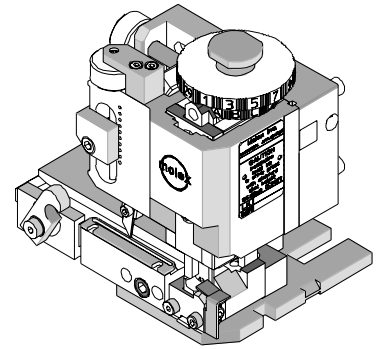




## FineAdjust Applicator Specification Sheet Part No. 63860-1400



### FEATURES

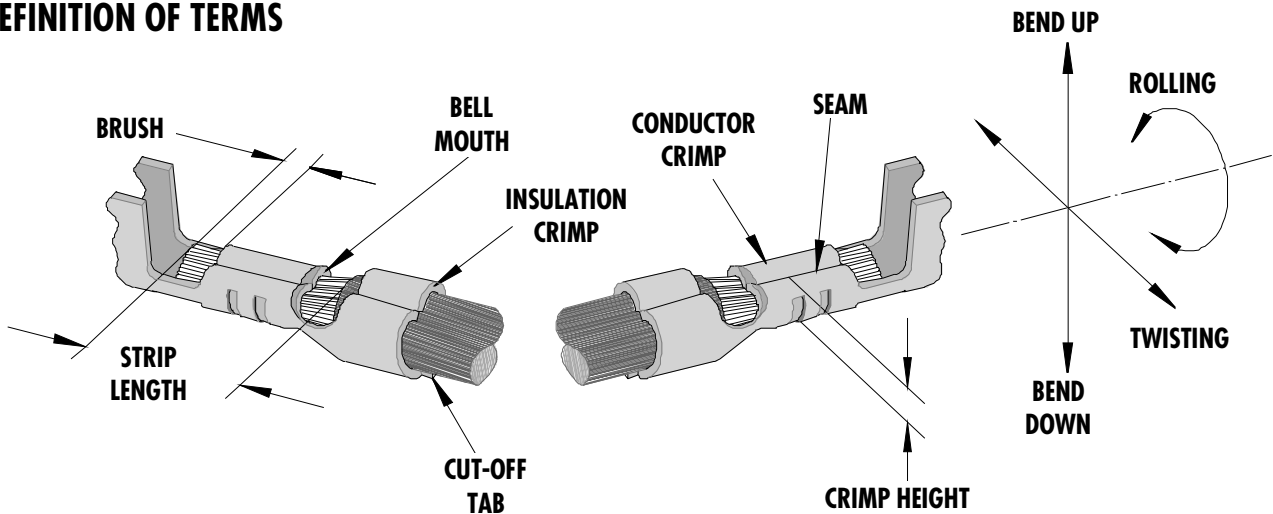
- Quick punch removal with the push of a button for fast and easy tooling change
- Applicator designed to industry standard mounting and shut height 135.80mm (5.346")
- Quick set-up time; plus the crimp height, track and feed adjustments can be set without removing the applicator from the press
- Fine adjustment allows users to achieve target with little effort by adjusting in increments of 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

Products: Mini-Fit Jr.™ Crimp Terminal 18-24 AWG with smaller insulation OD's.

