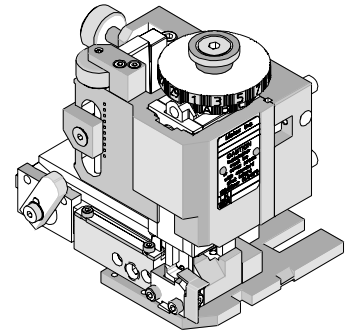




# FineAdjust Applicator Specification Sheet Part No. 63864-4100 (Full Radius Insulation Crimp)



## FEATURES

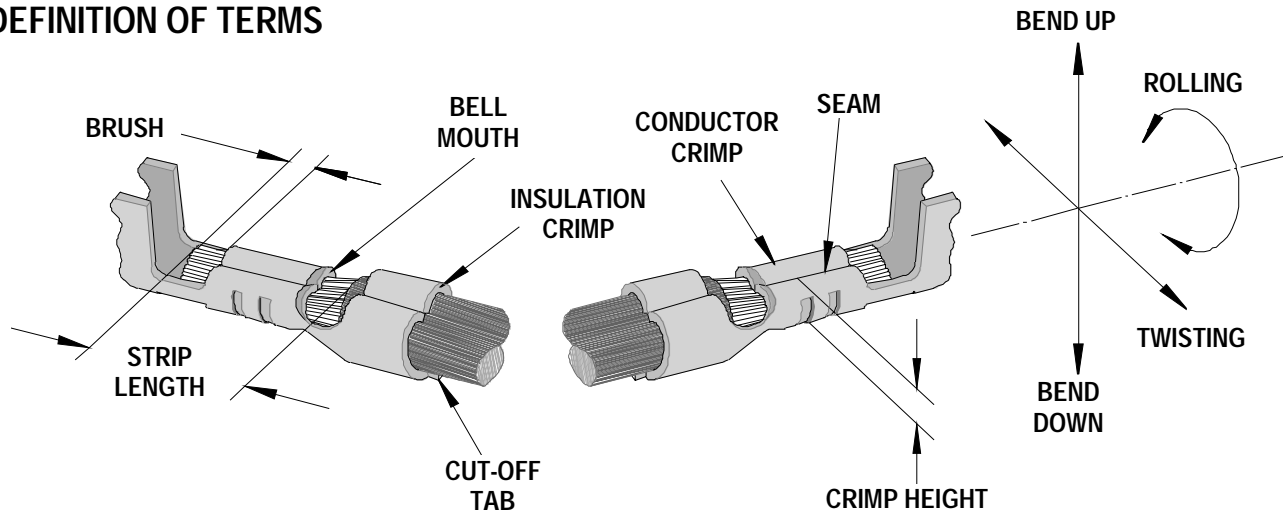
- Quick punch removal with the push of a button for fast and easy tooling change
- Applicator designed to industry standard mounting and shut height 135.80mm (5.346")
- Quick set-up time; plus the crimp height, track and feed adjustments can be set without removing the applicator from the press
- Fine 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       | mm <sup>2</sup> | 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 | Twist  | Roll | Punch Width mm (Ref) |      |            |      | Seam<br>Seam shall not be open and<br>no wire allowed out<br>of the crimping area |
|---------------------|---------|-----------|--------|------|----------------------|------|------------|------|---|
|                     | Degree  |           | Degree |      | Conductor            |      | Insulation |      |   |
|                     |         |           |        |      | mm                   | In   | mm         | In   |   |
| 42477               | 3       | 3         | 4      | 8    | 2.30                 | .090 | 3.60       | .141 |   |
| 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 <sup>2</sup> | 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 |

