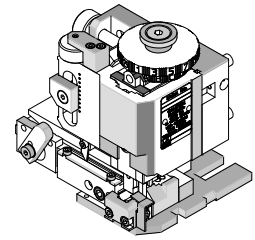




**FineAdjust
Applicator**

**Application Tooling
Specification Sheet**



Order No. 63900-1400

FEATURES

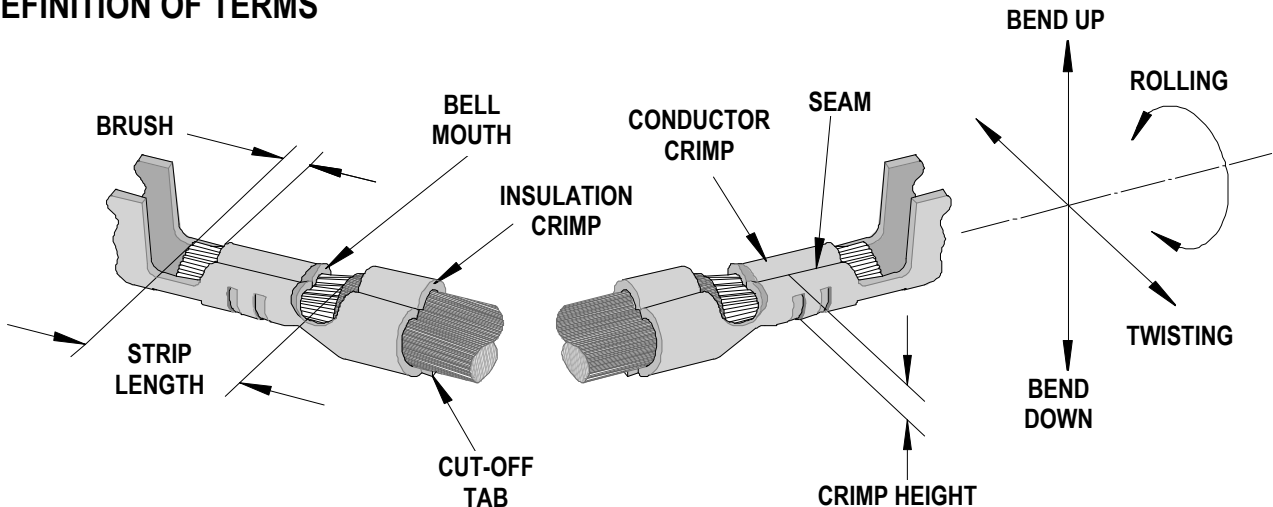
- Quick punch removal with the push of a button for fast and easy tooling change
- Applicator designed to industry standard mounting and shut height 135.80mm (5.346")
- Quick set-up time; plus the crimp height, track and feed adjustments can be set without removing the applicator from the press
- Fine 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: Low Force Micro-Fit 3.0™ Crimp Terminal 20-24 AWG.

Terminal Series No.	Terminal Order No.		Wire Size		Insulation Diameter		Strip Length	
			AWG	mm ²	mm	In.	mm	In.
46235	46235-0001	46235-0002	20-24	0.50-0.20	1.30-1.85	.051-.073	2.54-2.92	.100-.115
	46235-5001	46235-5002						

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.
46235	0.05-0.40	.002-.016	0.25	.010	0.20-0.80	.008-.031

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.	
46235	3	3	4	8	1.20	.047	1.90	.075	

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.
46235	20	0.50	0.76-0.81	.030-.032	1.25	.049	57.9	13.0
	22	0.35	0.71-0.76	.028-.030	1.25	.049	35.6	8.0
	24	0.20	0.66-0.71	.026-.028	1.25	.049	22.3	5.0

*** 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

FineAdjust Applicator 63900-1400				
Item	Order No	Engineering No.	Description	Quantity
Perishable Tooling				
	63900-1470	63900-1470	Tool Kit (All "Y" Items)	REF
1	63457-0037	63457-0037	Conductor Punch	1 Y
2	63455-0051	63455-0051	Conductor Anvil	1 Y
3	63446-1902	63446-1902	Insulation Punch	1 Y
4	63445-1910	63445-1910	Insulation Anvil	1 Y
5	63443-0002	63443-0002	Cut-Off Plunger Front	1 Y
6	63443-0012	63443-0012	Plunger Retainer Front	1 Y
Other Components				
7	11-18-4083	60707-8	Feed Guide	1
8	11-24-1067	4996-4	Cut-Off Plunger Spring	1
9	11-40-4039	8302-5	Plunger Striker	1
10	63443-0009	63443-0009	Front Scrap Chute	1
11	63443-0025	63443-0025	Key	1
12	63443-0090	63443-0090	Wire Stop	1
13	63443-1717	63443-1717	Height Spacer	1
14	63443-2216	63443-2216	Coarse Spacer (16.00mm)	1
15	63443-2302	63443-2302	Fine Spacer (3.10mm)	1
16	63443-6109	63443-6109	Rear Cover	1
Frame				
17	63800-4901	63800-4901	Top	1
18	63801-3281	63801-3281	Base	1
19	63801-4650	63801-4650	Track	1
Hardware				
20	N/A	N/A	M3 by 6 Long SHCS	2**
21	N/A	N/A	M3 by 6 Long FHCS	1**
22	N/A	N/A	M4 by 6 Long SHCS	2**
23	N/A	N/A	M4 by 12 Long BHCS	2**
24	N/A	N/A	M4 by 50 Long SHCS	2**
25	N/A	N/A	M5 by 12 Lg SHCS	1**
26	N/A	N/A	#10-32 by 3/8" Long Flat Point SSS	1**
27	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

