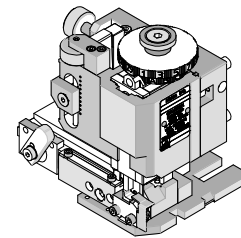




**FineAdjust  
Applicator**

**Application Tooling  
Specification Sheet**



**Order No. 63902-4000**

**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**

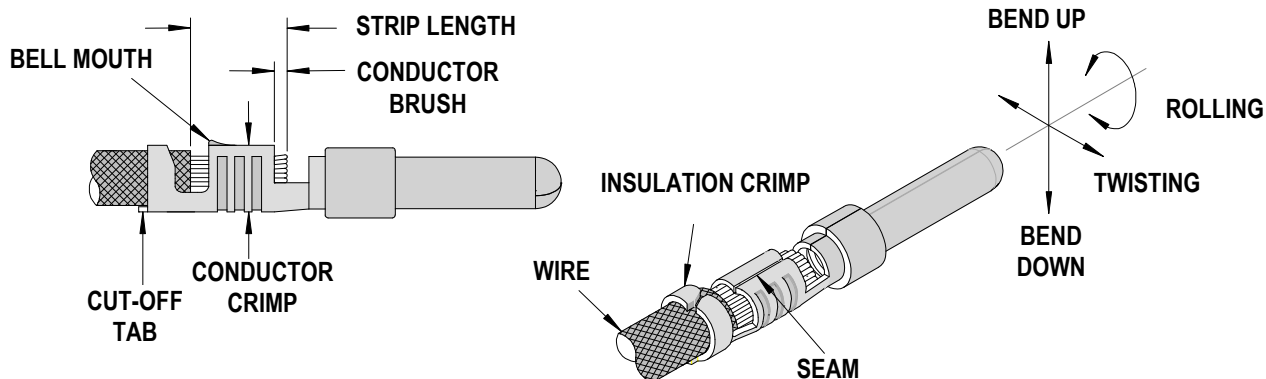
Products: 2.80mm (.110") Crimp Terminal, Male and Female, 2.50-4.00mm<sup>2</sup> wire.

Terminal Series No.	Terminal Order No.	Wire Size		Insulation Diameter				Strip Length	
				IPC/WHMA-A620 (1)		Terminal (2)			
		AWG	mm <sup>2</sup>	mm	In.	mm	In.	mm	In.
98012	98012-1302	-	2.50-4.00	3.00-4.60	.118-.181	2.60-4.90	.102-.193	4.70-6.00	.185-.236
98014	98014-0300	-	2.50-4.00	3.00-4.60	.118-.181	2.60-4.90	.102-.193	4.70-6.00	.185-.236

(1) To achieve optimum IPC-A620 Class 2 insulation crimps, use this insulation OD range

(2) Overall insulation OD specification for terminal

**DEFINITION OF TERMS**



## CRIMP SPECIFICATION

Terminal Series No.	Bell mouth		Cut-off Tab Maximum		Conductor Brush	
	mm	In.	mm	In.	mm	In.
98012	0.35-0.70	.013-.028	0.35	.013	0.20-1.00	.008-.039
98014	0.35-0.70	.013-.028	0.35	.013	0.20-1.00	.008-.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		Insulation		
					mm	In	mm	In	
98012	3	3	4	8	3.00	.118	4.55	.179	
98014	3	3	4	8	3.00	.118	4.55	.179	

After crimping, the conductor profile should measure the following.

Terminal Series No.	Wire Size		Conductor Crimp Height		Insulation Crimp Height (Ref)		Pull Force Minimum	
	AWG	mm <sup>2</sup>	mm	In.	mm	In.	N	Lb.
98012	-	2.5	1.70-1.80	.067-.071	3.75-3.95	.148-.156	210.0	47.21
	-	3.0	1.80-1.90	.071-.075	4.00-4.20	.157-.165	240.0	53.95
	-	4.0	2.05-2.15	.081-.085	5.00-5.20	.197-.205	265.0	59.57
98014	-	2.5	1.70-1.80	.067-.071	3.75-3.95	.148-.156	210.0	47.21
	-	3.0	1.80-1.90	.071-.075	4.00-4.20	.157-.165	240.0	53.95
	-	4.0	2.05-2.15	.081-.085	5.00-5.20	.197-.205	265.0	59.57

### Tool Qualification Notes:

1. Pull Force should be measured with no influence from the insulation crimp.
2. The above specifications are guidelines to an optimum crimp.

