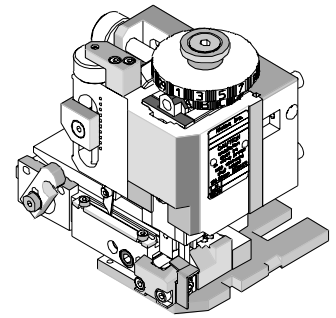




# FineAdjust Applicator Specification Sheet Part No. 63900-2000



## FEATURES

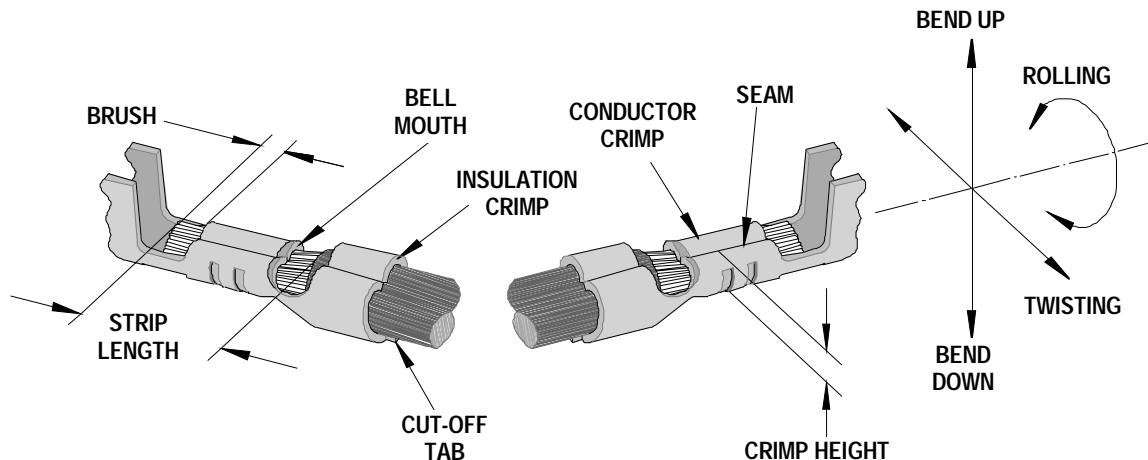
- Directly adapts to most automatic wire processing machines
- Quick punch removal with the push of a button for fast and easy tooling change
- Applicator designed to industry standard mounting and shut height 135.80mm (5.346")
- Quick set-up time; plus the crimp height, track and feed adjustments can 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

## SCOPE

Products: 1.78mm (.070") Tab Female Crimp Terminals, 18-22 AWG.

Terminal Series No.	Terminal Order No.	Wire Size		* Insulation Diameter		Strip Length	
		AWG	mm <sup>2</sup>	mm	In.	mm	In.
35028	35028-9010	18-22	0.80-0.35	2.00-2.90	.079-.114	4.20-5.00	.165-.197
* This Applicator provides optimum A-620 Class 2 crimps with insulation O.D. range of 2.30-2.90 mm.							

## 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.
35028	0.20-0.50	.008-.020	0.20	.008	0.00-1.00	0.00-.039

Terminal Series No.	Bend up	Bend down	Twist	Roll	Punch Width mm (Ref)				Seam  Seam shall not be open and no wire allowed out of the crimping area
					Conductor		Insulation		
	Degree		Degree		mm	In	mm	In	
35028	3	3	3	5	2.10	.083	2.80	.110	

After crimping, the conductor profile should measure the following.

Terminal Series No.	Wire Size		Conductor			
			Crimp Height		Crimp Width (Ref)	
	AWG	mm <sup>2</sup>	mm	In.	mm	In.
35028	18	0.80	1.27-1.37	.050-.054	2.10-2.20	.083-.087
	20	0.50	1.15-1.25	.045-.049	2.10-2.20	.083-.087
	22	0.35	1.07-1.17	.042-.046	2.10-2.20	.083-.087

Terminal Series No.	Wire Size		Insulation (Ref)				Pull Force Minimum	
			Crimp Height Max.		Crimp Width			
	AWG	mm <sup>2</sup>	mm	In.	mm	In.	N	Lb.
35028	18	0.80	3.00	.118	2.85-2.95	.112-.116	88.9	20.0
	20	0.50	2.70	.106	2.85-2.95	.112-.116	57.8	13.0
	22	0.35	2.55	.100	2.85-2.95	.112-.116	35.6	8.0

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

The above specifications are guidelines to an optimum crimp.

