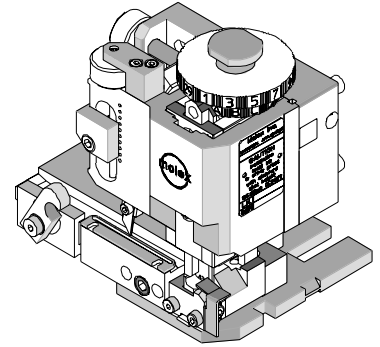




## FineAdjust Applicator Specification Sheet Part No. 63864-4000



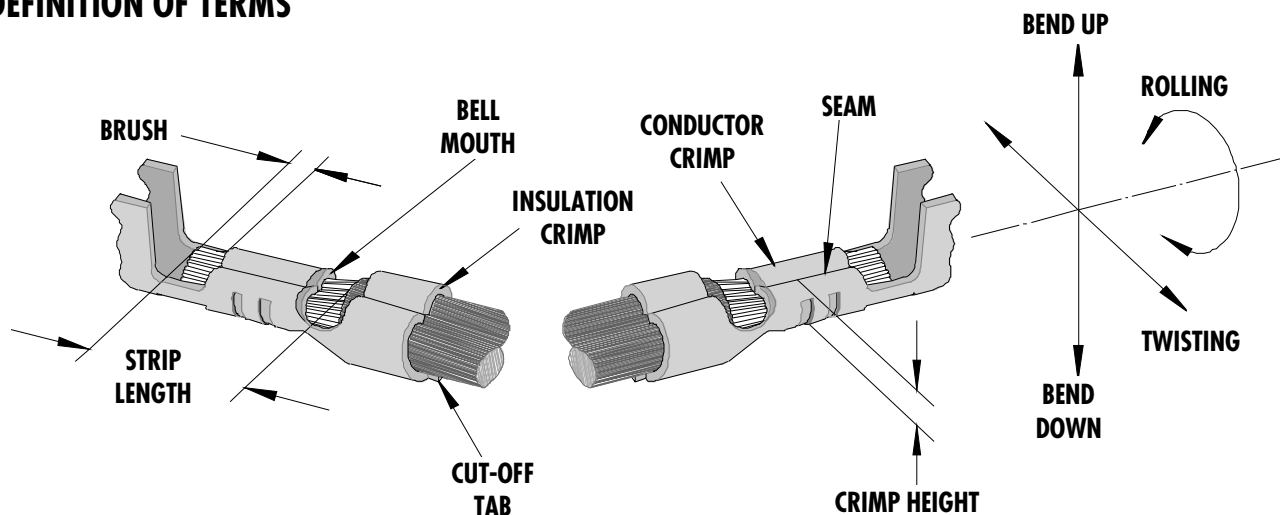
### FEATURES

- 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 0.15mm (.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
- Also available: 63864-4100 with full radius insulation punch recommended for large and max. insulation diameter, (See Scope)

### SCOPE

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	14-18	0.81-2.07	2.36-3.56	.093-.140	3.96-5.33	.156-.218
42478	02-09-2611	14-18	0.81-2.07	2.36-3.56	.093-.140	3.96-5.33	.156-.218
	02-09-2612						

### 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 Max.		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 Min.	
	AWG	mm <sup>2</sup>	mm	In.	N	Lb.
42477	14	2.07	1.91-1.80	.075-.071	222.4	50.00
42477	16	1.31	1.70-1.60	.067-.063	177.9	40.00
42477	18	0.81	1.55-1.47	.061-.058	115.6	26.00
42478	14	2.07	1.91-1.80	.075-.071	222.4	50.00
42478	16	1.31	1.70-1.60	.067-.063	177.9	40.00
42478	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>Mini-Mac Applicator 63864-4000</b>				
<b>Item</b>	<b>Order No</b>	<b>Engineering No.</b>	<b>Description</b>	<b>Quantity</b>
<b>Perishable Tooling</b>				
	<b>63864-4070</b>	<b>63864-4070</b>	<b>Tool Kit (All "Y" Items)</b>	<b>REF</b>
1	63444-2323	63444-2323	Conductor Punch	1 Y
2	63445-2348	63445-2348	Conductor Anvil	1 Y
3	63446-3607	63446-3607	Insulation Punch	1 Y
4	63445-3613	63445-3613	Insulation Anvil	1 Y
5	63443-0002	63443-0002	Cut-Off Plunger	1 Y
6	63443-0012	63443-0012	Front Plunger Retainer	1 Y
<b>Other Components</b>				
7	11-18-4083	60707-8	Front Cover	1
8	11-24-1067	4996-4	Cut-off Plunger Spring	1
9	63443-0009	63443-0009	Scrape Chute	1
10	63443-0021	63443-0021	Lower Tooling Key	1
11	63443-2417	63443-2417	Anvil Mount	1
12	63443-3160	63443-3160	Front Plunger Striker	1
13	63443-4006	63443-4006	Wire Stop	1
14	63443-6011	63443-6011	Rear Cover	1
<b>Frame</b>				
15	63800-4900	63800-4900	Fine Adjust Applicator Frame	1
<b>Hardware</b>				
16	N/A	N/A	M3 by 6Lg. SHCS	2**
17	N/A	N/A	M4 by 6Lg. SHCS	1**
18	N/A	N/A	M4 by 12Lg. BHCS	2**
19	N/A	N/A	M4 by 16Lg. SHCS	1**
20	N/A	N/A	M4 by 20Lg. SHCS	1**
21	N/A	N/A	M4 by 50Lg. SHCS	1**
22	N/A	N/A	3MM by 6Lg. Roll Pin	1**
23	N/A	N/A	#10-32 by 1/4"Lg. BHCS	1**
** Available from an industrial supply company such as MSC (1-800-645-7270).				