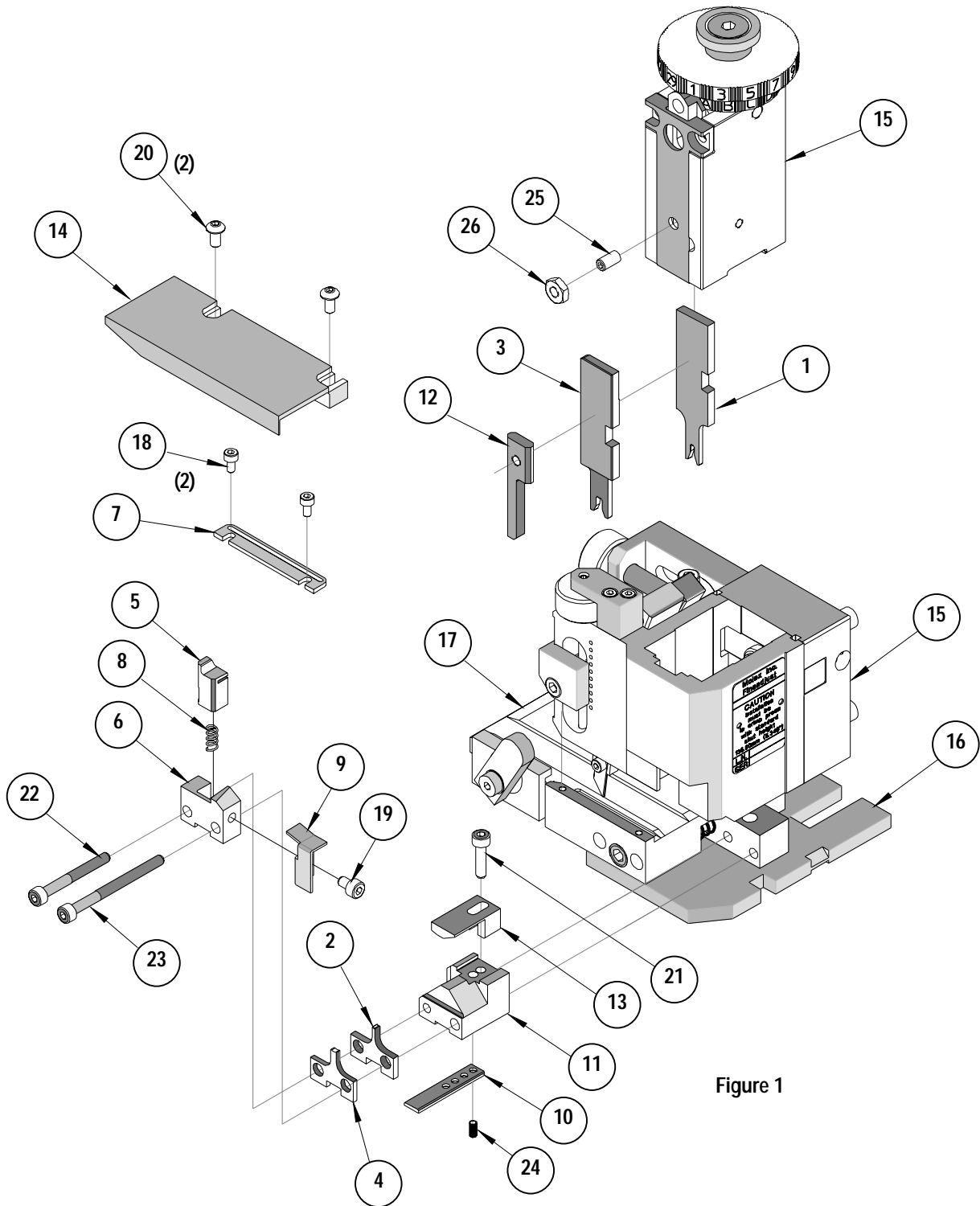
Pull Force should be measured with no influence from the insulation crimp.

The above specifications are guidelines to an optimum crimp.

**PARTS LIST**

| <b>FineAdjust Applicator 63864-4100</b>                                      |                 |                        |                                    |                 |
|--|-----------------|------------------------|------------------------------------|-----------------|
| <b>Item</b>  | <b>Order No</b> | <b>Engineering No.</b> | <b>Description</b>                 | <b>Quantity</b> |
| <b>Perishable Tooling</b>  |                 |                        |                                    |                 |
|  | 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             |
| <b>Other Components (644150)</b>   |                 |                        |                                    |                 |
| 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               |
| <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 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



## 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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