**PARTS LIST**

<b>FineAdjust Applicator 63900-2000</b>				
<b>Item</b>	<b>Order No</b>	<b>Engineering No.</b>	<b>Description</b>	<b>Quantity</b>
<b>Perishable Tooling</b>				
	63900-2070	63900-2070	Tool Kit (All "Y" Items)	REF
1	63444-2125	63444-2125	Conductor Punch	1 Y
2	63445-2149	63445-2149	Conductor Anvil	1 Y
3	63454-0065	63454-0065	Insulation Punch	1 Y
4	63445-2841	63445-2841	Insulation Anvil	1 Y
5	63443-0035	63443-0035	Front Cut-Off Plunger	1 Y
6	63443-0036	63443-0036	Front Plunger Retainer	1 Y
<b>Other Components(REF 002050)</b>				
7	11-17-0022	1739-21	Hold Down Spring	1
8	11-18-4083	60707-8	Feed Guide	1
9	11-24-1149	4996-37	Shank	1
10	63443-0009	63443-0009	Front Scrap Chute	1
11	63443-0024	63443-0024	Key	1
12	63443-0090	63443-0090	Wire Stop	1
13	63443-1719	63443-1719	18.9mm Height Spacer	1
14	63443-2214	63443-2214	14.0mm Coarse Spacer	1
15	63443-2317	63443-2317	3.85mm Fine Spacer	1
16	63443-3160	63443-3160	Plunger Striker	1
17	63443-6122	63443-6122	Rear Cover	1
18	63443-7003	63443-7003	Terminal Hold Down	1
19	63700-0539	63700-0539	Cut-Off Plunger Spring	1
<b>Frame</b>				
20	63800-4901	63800-4901	Top	1
21	63801-3281	63801-3281	Base	1
22	63801-4650	63801-4650	Track	1
<b>Hardware</b>				
23	N/A	N/A	M3 by 6 Long SHCS	2**
24	N/A	N/A	M3 by 6 Long FHCS	1**
25	N/A	N/A	M4 by 6 Long SHCS	2**
26	N/A	N/A	M4 by 12 Long BHCS	2**
27	N/A	N/A	M4 by 50 Long SHCS	2**
28	N/A	N/A	M5 by 12 Lg SHCS	1**
29	N/A	N/A	#5-40 by 3/8" Long SHCS	1**
30	N/A	N/A	#10-32 by 3/8" Long Flat Point SSS	1**
31	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

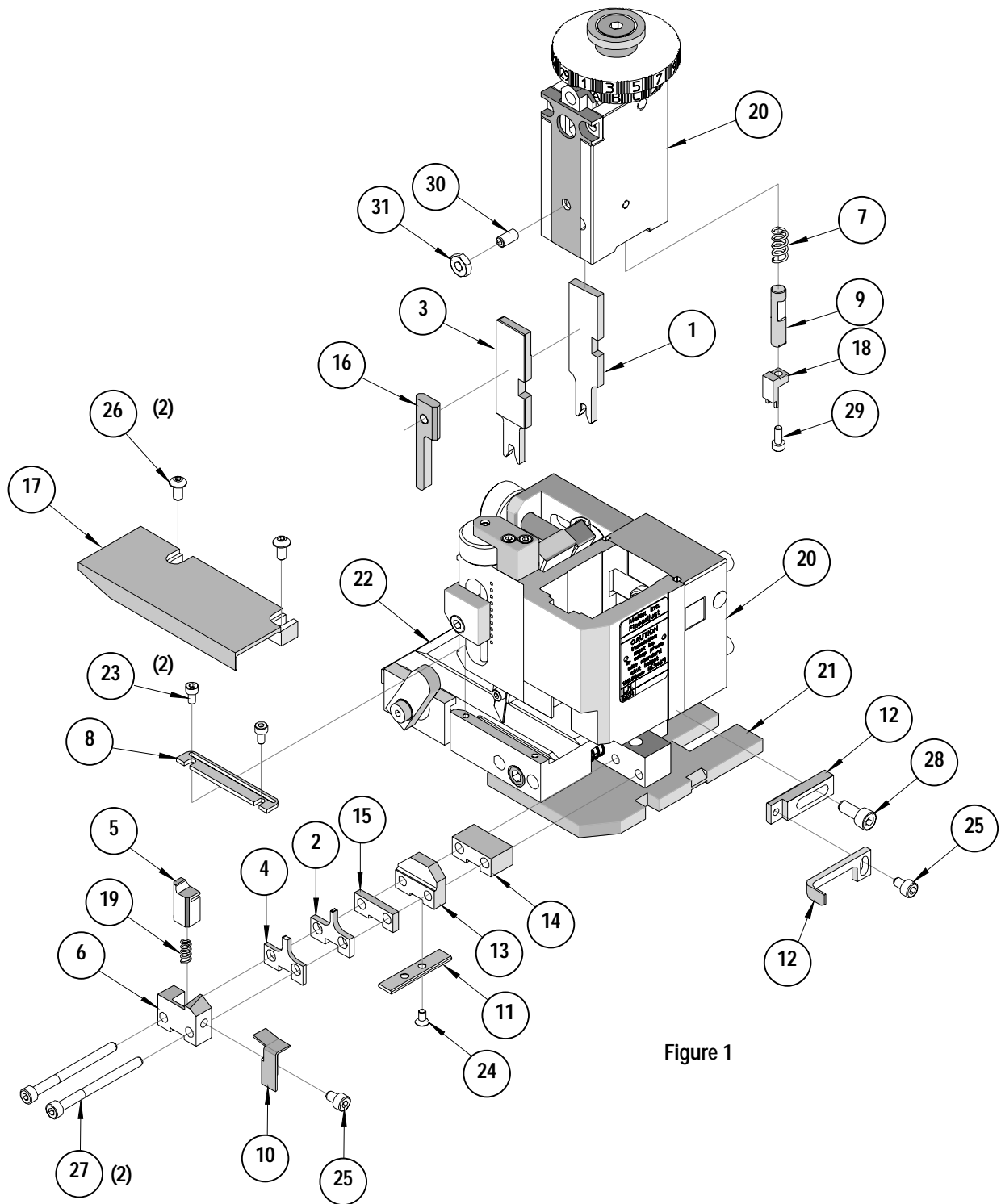


Figure 1

## 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 135.8mm (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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