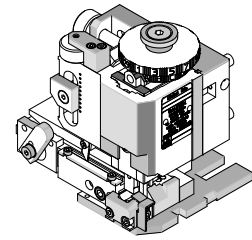




**FineAdjust
Applicator**

**Application Tooling
Specification Sheet**



Order No. 63868-1000

FEATURES

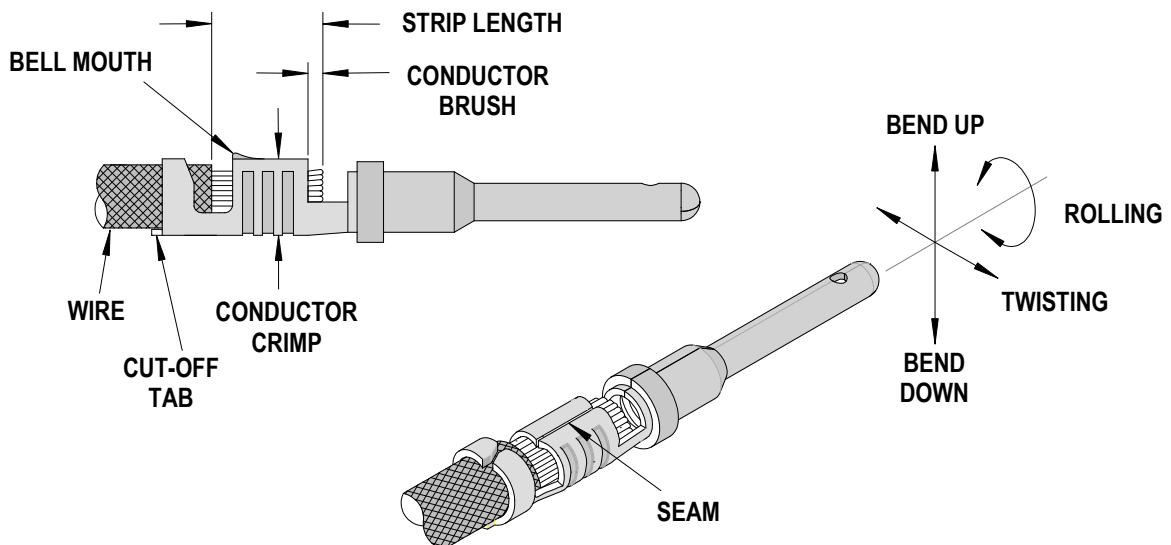
- Quick punch removal with the push of a button for fast and easy tooling change
- Applicator designed to industry standard mounting and shut height 135.80mm (5.346")
- Quick set-up time; plus the crimp height, track and feed adjustments can be set without removing the applicator from the press
- Fine 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: Contact Pin and Contact Socket (Hooded) 16-18 AWG – See 63868-1100 for different insulation diameters out of this range.

| Terminal Series No. | Terminal Order No. | | | | Wire Size | | Insulation Diameter | | Strip Length | |
|---------------------|--------------------|------------|------------|------------|-----------|-----------------|---------------------|-----------|--------------|-----------|
| | | | | | AWG | mm ² | mm | In. | mm | In. |
| 84524 | 84524-0004 | 84524-0014 | | | 16-18 | 1.31-0.82 | 1.40-1.79 | .055-.070 | 3.81-5.08 | .150-.200 |
| 84525 | 84525-0009 | 84525-0032 | | | 16-18 | 1.31-0.82 | 1.40-1.79 | .055-.070 | 3.81-5.08 | .150-.200 |
| 84590 | 84590-0020 | 84590-0025 | 84590-0026 | 84590-0031 | 16-18 | 1.31-0.82 | 1.40-1.79 | .055-.070 | 3.81-5.08 | .150-.200 |

DEFINITION OF TERMS



CRIMP SPECIFICATION

| Terminal Series No. | Bell mouth | | Cut-off Tab Max. | | Conductor Brush | |
|---------------------|------------|-----------|------------------|------|-----------------|-----------|
| | mm | In. | mm | In. | mm | In. |
| 84524 | 0.30-0.60 | .012-.024 | 0.50 | .020 | 0.30-0.80 | .012-.032 |
| 84525 | 0.30-0.60 | .012-.024 | 0.50 | .020 | 0.30-0.80 | .012-.032 |
| 84590 | 0.30-0.60 | .012-.024 | 0.50 | .020 | 0.30-0.80 | .012-.032 |

| Terminal Series No. | Bend up | Bend down | Twist | Roll | Punch Width (Ref) | | | | Seam Seam shall not be open and no wire allowed out of the crimping area |
|---------------------|---------|-----------|--------|------|-------------------|------|------------|------|---|
| | | | | | Conductor | | Insulation | | |
| | Degree | | Degree | | mm | In | mm | In | |
| 84524 | 3 ° | 3 ° | 4 ° | 8 ° | 2.30 | .090 | 2.20 | .087 | |
| 84525 | 3 ° | 3 ° | 4 ° | 8 ° | 2.30 | .090 | 2.20 | .087 | |
| 84590 | 3 ° | 3 ° | 4 ° | 8 ° | 2.30 | .090 | 2.20 | .087 | |

