| **FineAdjust Applicator**	molex®		
	Application Tooling Specification Sheet		
		Order No. 63900-8900	
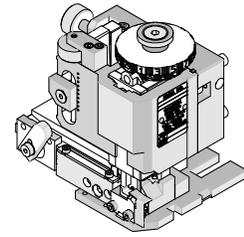
FEATURES

- 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: Term Signal Blade Crimp Terminals, 22 AWG.

Terminal Series No.	Wire Size		Insulation Diameter		Strip Length	
	AWG	mm²	mm	In.	mm	In.
45924-0001	22	.36	1.27-1.65	.050-.065	2.60-3.30	.102-.130
Note: Terminal is designed for UL style TW-10208 wire						

DEFINITION OF TERMS
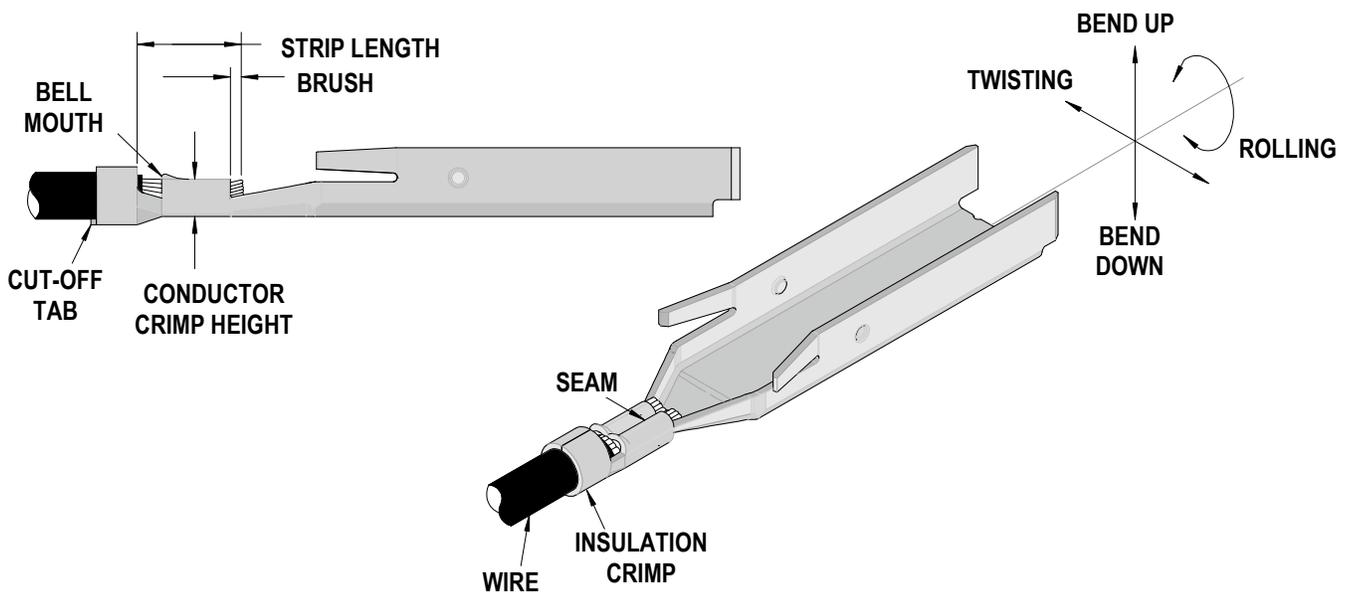
CRIMP SPECIFICATION

Terminal Series No.	Bell mouth		Cut-off Tab Maximum		Conductor Brush	
	mm	In.	mm	In.	mm	In.
45924-0001	0.20-0.50	.008-.020	0.50	.020	0.15-0.65	.006-.026

Terminal Series No.	Bend up	Bend down	Twist	Roll	Punch Width (Ref)				Seam
					Conductor		Insulation		Seam shall not be open and no wire allowed out of the crimping area
					mm	In	mm	In	
45924-0001	3°	3°	4°	8°	1.40	.055	1.80	.071	

After crimping, the crimp profiles should measure the following:

Terminal Series No.	Wire Size		Conductor				Insulation				Pull Force Minimum	
			Crimp Height		Crimp Width		Crimp Height		Crimp Width			
	AWG	mm²	mm	In.	mm	In.	mm	In.	mm	In.	N	Lb.
45924-0001	22	0.36	0.99-1.09	.039-.043	1.40-1.50	.055-.059	1.50-1.70	.059-.067	1.75-1.95	.069-.077	35.6	8.00

Tool Qualification Notes:

1. This Applicator was qualified to the above specifications with UL style TW-10208 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

Item	Order No	Engineering No.	Description	Quantity
FineAdjust Applicator 63900-8900				
Perishable Tooling				
	63900-8970	63900-8970	Tool Kit (All "Y" Items)	REF
1	63444-1418	63444-1418	Conductor Punch	1 Y
2	63445-1436	63445-1436	Conductor Anvil	1 Y
3	63454-0038	63454-0038	Insulation Punch	1 Y
4	63445-1814	63445-1814	Insulation Anvil	1 Y
5	63443-0035	63443-0035	Cut-Off Plunger Front	1 Y
6	63443-0036	63443-0036	Plunger Retainer Front	1 Y
Other Components				
7	11-18-4083	60707-8	Feed Guide	1
8	63443-0009	63443-0009	Front Scrap Chute	1
9	63443-0024	63443-0024	Key	1
10	63443-0090	63443-0090	Wire Stop	1
11	63443-1719	63443-1719	Height Spacer	1
12	63443-2216	63443-2216	Coarse Spacer	1
13	63443-2302	63443-2302	Fine Spacer	1
14	63443-3160	63443-3160	Front Plunger Striker	1
15	63443-6112	63443-6112	Rear Cover	1
16	63700-0539	63700-0539	Cut-Off Plunger Spring	1
Frame				
17	63800-4901	63800-4901	Top	1
18	63801-3281	63801-3281	Base	1
19	63801-4650	63801-4650	Track	1
Hardware				
20	N/A	N/A	M3 by 6 Long SHCS	2**
21	N/A	N/A	M3 by 6 Long FHCS	1**
22	N/A	N/A	M4 by 6 Long SHCS	2**
23	N/A	N/A	M4 by 12 Long BHCS	2**
24	N/A	N/A	M4 by 50 Long SHCS	2**
25	N/A	N/A	M5 by 12 Long SHCS	1**
26	N/A	N/A	#10-32 by 3/8"Long Flat Point SSS	1**
27	N/A	N/A	#10-32 Hex Jam Nut	1**