**PARTS LIST**

<b>FineAdjust Applicator 63902-4000</b>				
<b>Item</b>	<b>Order No</b>	<b>Engineering No.</b>	<b>Description</b>	<b>Quantity</b>
<b>Perishable Tooling</b>				
	63902-4070	63902-4070	Tool Kit (All "Y" Items)	REF
1	63457-0085	63457-0085	Conductor Punch	1 Y
2	63455-0107	63455-0107	Conductor Anvil	1 Y
3	63454-0133	63454-0133	Insulation Punch	1 Y
4	63456-0089	63456-0089	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</b>				
7	11-17-0022	1739-21	Hold Down Spring	1
8	11-18-4083	60707-8	Feed Guide	1
9	11-24-1067	4996-4	Cut-off Plunger Spring	1
10	11-40-4039	8302-5	Front Plunger Striker	1
11	63443-0009	63443-0009	Front Scrap Chute	1
12	63443-0024	63443-0024	Key	1
13	63443-0091	63443-0091	Wire Stop	1
14	63443-0093	63443-0093	Shank	1
15	63443-1709	63443-1709	Height Spacer	1
16	63443-2213	63443-2213	Coarse Spacer (13.00mm)	1
17	63443-2311	63443-2311	Fine Spacer (3.55mm)	1
18	63443-6130	63443-6130	Rear Cover	1
19	63443-7117	63443-7117	Terminal Hold Down	1
<b>Frame</b>				
20	63800-4901	63800-4901	Top	1
21	63801-3281	63801-3281	Base	1
22	63801-4650	63801-4650	Track	1
23	63459-0001	63459-0001	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	M3 by 8 Long SHCS	1**
27	N/A	N/A	M4 by 6 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

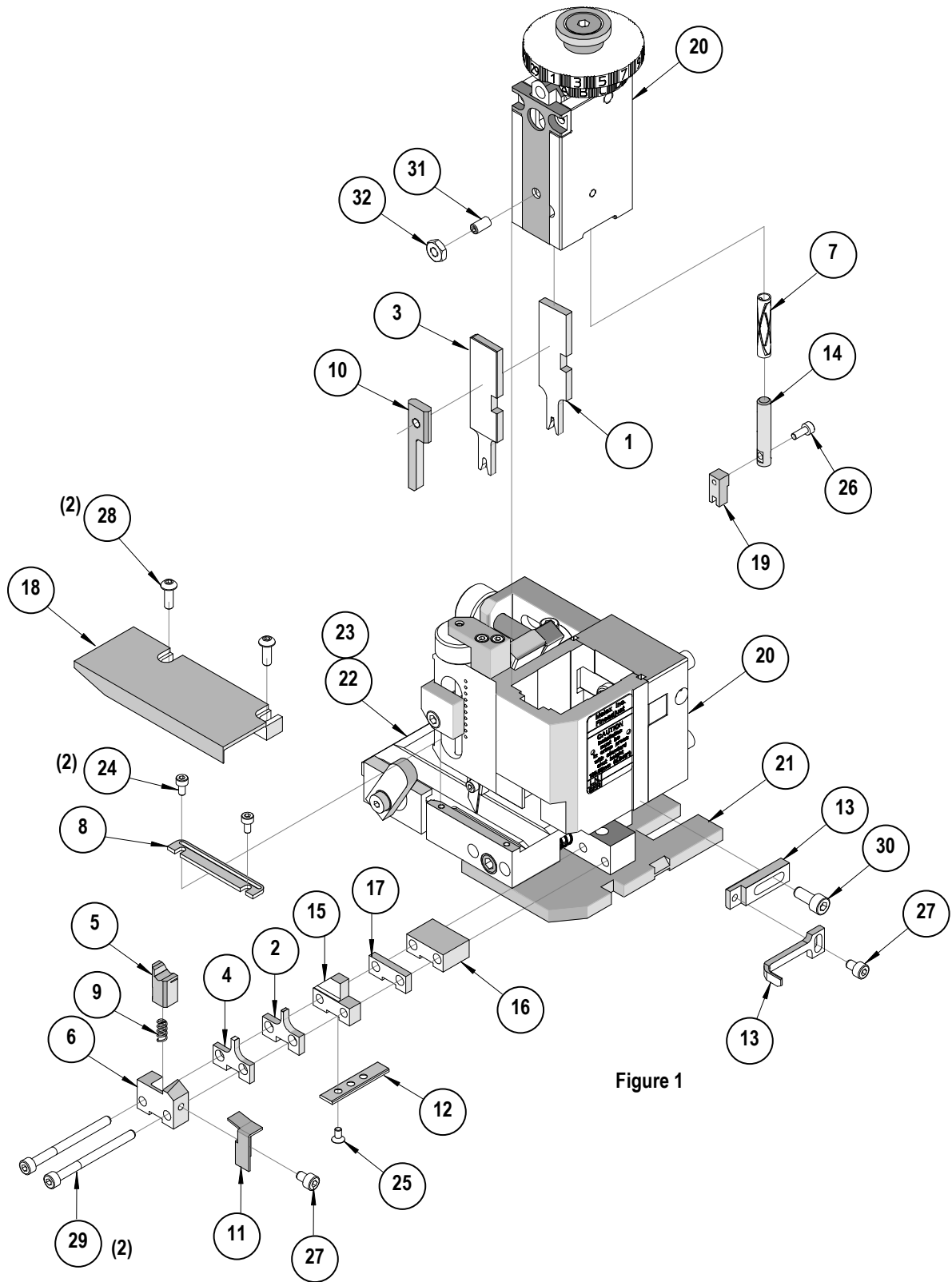


Figure 1

## 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 135.8mm (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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