# Assembly Drawing

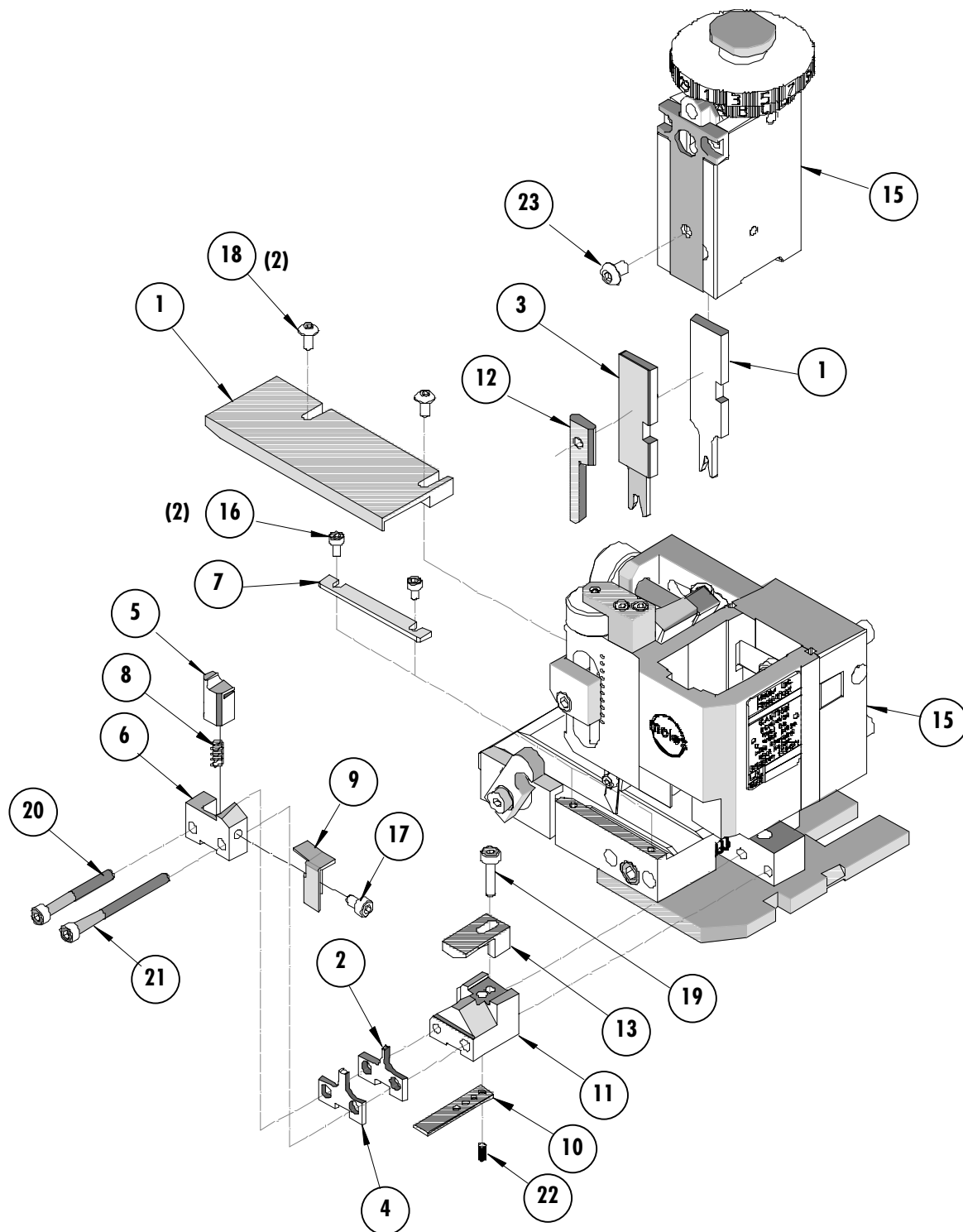


Figure 1

## 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 135.8 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.

### **Molex Application Tooling Group**

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