| Terminal Series No.  | Terminal Order No. |            |            |            | Wire Size |                 | Insulation Diameter |           | Strip Length |           |
|--|--------------------|------------|------------|------------|-----------|-----------------|---------------------|-----------|--------------|-----------|
|  |                    |            |            |            | AWG       | mm <sup>2</sup> | mm                  | In.       | mm           | In.       |
| 5556   | 39-00-0038         | 39-00-0153 | 39-00-0200 | 39-00-0419 | 18-24     | 0.80-0.20       | 1.30-2.15           | .051-.085 | 3.00-3.50    | .118-.138 |
|  | 39-00-0055         | 39-00-0163 | 39-00-0207 | 39-00-0425 |           |                 |                     |           |              |           |
|  | 39-00-0059         | 39-00-0169 | 39-00-0213 | 39-00-0428 |           |                 |                     |           |              |           |
|  | 39-00-0073         | 39-00-0175 | 39-00-0405 | 39-00-0436 |           |                 |                     |           |              |           |
|  | 39-00-0108         | 39-00-0181 | 39-00-0407 | 39-00-0440 |           |                 |                     |           |              |           |
|  | 39-00-0114         | 39-00-0194 | 39-00-0410 | 40-13-0851 |           |                 |                     |           |              |           |
| 5558   | 39-00-0040         | 39-00-0120 | 39-00-0420 | 39-00-0437 | 18-24     | 0.80-0.20       | 1.30-2.15           | .051-.085 | 3.00-3.50    | .118-.138 |
|  | 39-00-0053         | 39-00-0126 | 39-00-0426 | 40-01-0853 |           |                 |                     |           |              |           |
|  | 39-00-0061         | 39-00-0219 | 39-00-0427 | 40-13-0853 |           |                 |                     |           |              |           |
|  | 39-00-0075         | 39-00-0411 | 39-00-0430 | 98-00-0174 |           |                 |                     |           |              |           |
| 30490  | 30490-0002         | 30490-1002 | 30490-2002 |            | 18-24     | 0.80-0.20       | 1.30-2.15           | .051-.085 | 3.00-3.50    | .118-.138 |
| 44476  | 44476-1111         | 44476-1211 |            |            | 18-20     | 0.80-0.50       | 1.30-2.15           | .051-.085 | 3.00-3.50    | .118-.138 |
| 44478  | 44478-1111         | 44478-1211 |            |            | 18-20     | 0.80-0.50       | 1.30-2.15           | .051-.085 | 3.00-3.50    | .118-.138 |
| 44485  | 44485-1211         | 44485-1311 | 44485-1411 |            | 18-24     | 0.80-0.20       | 1.30-2.15           | .051-.085 | 3.00-3.50    | .118-.138 |
| 45750  | 45750-1111         | 45750-1211 |            |            | 18-20     | 0.80-0.50       | 1.65-2.05           | .065-.081 | 3.00-3.50    | .118-.138 |
| 46012  | 46012-1111         | 46012-1211 |            |            | 18-20     | 0.80-0.50       | 1.65-2.05           | .065-.081 | 3.00-3.50    | .118-.138 |
| 46018  | 46018-1541         |            |            |            | 18-20     | 0.80-0.50       | 1.65-2.05           | .065-.081 | 3.00-3.50    | .118-.138 |
| 46083  | 46083-1111         | 46083-1121 | 46083-1211 | 46083-1221 | 18-20     | 0.80-0.50       | 1.65-2.05           | .065-.081 | 3.00-3.50    | .118-.138 |
| 46098  | 46098-1541         |            |            |            | 18-20     | 0.80-0.50       | 1.65-2.05           | .065-.081 | 3.00-3.50    | .118-.138 |
| <p>⚠ This Applicator will crimp the above terminals and wires.<br/>However it provides optimum A-620 Class 2 crimps for 18-20 AWG wire<br/>with insulation OD 1.65-2.05mm (example UL1007).<br/>Applicator 63860-1000 should be used for insulation OD 2.05-2.95mm (example UL1015).</p> |                    |            |            |            |           |                 |                     |           |              |           |

### 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.       |
| 5556                | 0.20-0.50  | .008-.020 | 0.30             | .012 | 0.00-1.00       | .000-.039 |
| 5558                | 0.20-0.50  | .008-.020 | 0.30             | .012 | 0.00-1.00       | .000-.039 |
| 30490               | 0.20-0.50  | .008-.020 | 0.30             | .012 | 0.00-1.00       | .000-.039 |
| 44476               | 0.20-0.50  | .008-.020 | 0.30             | .012 | 0.00-1.00       | .000-.039 |
| 44478               | 0.20-0.50  | .008-.020 | 0.30             | .012 | 0.00-1.00       | .000-.039 |
| 44485               | 0.20-0.50  | .008-.020 | 0.30             | .012 | 0.00-1.00       | .000-.039 |
| 45750               | 0.20-0.50  | .008-.020 | 0.30             | .012 | 0.00-1.00       | .000-.039 |
| 46012               | 0.20-0.50  | .008-.020 | 0.30             | .012 | 0.00-1.00       | .000-.039 |
| 46018               | 0.20-0.50  | .008-.020 | 0.30             | .012 | 0.00-1.00       | .000-.039 |
| 46083               | 0.20-0.50  | .008-.020 | 0.30             | .012 | 0.00-1.00       | .000-.039 |
| 46098               | 0.20-0.50  | .008-.020 | 0.30             | .012 | 0.00-1.00       | .000-.039 |

