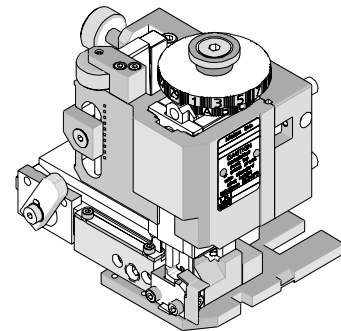




# FineAdjust Applicator Specification Sheet Part No. 63900-4600



## FEATURES

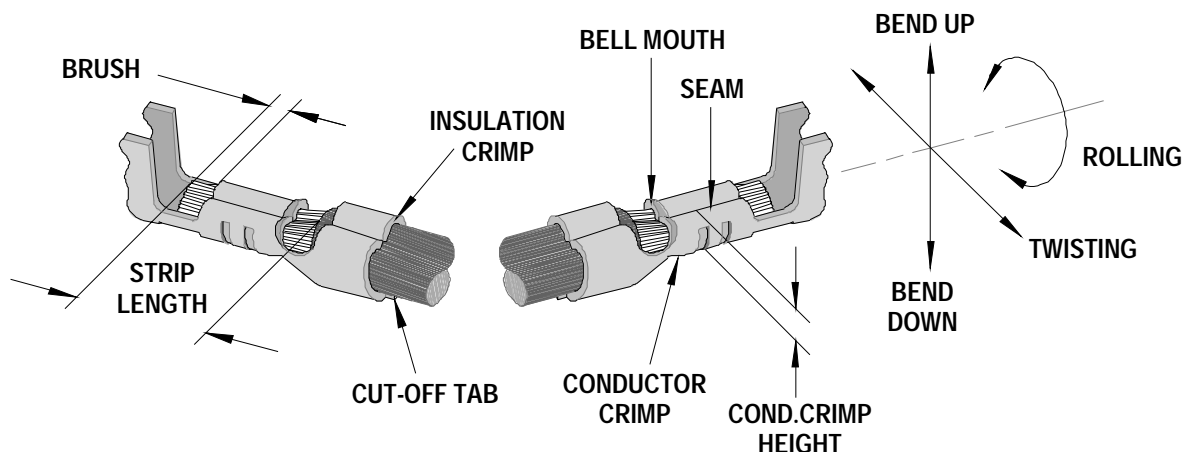
- Quick punch removal with the push of a button for fast and easy tooling change
- Applicator designed to industry standard mounting and shut height 135.80mm (5.346")
- Quick set-up time; plus the crimp height, track and feed adjustments can be set without removing the applicator from the press
- Fine 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: 2.50mm (.098") Pitch SPOX™ Wire-to-Board and Wire-to-Wire Crimp Terminal, 22-28 AWG.

Terminal Series No	Terminal Order No.			Wire Size		Insulation Diameter		Strip Length	
				AWG	mm <sup>2</sup>	mm	In.	mm	In.
5103	08-70-0056	39-00-0188	39-00-0389	22-28	0.35-0.08	1.15-1.90	.045-.075	2.60-3.20	.102-.126
	08-70-0058	39-00-0388	39-00-0390						
	08-700-0569	39-00-0387							
	08-700-0589	39-00-0442							
5241	08-70-0102			22-28	0.35-0.08	1.15-1.90	.045-.075	2.60-3.20	.102-.126
50802	50802-8000	50802-9001		22-28	0.35-0.08	1.15-1.90	.045-.075	2.60-3.20	.102-.126

## 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.
5103	0.20-0.50	.008-.020	0.30	.012	0.00-1.00	.000-.039
5241	0.20-0.50	.008-.020	0.30	.012	0.00-1.00	.000-.039
50802	0.20-0.50	.008-.020	0.30	.012	0.00-1.00	.000-.039

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		
	mm	In	mm	In	mm	In	mm	In	
5103	4	4	3	8	1.40	.055	1.90	.075	
5241	4	4	3	8	1.40	.055	1.90	.075	
50802	4	4	3	8	1.40	.055	1.90	.075	

After crimping, the conductor profile should measure the following.

Terminal Series No.	Wire Size		Conductor Crimp Height		Pull Force Minimum	
	AWG	mm <sup>2</sup>	mm	In.	N	Lb.
5103	22	0.35	0.82-0.87	.032-.034	39.1	8.8
	24	0.20	0.75-0.80	.030-.031	29.3	6.6
	26	0.12	0.70-0.75	.028-.030	19.6	4.4
	28	0.08	0.66-0.71	.026-.028	9.8	2.2
5241	22	0.35	0.82-0.87	.032-.034	39.1	8.8
	24	0.20	0.75-0.80	.030-.031	29.3	6.6
	26	0.12	0.70-0.75	.028-.030	19.6	4.4
	28	0.08	0.66-0.71	.026-.028	9.8	2.2
50802	22	0.35	0.82-0.87	.032-.034	39.1	8.8
	24	0.20	0.75-0.80	.030-.031	29.3	6.6
	26	0.12	0.70-0.75	.028-.030	19.6	4.4
	28	0.08	0.66-0.71	.026-.028	9.8	2.2

