item</b>	<b>Order No</b>	<b>Engineering No.</b>	<b>Description</b>	<b>Quantity</b>
<b>Perishable Tooling</b>				
	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
<b>Other Components</b>				
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
<b>Frame</b>				
19	63800-4901	63800-4901	Top	1
20	63801-3281	63801-3281	Base	1
21	63801-4650	63801-4650	Track	1
<b>Hardware</b>				
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

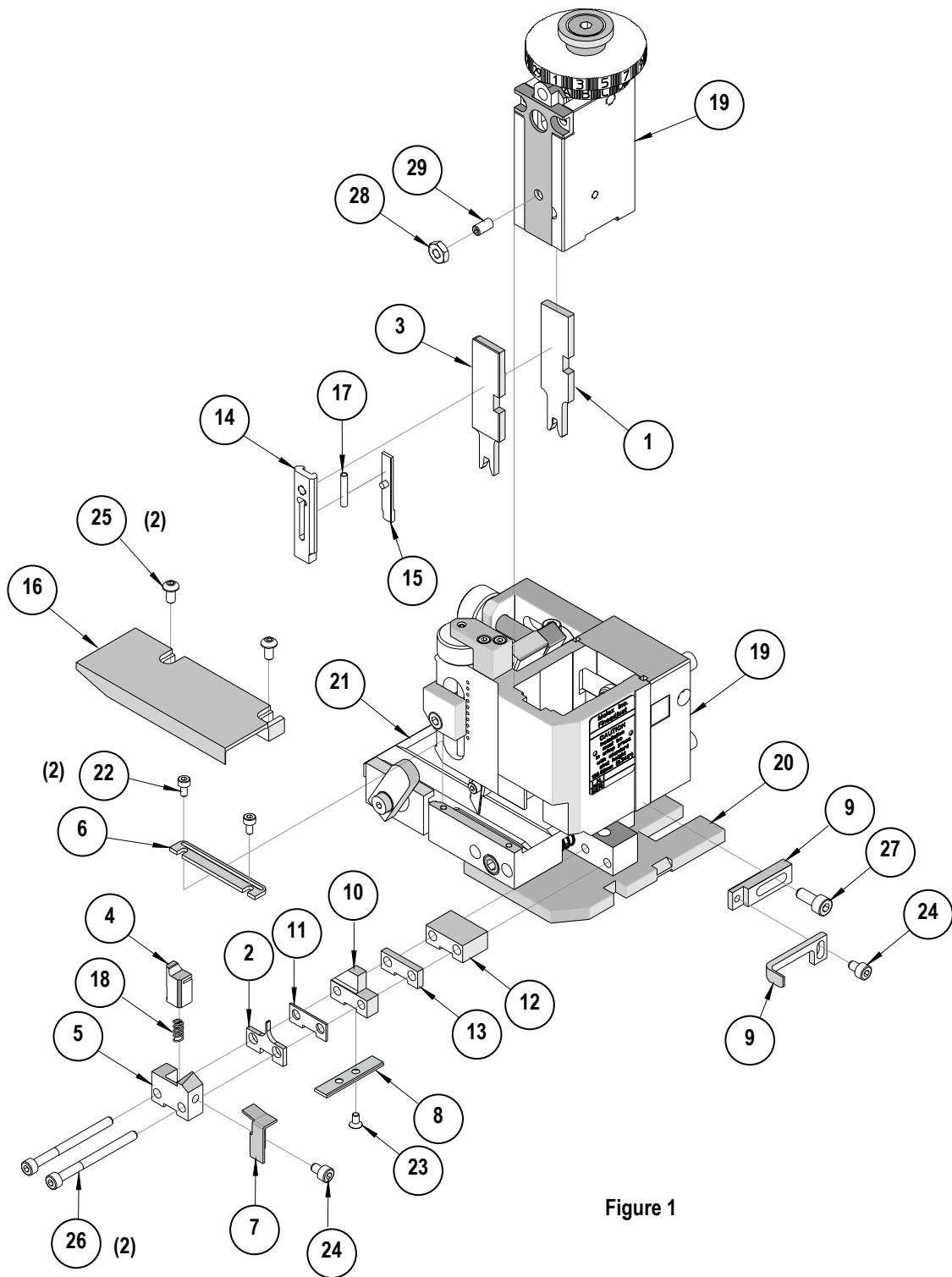


Figure 1

## 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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