| Terminal Series No. | Bend up | Bend down | Twist  | Roll | Punch Width (Ref) |      |            |      | Seam<br>Seam shall not be open<br>And no wire allowed out<br>of the crimping area |
|---------------------|---------|-----------|--------|------|-------------------|------|------------|------|---|
|                     |         |           |        |      | Conductor         |      | Insulation |      |   |
|                     | Degree  |           | Degree |      | mm                | In.  | mm         | In.  |   |
| 5556                | 5       | 2         | 5      | 15   | 1.60              | .063 | 2.00       | .079 |   |
| 5558                | 5       | 2         | 5      | 15   | 1.60              | .063 | 2.00       | .079 |   |
| 30490               | 5       | 2         | 5      | 15   | 1.60              | .063 | 2.00       | .079 |   |
| 44476               | 5       | 2         | 5      | 15   | 1.60              | .063 | 2.00       | .079 |   |
| 44478               | 5       | 2         | 5      | 15   | 1.60              | .063 | 2.00       | .079 |   |
| 44485               | 5       | 2         | 5      | 15   | 1.60              | .063 | 2.00       | .079 |   |
| 45750               | 5       | 2         | 5      | 15   | 1.60              | .063 | 2.00       | .079 |   |
| 46012               | 5       | 2         | 5      | 15   | 1.60              | .063 | 2.00       | .079 |   |
| 46018               | 5       | 2         | 5      | 15   | 1.60              | .063 | 2.00       | .079 |   |
| 46083               | 5       | 2         | 5      | 15   | 1.60              | .063 | 2.00       | .079 |   |
| 46098               | 5       | 2         | 5      | 15   | 1.60              | .063 | 2.00       | .079 |   |

After crimping, the crimp profiles should measure the following:

| Terminal Series No. | Wire Size |                 | Conductor    |           |                   |      | Pull Force Min. |      |
|---------------------|-----------|-----------------|--------------|-----------|-------------------|------|-----------------|------|
|                     |           |                 | Crimp Height |           | Crimp Width (Ref) |      |                 |      |
|                     | AWG       | mm <sup>2</sup> | mm           | In.       | mm                | In.  | N               | Lb.  |
| 5556                | 18        | 0.80            | 0.97-1.07    | .038-.042 | 1.68              | .066 | 88.0            | 19.8 |
| 5556                | 20        | 0.50            | 0.95-1.04    | .037-.041 | 1.66              | .065 | 58.7            | 13.2 |
| 5556                | 22        | 0.35            | 0.85-0.94    | .033-.037 | 1.65              | .065 | 39.1            | 8.8  |
| 5556                | 24        | 0.20            | 0.79-0.87    | .031-.034 | 1.63              | .064 | 29.3            | 6.6  |
| 5558                | 18        | 0.80            | 0.97-1.07    | .038-.042 | 1.68              | .066 | 88.0            | 19.8 |
| 5558                | 20        | 0.50            | 0.95-1.04    | .037-.041 | 1.66              | .065 | 58.7            | 13.2 |
| 5558                | 22        | 0.35            | 0.85-0.94    | .033-.037 | 1.65              | .065 | 39.1            | 8.8  |
| 5558                | 24        | 0.20            | 0.79-0.87    | .031-.034 | 1.63              | .064 | 29.3            | 6.6  |
| 30490               | 18        | 0.80            | 0.97-1.07    | .038-.042 | 1.68              | .066 | 88.0            | 19.8 |
| 30490               | 20        | 0.50            | 0.95-1.04    | .037-.041 | 1.66              | .065 | 58.7            | 13.2 |
| 30490               | 22        | 0.35            | 0.85-0.94    | .033-.037 | 1.65              | .065 | 39.1            | 8.8  |
| 30490               | 24        | 0.20            | 0.79-0.87    | .031-.034 | 1.63              | .064 | 29.3            | 6.6  |
| 44476               | 18        | 0.80            | 0.97-1.07    | .038-.042 | 1.68              | .066 | 68.4            | 15.4 |
| 44476               | 20        | 0.50            | 0.95-1.04    | .037-.041 | 1.66              | .065 | 58.7            | 13.2 |
| 44478               | 18        | 0.80            | 0.97-1.07    | .038-.042 | 1.68              | .066 | 68.4            | 15.4 |
| 44478               | 20        | 0.50            | 0.95-1.04    | .037-.041 | 1.66              | .065 | 58.7            | 13.2 |
| 44485               | 18        | 0.80            | 0.97-1.07    | .038-.042 | 1.68              | .066 | 88.0            | 19.8 |
| 44485               | 20        | 0.50            | 0.95-1.04    | .037-.041 | 1.66              | .065 | 58.7            | 13.2 |
| 44485               | 22        | 0.35            | 0.85-0.94    | .033-.037 | 1.65              | .065 | 39.1            | 8.8  |
| 44485               | 24        | 0.20            | 0.79-0.87    | .031-.034 | 1.63              | .064 | 29.3            | 6.6  |
| 45750               | 18        | 0.80            | 0.97-1.07    | .038-.042 | 1.68              | .066 | 68.4            | 15.4 |
| 45750               | 20        | 0.50            | 0.84-0.94    | .033-.037 | 1.66              | .065 | 58.7            | 13.2 |
| 46012               | 18        | 0.80            | 0.97-1.07    | .038-.042 | 1.68              | .066 | 68.4            | 15.4 |
| 46012               | 20        | 0.50            | 0.84-0.94    | .033-.037 | 1.66              | .065 | 58.7            | 13.2 |
| 46018               | 18        | 0.80            | 0.97-1.07    | .038-.042 | 1.68              | .066 | 68.4            | 15.4 |
| 46018               | 20        | 0.50            | 0.84-0.94    | .033-.037 | 1.66              | .065 | 58.7            | 13.2 |
| 46083               | 18        | 0.80            | 0.97-1.07    | .038-.042 | 1.68              | .066 | 68.4            | 15.4 |
| 46083               | 20        | 0.50            | 0.84-0.94    | .033-.037 | 1.66              | .065 | 58.7            | 13.2 |
| 46098               | 18        | 0.80            | 0.97-1.07    | .038-.042 | 1.68              | .066 | 68.4            | 15.4 |
| 46098               | 20        | 0.50            | 0.84-0.94    | .033-.037 | 1.66              | .065 | 58.7            | 13.2 |