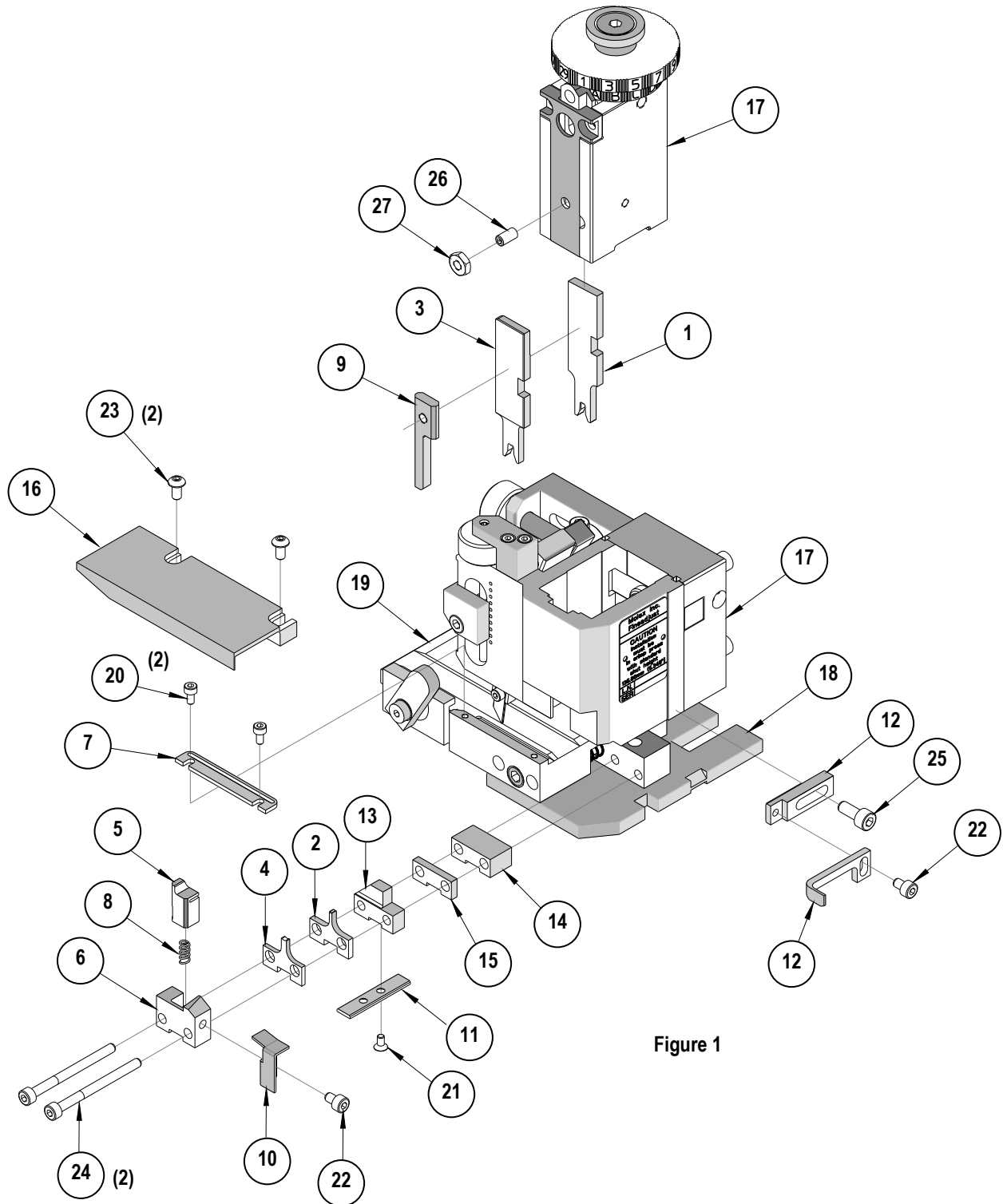


Figure 1

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 135.80 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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