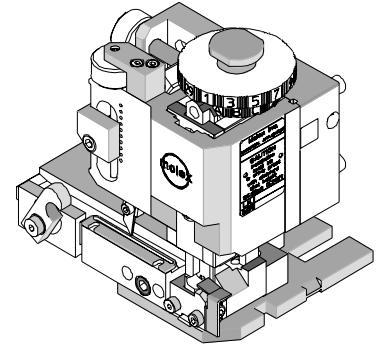




# FineAdjust Applicator Specification Sheet Part No. 63868-7000



## 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

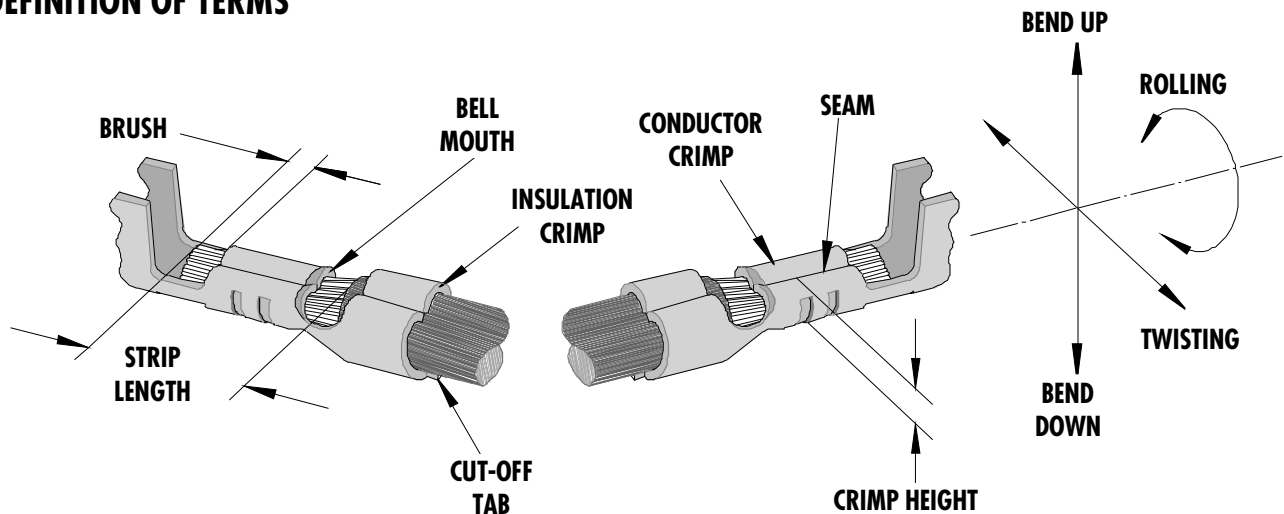
## SCOPE

Products: 2.00mm (.079") Wire to Board Dual Grid Connector Receptacle Terminal

Terminal Order No.	Wire Size		Insulation Diameter		Strip Length	
	AWG	mm <sup>2</sup>	mm	In.	mm	In.
501647-1000	22-26	0.13-0.32	0.95-1.50	.037-.059	2.10-2.50	.083-.098

**Note: Terminal will accommodate the UL1007 wires**

## DEFINITION OF TERMS



The above terminal drawing is a generic terminal representation. It is not an image of any terminal listed in the scope.

**CRIMP SPECIFICATION**

Terminal Order No.	Bell mouth		Cut-off Tab Max.		Conductor Brush	
	mm	In.	mm	In.	mm	In.
501647-1000	0.10-0.45	.004-.018	0.25	.010	0.10-0.90	.004-.035

Terminal Order 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
	Degree		Degree		Conductor		Insulation		
	mm	In	mm	In	mm	In	mm	In	
501647-1000	3	3	3	8	1.20	.047	1.50	.059	

After crimping, the crimp profiles should measure the following:

Terminal Order No.	Wire Size		Conductor			
	AWG	mm <sup>2</sup>	Crimp Height		Crimp Width (Ref)	
			mm	In.	mm	In.
501647-1000	22	0.32	0.83-0.88	.033-.035	1.25	.049
501647-1000	24	0.20	0.75-0.80	.029-.031	1.25	.049
501647-1000	26	0.13	0.70-0.75	.027-.029	1.25	.049

Terminal Order No.	Wire Size		Insulation				Pull Force Min.	
	AWG	mm <sup>2</sup>	Crimp Height (Ref)		Crimp Width (Ref)		N	Lb.
			mm	In.	mm	In.		
501647-1000	22	0.32	1.65	.065	1.60	.063	39.2	8.8
501647-1000	24	0.20	1.60	.063	1.60	.063	29.4	6.6
501647-1000	26	0.13	1.55	.061	1.60	.063	19.6	4.4

\* Tool Qualification Notes:

1. This Applicator was qualified to the above specifications with UL1007 wire.
2. Pull Force should be measured with no influence from the insulation crimp.
3. The above specifications are guidelines to an optimum crimp.

**PARTS LIST**

<b>FineAdjust Applicator 63868-7000</b>				
<b>Item</b>	<b>Order No</b>	<b>Engineering No.</b>	<b>Description</b>	<b>Quantity</b>
<b>Perishable Tooling</b>				
	63868-7070	63868-7070	Tool Kit (All "Y" Items)	REF
1	63444-1207	63444-1207	Conductor Punch	1 Y
2	63445-1217	63445-1217	Conductor Anvil	1 Y
3	63446-1510	63446-1510	Insulation Punch	1 Y
4	63445-1503	63445-1503	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 (87050)</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	63443-2405	63443-2405	Anvil Mount	1
13	63443-4025	63443-4025	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 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 16 Long 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 1/4" Long BHCS	1**
** Available from an industrial supply company such as MSC (1-800-645-7270).				