**🔧 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 63860-1400</b>                                      |                 |                        |                          |                 |
|--|-----------------|------------------------|--------------------------|-----------------|
| <b>Item</b>  | <b>Order No</b> | <b>Engineering No.</b> | <b>Description</b>       | <b>Quantity</b> |
| <b>Perishable Tooling</b>  |                 |                        |                          |                 |
|  | 63860-1470      | 63860-1470             | Tool Kit (All "Y" Items) | REF             |
| 1  | 63444-1609      | 63444-1609             | Conductor Punch          | 1 Y             |
| 2  | 63445-1646      | 63445-1646             | Conductor Anvil          | 1 Y             |
| 3  | 63446-2001      | 63446-2001             | Insulation Punch         | 1 Y             |
| 4  | 63445-2005      | 63445-2005             | 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             |
| <b>Other Components</b>  |                 |                        |                          |                 |
| 7  | 11-24-1067      | 4996-4                 | Cut-off Plunger Spring   | 1               |
| 8  | 11-40-4039      | 8302-5                 | Plunger Striker Front    | 1               |
| 9  | 63443-0021      | 63443-0021             | Lower Tooling Key        | 1               |
| 10   | 63443-6003      | 63443-6003             | Rear Cover               | 1               |
| 11   | 11-18-4083      | 60707-8                | Front Cover              | 1               |
| 12   | 63443-2408      | 63443-2408             | Anvil Mount              | 1               |
| 13   | 63443-4018      | 63443-4018             | Wire Stop                | 1               |
| 14   | 63443-0009      | 63443-0009             | Scrap Chute Front        | 1               |
| <b>Frame</b>   |                 |                        |                          |                 |
| 15   | 63800-4901      | 63800-4901             | Top                      | 1               |
| 16   | 63801-3281      | 63801-3281             | Base                     | 1               |
| 17   | 63801-4650      | 63801-4650             | Track                    | 1               |
| <b>Hardware</b>  |                 |                        |                          |                 |
| 18   | N/A             | N/A                    | M3 by 6Lg. SHCS          | 2**             |
| 19   | N/A             | N/A                    | M4 by 6Lg. SHCS          | 1**             |
| 20   | N/A             | N/A                    | M4 by 12Lg. BHCS         | 2**             |
| 21   | N/A             | N/A                    | M4 by 16Lg SHCS          | 1**             |
| 22   | N/A             | N/A                    | M4 by 20Lg. SHCS         | 1**             |
| 23   | N/A             | N/A                    | M4 by 50Lg. SHCS         | 1**             |
| 24   | N/A             | N/A                    | 3MM by 6Lg. Roll Pin     | 1**             |
| 25   | 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