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 63900-4600</b>				
Item	Order No	Engineering No.	Description	Quantity
<b>Perishable Tooling</b>				
	63900-4670	63900-4670	Tool Kit (All "Y" Items)	REF
1	63444-1417	63444-1417	Conductor Punch	1 Y
2	63445-1435	63445-1435	Conductor Anvil	1 Y
3	63446-1914	63446-1914	Insulation Punch	1 Y
4	63445-1924	63445-1924	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 (REF 004450)</b>				
7	11-18-4083	60707-8	Feed Guide	1
8	11-24-1067	4996-4	Cut-off Plunger Spring	1
9	11-40-4039	8302-5	Front 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	63443-1703	63443-1703	17.30mm Height Spacer	1
14	63443-2216	63443-2216	16.00mm Coarse Spacer	1
15	63443-2302	63443-2302	3.10mm Fine Spacer	1
16	63443-6111	63443-6111	Rear Cover	1
<b>Frame</b>				
17	63800-4901	63800-4901	Top	1
18	63801-3281	63801-3281	Base	1
19	63801-4650	63801-4650	Track	1
<b>Hardware</b>				
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

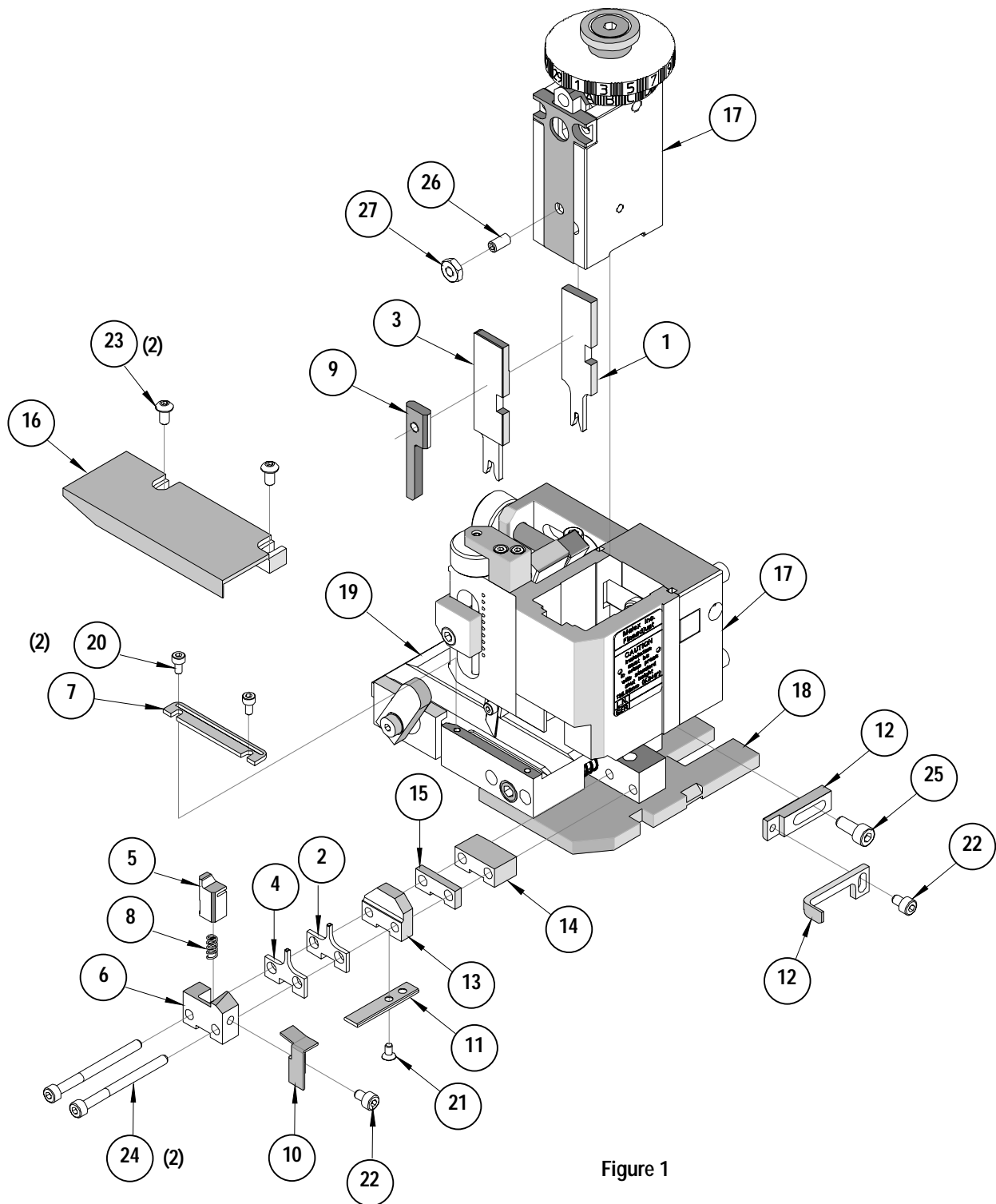


Figure 1

## 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 135.8 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.

**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>