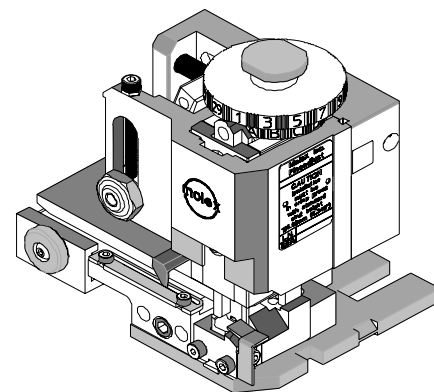




FineAdjust Applicator Specification Sheet Part No. 63864-3000



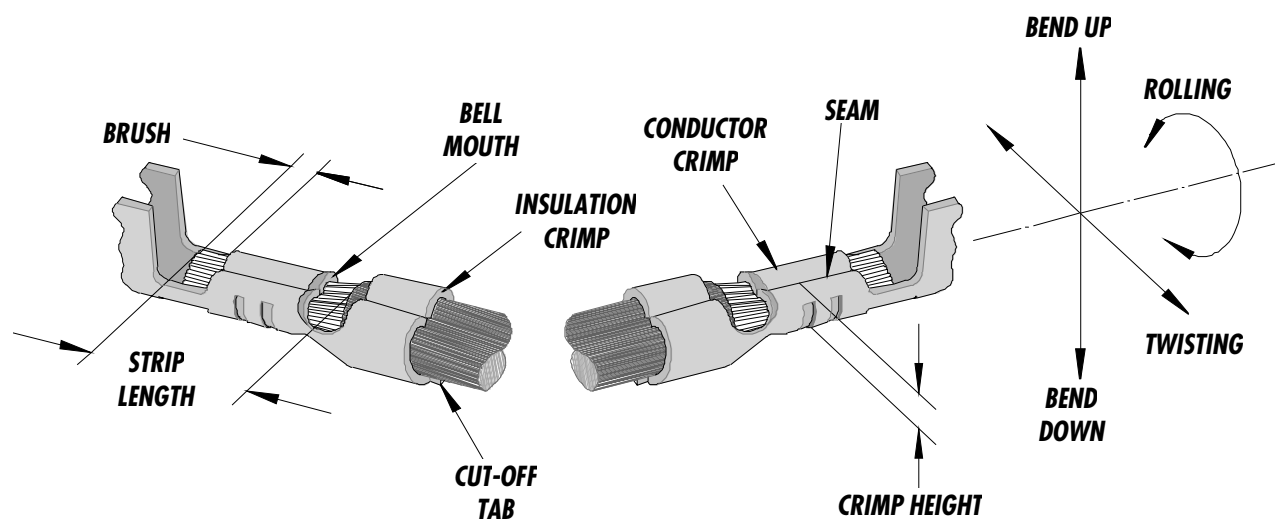
FEATURES

- 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

SCOPE

Terminal Series No.	Wire Size		Insulation Diameter		Strip Length	
	AWG	mm ²	mm	In.	mm	In.
50212-8*00	24-30	0.20-0.05	0.80-1.40	.031-.055	1.30-1.80	.051-.071
50394-8***	24-30	0.20-0.05	0.80-1.40	.031-.055	1.30-1.80	.051-.071

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.
50212-8*00	0.05-0.35	.002-.014	0.20	.008	0.00-0.50	.000-.020
50394-8***	0.05-0.35	.002-.014	0.20	.008	0.00-0.50	.000-.020

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
	Degree		Degree		Conductor		Insulation		
					mm	In	mm	In	
50212-8*00	4	3	3	4	1.00	.039	1.40	.055	
50394-8***	4	3	3	4	1.00	.039	1.40	.055	

After crimping, the conductor profile should measure the following.

Terminal Series No.	Wire Size		Crimp Height		Pull Force Min.	
	AWG	mm ²	mm	In.	N	Lb.
50212-8*00	24	0.20	0.60-0.65	.024-.026	29.3	6.60
50212-8*00	26	0.12	0.59-0.64	.023-.025	19.6	4.40
50212-8*00	28	0.08	0.56-0.61	.022-.024	9.8	2.20
50212-8*00	30	0.05	0.53-0.58	.021-.023	4.9	1.10
50394-8***	24	0.20	0.60-0.65	.024-.026	29.3	6.60
50394-8***	26	0.12	0.59-0.64	.023-.025	19.6	4.40
50394-8***	28	0.08	0.56-0.61	.022-.024	9.8	2.20
50394-8***	30	0.05	0.53-0.58	.021-.023	4.9	1.10

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

The above specifications are guidelines to an optimum crimp.

PARTS LIST

Item	Order No	Engineering No.	Description	Quantity
	63864-3000	63864-3000	FineAdjust Applicator (Fig. 1)	REF
1	63444-1003	63444-1003	Conductor Punch	1 Y
2	63445-1013	63445-1013	Conductor Anvil	1 Y
3	63446-1430	63446-1430	Insulation Punch	1 Y
4	63445-1405	63445-1405	Insulation Anvil	1 Y
5	63443-0003	63443-0003	Cut-Off Plunger	1 Y
6	63443-0012	63443-0012	Front Plunger Retainer	1 Y
7	11-18-4083	60707-8	Front Cover	1
8	11-24-1067	4996-4	Cut-off Plunger Spring	1
9	11-40-4039	8302-5	Front Plunger Striker	1
10	63443-0009	63443-0009	Scrape Chute	1
11	63443-0021	63443-0021	Lower Tooling Key	1
12	63443-2421	63443-2421	Anvil Mount	1
13	63443-4025	63443-4025	Wire Stop	1
14	63443-6003	63443-6003	Rear Cover	1
15	63800-4900	63800-4900	Fine Adjust Applicator Frame	1
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**
	63864-3070	63864-3070	Tool Kit (All Y Items)	REF

**** The following purchased parts are 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.

**Molex Application Tooling Group
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Visit our Web site at <http://www.molex.com>

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