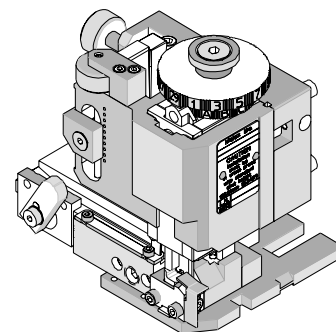




# FineAdjust Applicator Specification Sheet Part No. 63900-6500



## FEATURES

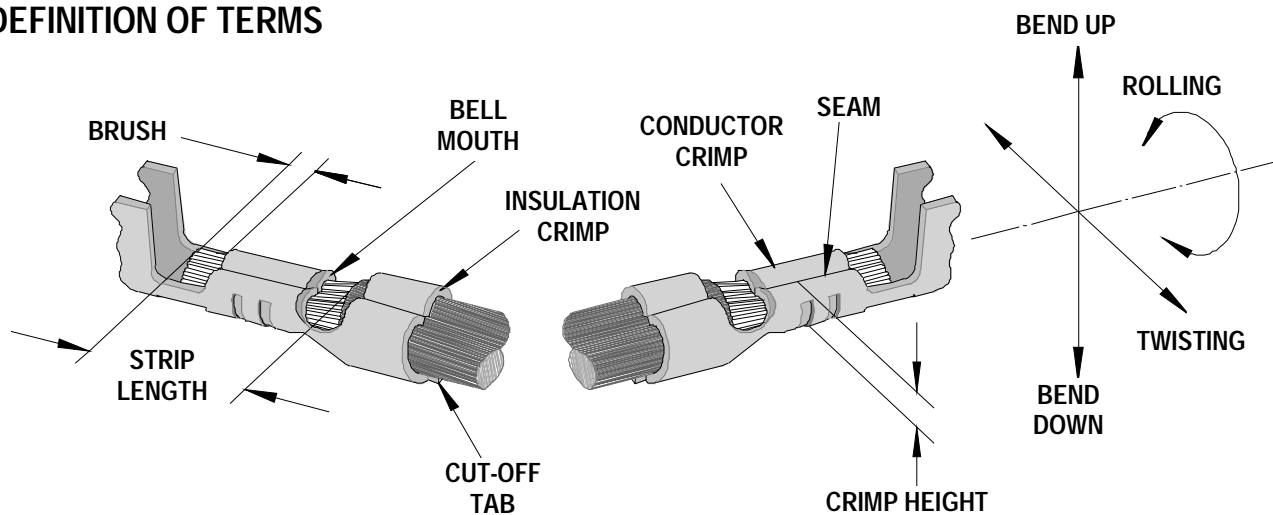
- Quick punch removal with the push of a button for fast and easy tooling change
- Applicator designed to industry standard mounting and shut height 135.80mm (5.346")
- Quick set-up time; plus the crimp height, track and feed adjustments can be set without removing the applicator from the press
- Fine 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: PicoFlex® Discrete Wire Crimp Terminal, 24-28 AWG.

Terminal Series No.	Terminal Order No.	Wire Size		Insulation Diameter		Strip Length	
		AWG	mm <sup>2</sup>	mm	In.	mm	In.
91821	91821-0001	24-28	0.20-0.09	0.90-1.50	.035-.059	2.00-2.50	.079-.098
	91821-0003						

## 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	
			Front (Contact)		Rear (Crimp)			
	mm	In.	mm	In.	mm	In.	mm	In.
91821	0.20-0.40	.008-.016	0.10	.004	0.15	.006	0.20-0.70	.008-.028

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
	Degree		Degree		Conductor		Insulation		
	mm	In	mm	In	mm	In	mm	In	
91821	3	3	3	8	1.00	.039	1.80	.071	

After crimping, the conductor profile should measure the following.

Terminal Series No.	Wire Size		Conductor Crimp Height		Insulation Crimp Height Maximum		Pull Force Minimum	
	AWG	mm <sup>2</sup>	mm	In.	mm	In.	N	Lb.
91821	24	0.20	0.67-0.72	.026-.028	1.65	.065	30.0	6.7
	26	0.12	0.64-0.69	.025-.027	1.65	.065	20.0	4.5
	28	0.08	0.60-0.65	.024-.026	1.65	.065	10.0	2.3