** Available from an industrial supply company such as MSC (1-800-645-7270).
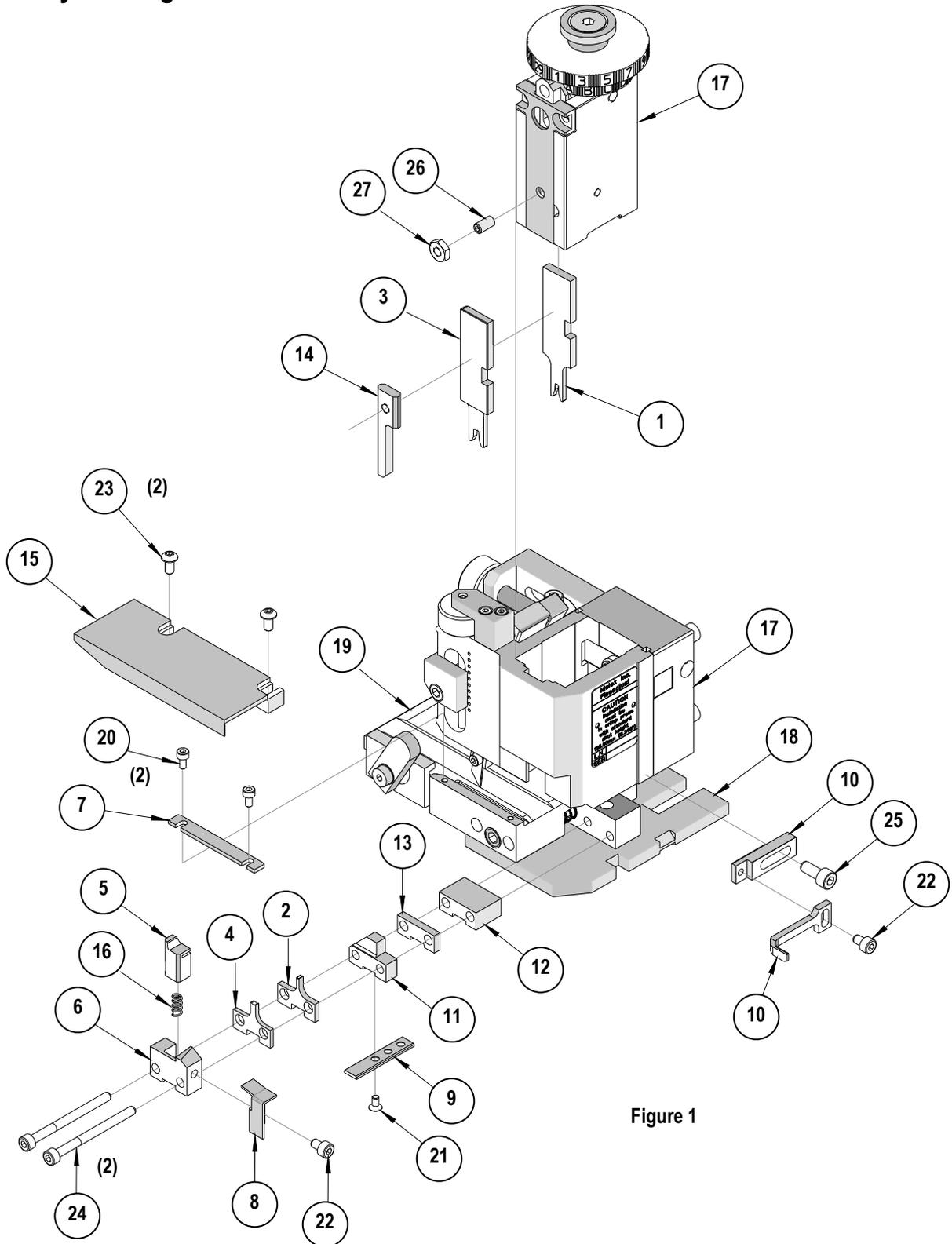
Assembly Drawing

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 135.80 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.

CAUTION:
Molex tooling crimp specifications are valid only when used with Molex terminals and tooling manufactured by Molex and sold by Molex or authorized distributors ("Molex Tooling"). When using tooling other than Molex Tooling with Molex specific connector systems listed in our ATS documents, the Molex tooling qualification does not apply and the responsibility for full qualification of the connector system is that of the customer.
Molex accepts no liability for connector performance or tooling support where tooling other than Molex Tooling is used or where Molex Tooling is modified.

Application Tooling Support
2200 Wellington Court
Lisle, IL 60532 USA
Phone: +1-402-458-TOOL (8665)
E-mail: applicationtooling@molex.com

Visit our Website at www.molex.com/applicationtooling