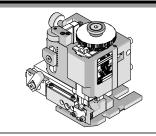
FineAdjust
Applicator
(Overlap Insulation
Crimp)



Application Tooling Specification Sheet



Order No. 63902-4600

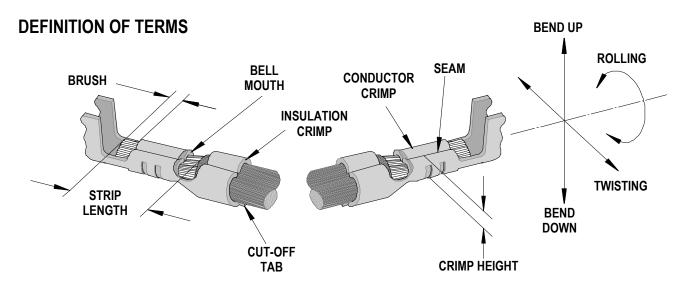
FEATURES

- 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: Standard .093" (2.63mm) Pin and Socket Crimp Terminal

Terminal Series No.	Terminal Order No.	Wi	re Size	Insulation	Diameter	Strip Length	
		AWG	mm²	mm	ln.	mm	ln.
42477	02-09-1615	16-18	0.81-1.30	2.36-3.20	.093126	3.96-5.33	.156218
42478	02-09-2611	16-18	0.81-1.30	2.36-3.20	.093126	3.96-5.33	.156218
	02-09-2612						
For 14AWG 2.79mm (.110") -3.56mm (.140") insulation diameter, use 63902-4700 applicator.							



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

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CRIMP SPECIFICATION

	Tarminal Carias No.	Bell n	nouth	Cut-off Tab	Maximum (Conductor Brush	
Terminal Series No.	mm	ln.	mm	ln.	mm	ln.	
	42477	0.25-0.58	.010023	0.25	.010	0.13-0.55	.005022
	42478	0.25-0.58	.010023	0.25	.010	0.13-0.55	.005022

	Bend up Bend down		Twist	Roll	Punch Width mm (Ref)		(Ref)	C		
Terminal Series No.	Degree		Degree		Conductor		Insulation		Seam	
					mm	In	mm	In	Seam shall not be open and no wire allowed out	
42477	3	3	4	8	2.30	.090	3.60	.141	of the crimping area	
42478	3	3	4	8	2.30	.090	3.60	.141	or the chiliping area	

After crimping, the conductor profile should measure the following.

Terminal Series No.	Wire Size		Crimp	Height	Pull Force Minimum		
Terminal Series No.	AWG	mm ²	mm In.		N	Lb.	
42477	16	1.31	1.70-1.60	.067063	177.9	40.00	
42477	18	0.81	1.55-1.47	.061058	115.6	26.00	
42478	16	1.31	1.70-1.60	.067063	177.9	40.00	
42470	18	0.81	1.55-1.47	.061058	115.6	26.00	

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

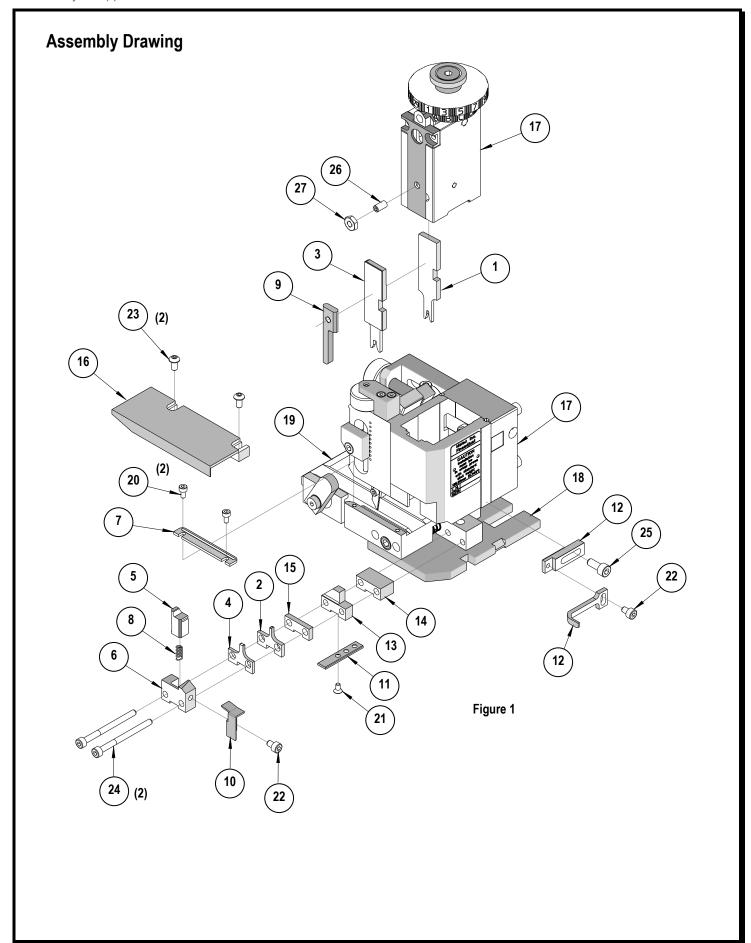
The above specifications are guidelines to an optimum crimp.

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PARTS LIST

FineAdjust Applicator 63902-4600								
Item	Order No Engineering No. Description							
Perishable Tooling								
	63902-4670	63902-4670	Tool Kit (All "Y" Items)	REF				
1	63444-2325	63444-2325	Conductor Punch	1 Y				
2	63445-2348	63445-2348	Conductor Anvil	1 Y				
3	63454-0066	63454-0066	Insulation Punch-Overlap	1 Y				
4	63445-3614	63445-3614	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				
			Components					
7	11-18-4083	60707-8	Feed Guide	1				
8	11-24-1067	4996-4	Cut-Off Plunger Spring	1				
9	63443-3160	63443-3160	Plunger Striker	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	18.90mm Height Spacer	1				
14	63443-2214	63443-2214	14.00mm Coarse Spacer	1				
15	63443-2308	63443-2308	3.40mm Fine Spacer	1				
16	63443-6119	63443-6119	Rear Cover	1				
Frame								
17	63800-4901	63800-4901	Тор	1				
18	63801-3281	63801-3281	Base	1				
19	63801-4650	63801-4650	Track	1				
			lardware					
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).							

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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.

http://www.molex.com

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