# Assembly Drawing

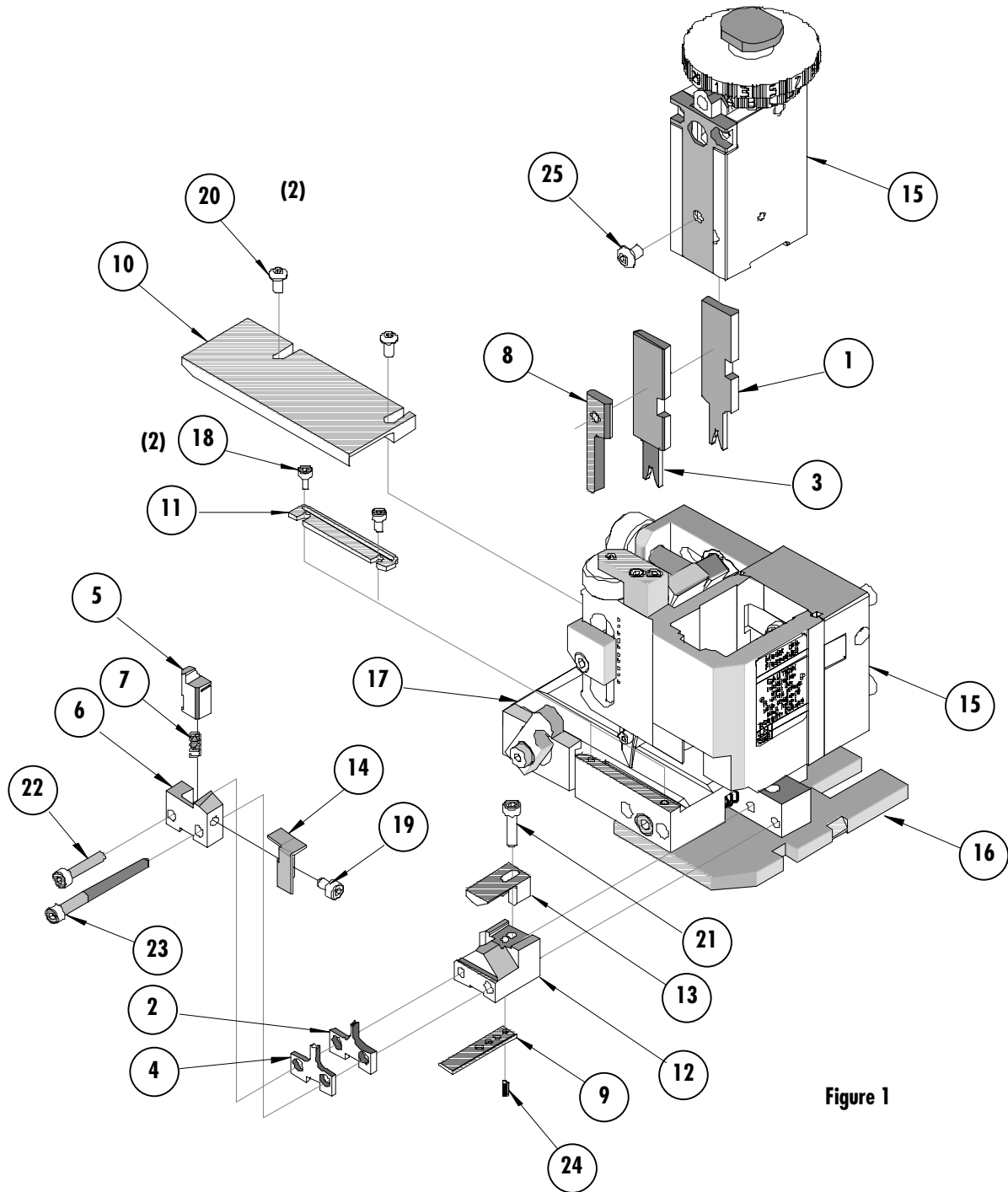


Figure 1

## 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.

**Americas Headquarters**  
Lisle, Illinois 60532 U.S.A.  
1-800-78MOLEX  
amerinfo@molex.com

**Far East North Headquarters**  
Yamato, Kanagawa, Japan  
81-462-65-2324  
feninfo@molex.com

**Far East South Headquarters**  
Jurong, Singapore  
65-6-268-6868  
fesinfo@molex.com

**European Headquarters**  
Munich, Germany  
49-89-413092-0  
eurinfo@molex.com

**Corporate Headquarters**  
2222 Wellington Ct.  
Lisle, IL 60532 U.S.A.  
630-969-4550  
Fax: 630-969-1352

Visit our Web site at <http://www.molex.com>



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#### Как с нами связаться

**Телефон:** 8 (812) 309 58 32 (многоканальный)

**Факс:** 8 (812) 320-02-42

**Электронная почта:** [org@eplast1.ru](mailto:org@eplast1.ru)

**Адрес:** 198099, г. Санкт-Петербург, ул. Калинина, дом 2, корпус 4, литера А.