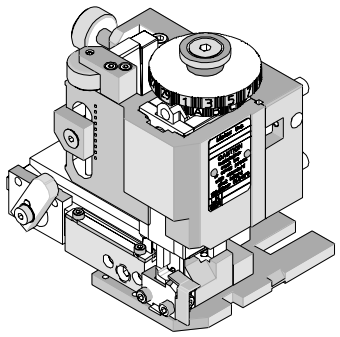
FineAdjust Applicator Specification Sheet Part No. 63864-4100 (Full Radius Insulation Crimp)



FEATURES

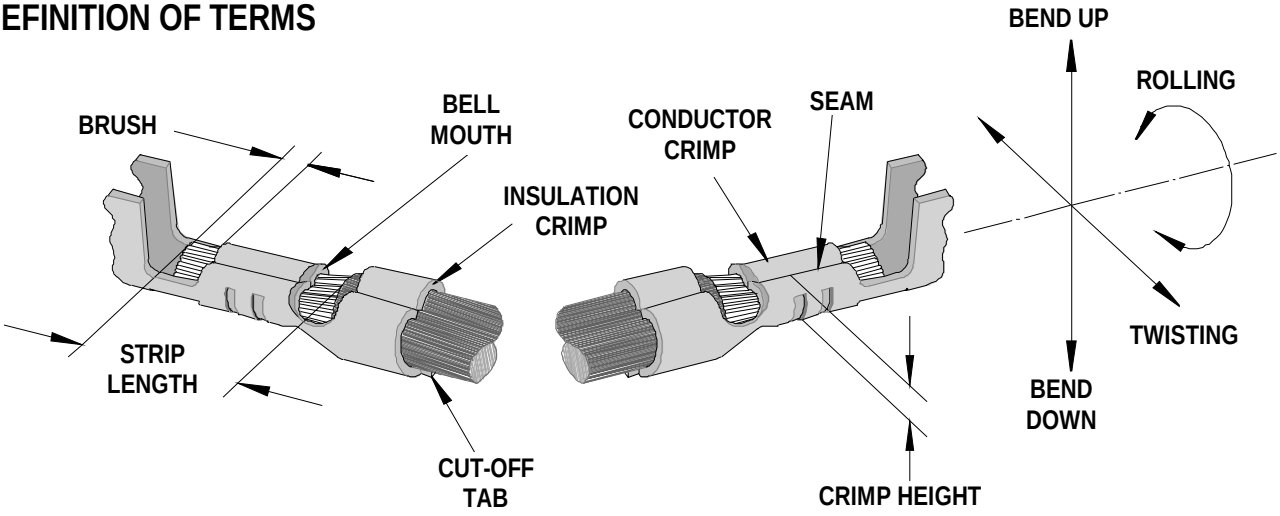
- Quick punch removal with the push of a button for fast and easy tooling change
- Applicator designed to industry standard mounting and shut height 135.80mm (5.346")
- Quick set-up time; plus the crimp height, track and feed adjustments can be set without removing the applicator from the press
- Fine 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
- Also available: 63864-4000 with standard “B” insulation crimp recommended for small and min. insulation diameter, (See Scope)

SCOPE

Products: Standard .093" (2.63mm) Pin and Socket Crimp Terminal

Terminal Series No.	Terminal Order No.	Wire Size		Insulation Diameter		Strip Length	
		AWG	mm²	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 Maximum		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 Degree		Twist Roll Degree		Punch Width mm (Ref) Conductor		Insulation		Seam
					mm	In	mm	In	
42477	3	3	4	8	2.30	.090	3.60	.141	Seam shall not be open and no wire allowed out of the crimping area
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 Minimum	
	AWG	mm^2	mm	In.	N	Lb.
42477	14	2.07	1.91-1.80	.075-.071	222.4	50.00
	16	1.31	1.70-1.60	.067-.063	177.9	40.00
	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
	16	1.31	1.70-1.60	.067-.063	177.9	40.00
	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