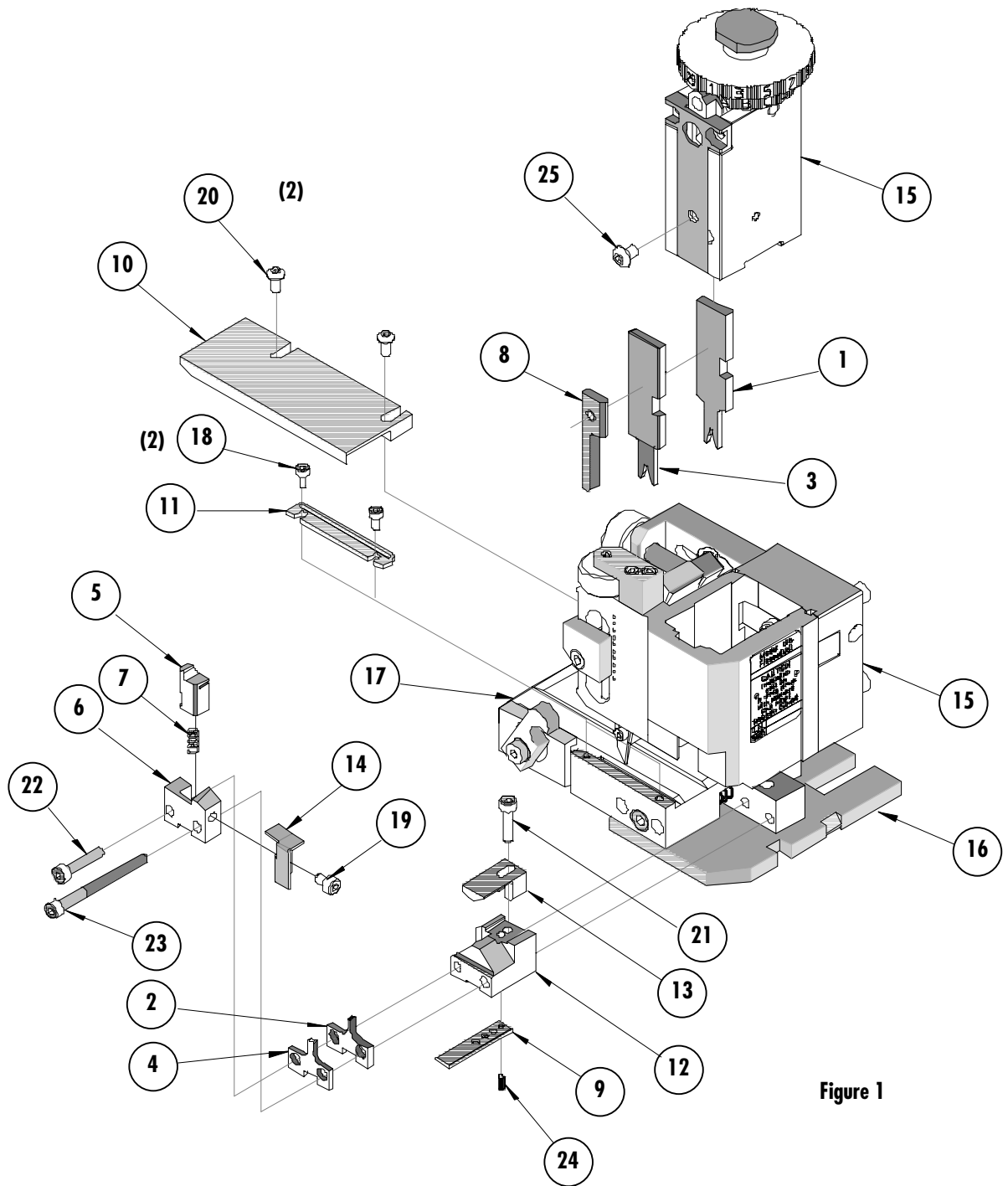


Figure 1

## 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 135.80 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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