After crimping, the crimp profiles should measure the following:

| Terminal Series No. | Wire Size | | Conductor | | | | Pull Force Minimum | |
|---------------------|-----------|-----------------|--------------|-----------|-------------------|-----------|--------------------|-----|
| | | | Crimp Height | | Crimp Width (Ref) | | | |
| | AWG | mm ² | mm | In. | mm | In. | N | Lb. |
| 84524 | 16 | 1.31 | 1.46-1.54 | .057-.060 | 2.30-2.50 | .090-.098 | 111.3 | 25 |
| | 18 | 0.82 | 1.26-1.34 | .050-.053 | 2.30-2.50 | .090-.098 | 111.3 | 25 |
| 84525 | 16 | 1.31 | 1.46-1.54 | .057-.060 | 2.30-2.50 | .090-.098 | 111.3 | 25 |
| | 18 | 0.82 | 1.26-1.34 | .050-.053 | 2.30-2.50 | .090-.098 | 111.3 | 25 |
| 84590 | 16 | 1.31 | 1.46-1.54 | .057-.060 | 2.30-2.50 | .090-.098 | 111.3 | 25 |
| | 18 | 0.82 | 1.26-1.34 | .050-.053 | 2.30-2.50 | .090-.098 | 111.3 | 25 |

Tool Qualification Notes:

1. This Applicator was qualified to the above specifications with UL 1061 wire.
2. Pull Force should be measured with no influence from the insulation crimp.
3. The above specifications are guidelines to an optimum crimp.

PARTS LIST

| FineAdjust Applicator 63868-1000 | | | | |
|--|-----------------|------------------------|---------------------------|-----------------|
| Item | Order No | Engineering No. | Description | Quantity |
| Perishable Tooling | | | | |
| | 63868-1070 | 63868-1070 | Tool Kit (All "Y" Items) | REF |
| 1 | 63457-0028 | 63457-0028 | Conductor Punch | 1 Y |
| 2 | 63445-2319 | 63445-2319 | Conductor Anvil | 1 Y |
| 3 | 63454-0039 | 63454-0039 | Insulation Punch | 1 Y |
| 4 | 63445-2236 | 63445-2236 | Insulation Anvil | 1 Y |
| 5 | 63443-0037 | 63443-0037 | Cut-Off Plunger Front | 1 Y |
| 6 | 63443-0038 | 63443-0038 | Plunger Retainer Front | 1 Y |
| Other Components | | | | |
| 7 | 11-17-0022 | 1739-21 | Compression Spring | 1 |
| 8 | 11-18-4083 | 60707-8 | Front Cover | 1 |
| 9 | 11-18-4456 | 60739A109 | Wire Hold Down Spring | 1 |
| 10 | 11-24-1149 | 4996-37 | Shank | 1 |
| 11 | 63443-0009 | 63443-0009 | Scrap Chute Front | 1 |
| 12 | 63443-0021 | 63443-0021 | Lower Tooling Key | 1 |
| 13 | 63443-0061 | 63443-0061 | Wire Stop | 1 |
| 14 | 63443-2801 | 63443-2801 | Plunger Striker Front | 1 |
| 15 | 63443-1168 | 63443-1168 | Blade-Wire Hold Down | 1 |
| 16 | 63443-1169 | 63443-1169 | Terminal Hold Down | 1 |
| 17 | 63443-2518 | 63443-2518 | Anvil Mount | 1 |
| 18 | 63443-2912 | 63443-2912 | Wire Hold-Down Plunger | 1 |
| 19 | 63443-6121 | 63443-6121 | Rear Cover | 1 |
| 20 | 63600-0021 | 63600-0021 | Spring-Compression | 1 |
| 21 | 63600-2673 | 63600-2673 | Mini Rod | 1 |
| 22 | 63700-0539 | 63700-0539 | Cut-off Plunger Spring | 1 |
| Frame | | | | |
| 23 | 63800-4901 | 63800-4901 | Top | 1 |
| 24 | 63801-3281 | 63801-3281 | Base | 1 |
| 25 | 63801-4650 | 63801-4650 | Track | 1 |
| Hardware | | | | |
| 26 | N/A | N/A | M3 by 6 Long SHCS | 2** |
| 27 | N/A | N/A | M4 by 6 Long SHCS | 1** |
| 28 | N/A | N/A | M4 by 12 Long BHCS | 2** |
| 29 | N/A | N/A | M4 by 50 Long SHCS | 2** |
| 30 | N/A | N/A | M5 by 12 Long SHCS | 1** |
| 31 | N/A | N/A | 2mm by 5 Long Roll Pin | 1** |
| 32 | N/A | N/A | 3mm by 6 Long Roll Pin | 1** |
| 33 | N/A | N/A | #5-40 by 3/8" Long SHCS | 1** |
| 34 | N/A | N/A | #10-32 by 5/32" Long BHCS | 1** |
| ** Available from an industrial supply company such as MSC (1-800-645-7270). | | | | |