FineAdjust Applicator 63864-4100				
Item	**Order No**	**Engineering No.**	**Description**	**Quantity**
Perishable Tooling				
	63864-4170	63864-4170	Tool Kit (All "Y" Items)	REF
1	63444-2323	63444-2323	Conductor Punch	1 Y
2	63445-2348	63445-2348	Conductor Anvil	1 Y
3	63460-3606	63460-3606	Insulation Punch-Full Radius	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
Other Components (644150)				
7	11-18-4083	60707-8	Feed Guide	1
8	11-24-1067	4996-4	Cut-off Plunger Spring	1
9	63443-0009	63443-0009	Front Scrap 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
Frame				
15	63800-4901	63800-4901	Top	1
16	63801-3281	63801-3281	Base	1
17	63801-4650	63801-4650	Track	1
Hardware				
18	N/A	N/A	M3 by 6 Long SHCS	2**
19	N/A	N/A	M4 by 6 Long SHCS	1**
20	N/A	N/A	M4 by 12 Long BHCS	2**
21	N/A	N/A	M4 by 16Lg SHCS	1**
22	N/A	N/A	M4 by 20 Long SHCS	1**
23	N/A	N/A	M4 by 50 Long SHCS	1**
24	N/A	N/A	3MM by 6 Long Roll Pin	1**
25	N/A	N/A	#10-32 by 3/8"Long Flat Point SSS	1**
26	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

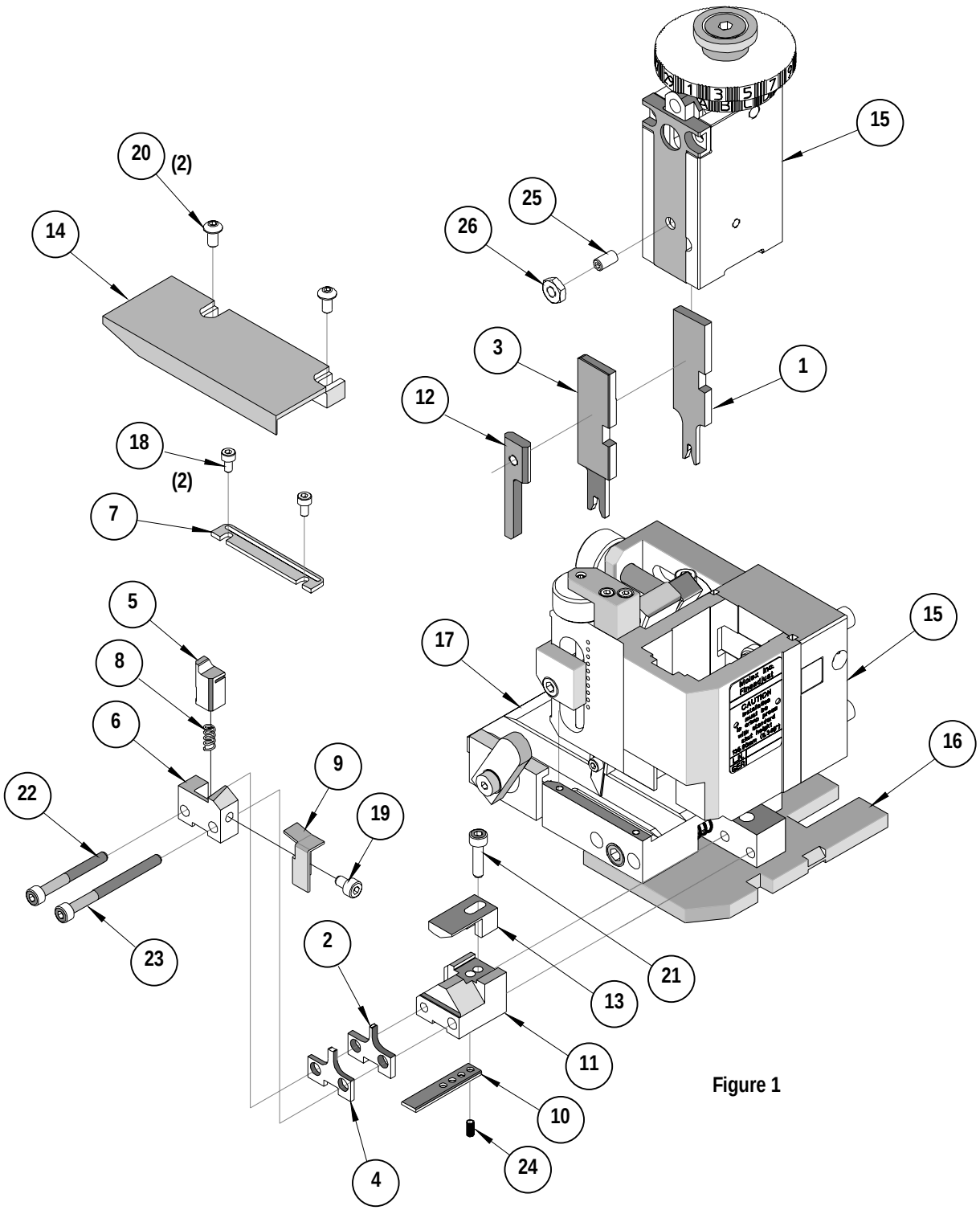


Figure 1

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 135.8 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.

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