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 63900-6500</b>				
<b>Item</b>	<b>Order No</b>	<b>Engineering No.</b>	<b>Description</b>	<b>Quantity</b>
<b>Perishable Tooling</b>				
	63900-6570	63900-6570	Tool Kit (All "Y" Items)	REF
1	63444-1005	63444-1005	Conductor Punch	1 Y
2	63445-1010	63445-1010	Conductor Anvil	1 Y
3	63446-1810	63446-1810	Insulation Punch	1 Y
4	63445-1820	63445-1820	Insulation Anvil	1 Y
5	63443-0003	63443-0003	Cut-Off Plunger	2 Y
6	63443-0012	63443-0012	Front Plunger Retainer	1 Y
7	63443-1403	63443-1403	Cut-off Die Blade	1 Y
8	63443-1002	63443-1002	Rear Plunger Retainer	1 Y
<b>Other Components (REF 006550)</b>				
9	11-18-4083	60707-8	Feed Guide	1
10	11-24-1067	4996-4	Cut-Off Plunger Spring	2
11	11-40-4039	8302-5	Plunger Striker	1
12	63443-0009	63443-0009	Scrape Chute	1
13	63443-0024	63443-0024	Key	1
14	63443-0090	63443-0090	Wire Stop	1
15	63443-1740	63443-1740	21.00mm Height Spacer	1
16	63443-2133	63443-2133	Spacer	1
17	63443-2203	63443-2203	3.00mm Coarse Spacer	1
18	63443-2312	63443-2312	3.60mm Fine Spacer	1
19	63443-3060	63443-3060	Rear Plunger Striker	1
20	63443-6003	63443-6003	Rear Cover	1
<b>Frame</b>				
21	63800-4901	63800-4901	Top	1
22	63801-3281	63801-3281	Base	1
23	63801-4650	63801-4650	Track	1
<b>Hardware</b>				
24	N/A	N/A	M3 by 6 Long SHCS	2**
25	N/A	N/A	M3 by 6 Long FHCS	1**
26	N/A	N/A	M4 by 6 Long SHCS	2**
27	N/A	N/A	M4 by 10 Long SHCS	2**
28	N/A	N/A	M4 by 12 Long BHCS	2**
29	N/A	N/A	M4 by 50 Long SHCS	2**
30	N/A	N/A	M5 by 12 Long SHCS	1**
31	N/A	N/A	#10-32 by 3/8" Long Flat Point SSS	1**
32	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

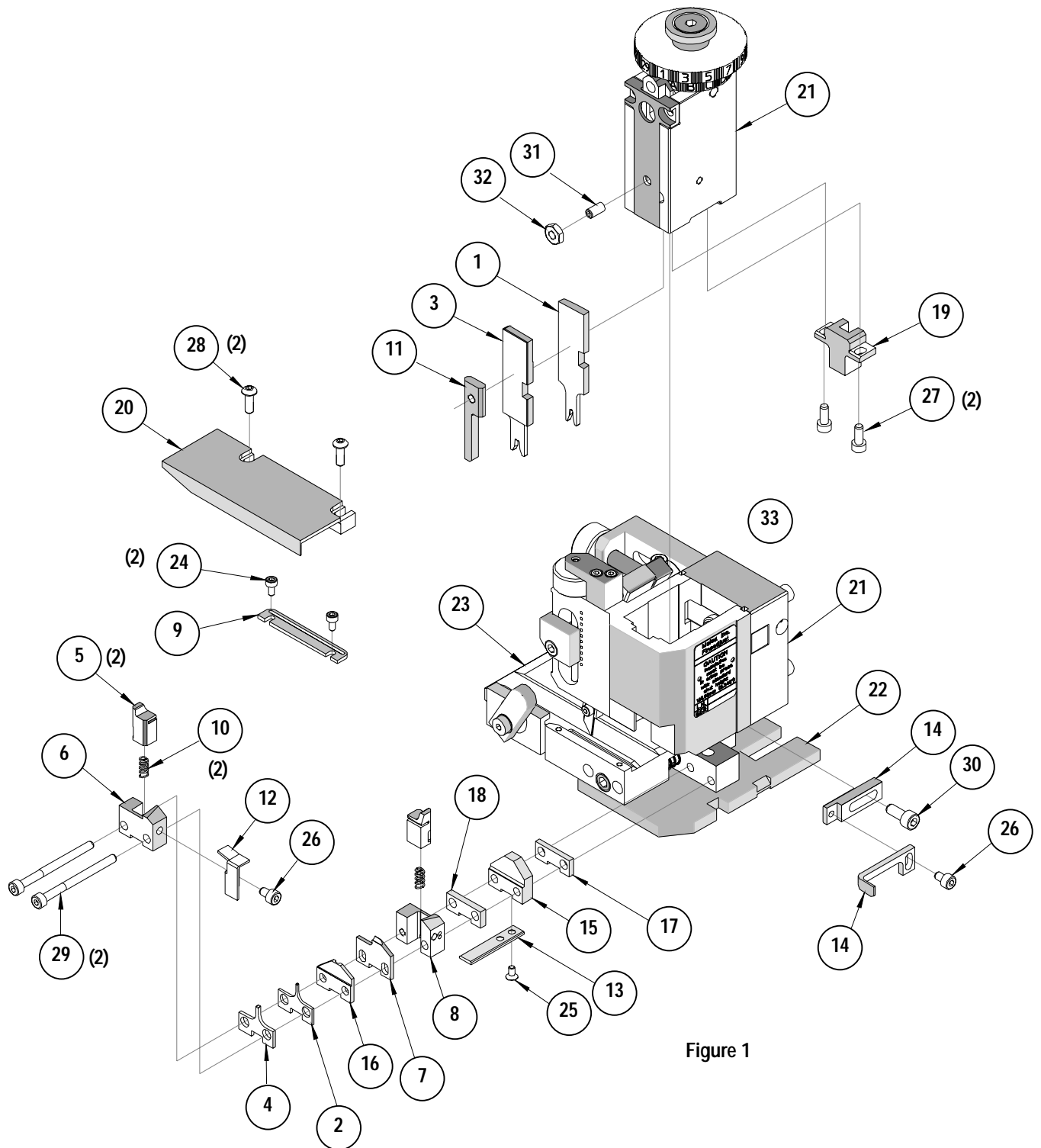


Figure 1

## 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.

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