Assembly Drawing

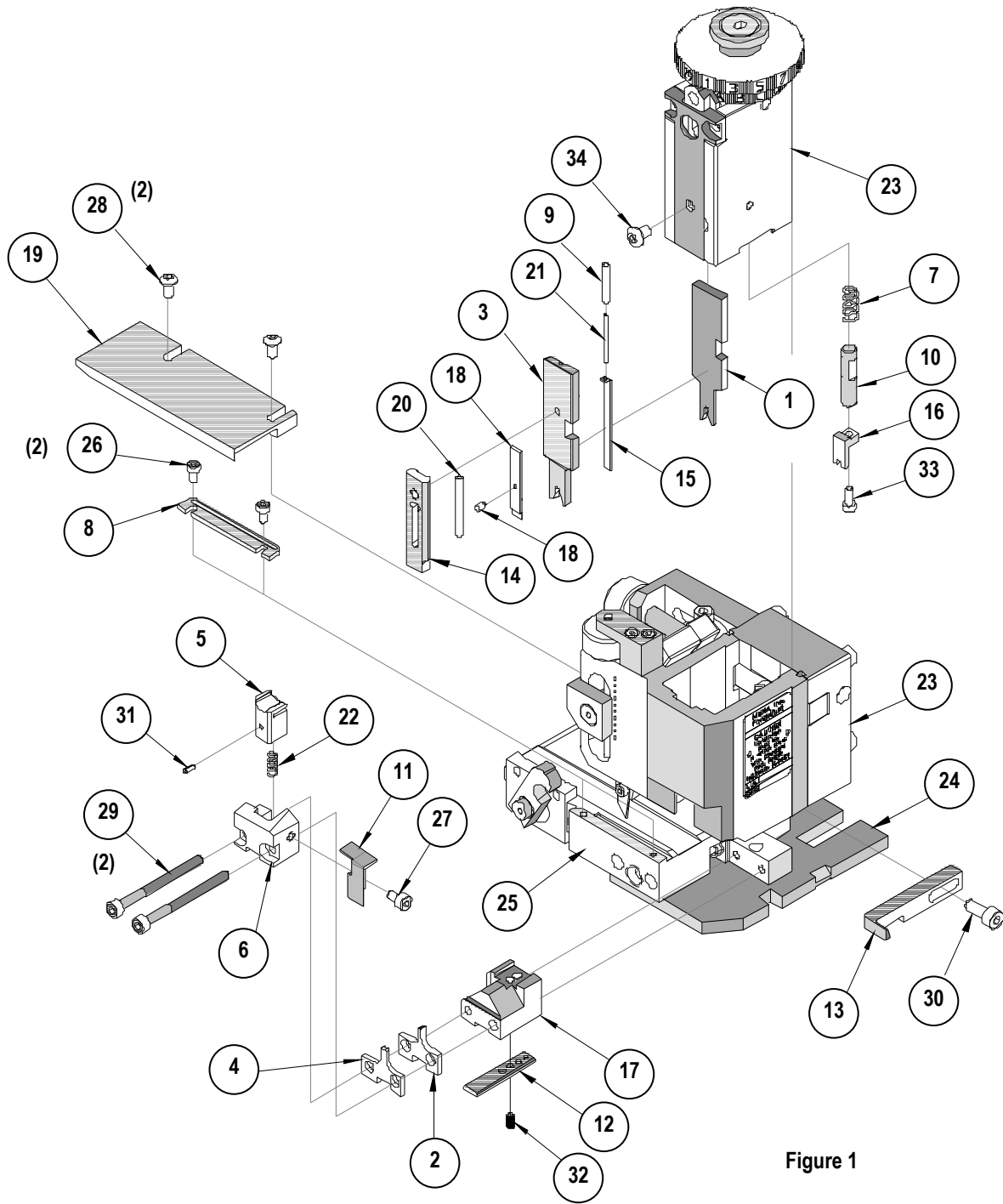


Figure 1

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 135.80 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.

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