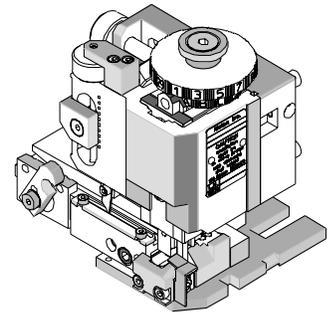




# FineAdjust Applicator Specification Sheet Part No. 63863-5200



## FEATURES

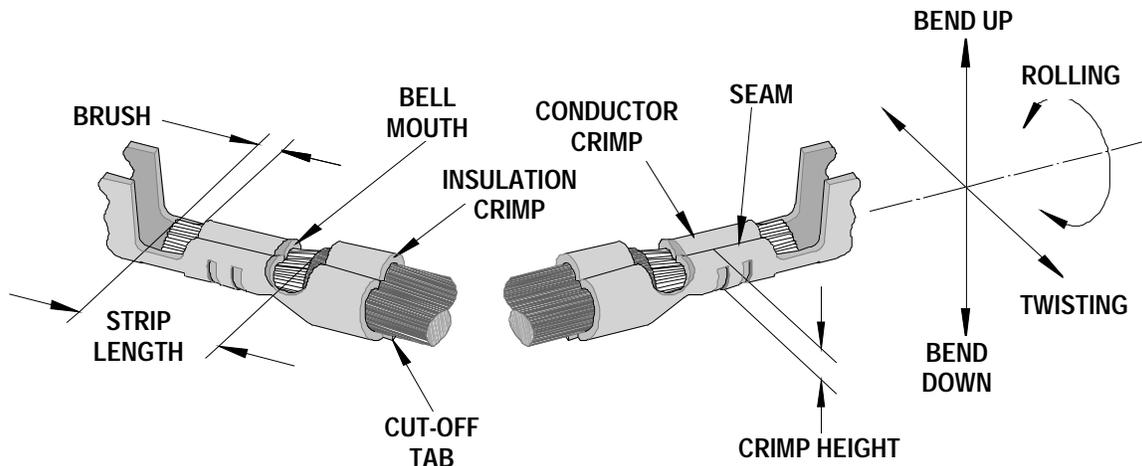
- Directly adapts to most automatic wire processing machines
- Quick punch removal with the push of a button for fast and easy tooling change
- Applicator designed to industry standard mounting and shut height 135.80mm (5.346")
- Quick set-up time; plus the crimp height, track and feed adjustments can 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: 2.00mm (.079") Pitch Crimp Terminal for 22-28 AWG.

Terminal Series No.	Terminal Order No.		Wire Size		Insulation Diameter		Strip Length	
			AWG	mm <sup>2</sup>	mm	In.	mm	In.
50639	50639-8018	50639-8049	22-28	0.35-0.08	0.55-1.15	.022-.045	2.20-2.70	.087-.106
	50639-8027	50639-8091						
	50639-8028	50639-8099						
	50639-8030							

## 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.
50639	0.20-0.50	.008-.020	0.20	.0008	0.10-0.50	0.004-.020

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	
50639	4	4	4	6	1.30	.051	1.40	.055	

After crimping, the conductor profile should measure the following.

Terminal Series No.	Wire Size		Conductor			
			Crimp Height		Crimp Width (Ref)	
	AWG	mm <sup>2</sup>	mm	In.	mm	In.
50639	22	0.35	0.94-0.99	.037-.039	1.20-1.40	.047-.055
	24	0.20	0.91-0.96	.036-.038	1.20-1.40	.047-.055
	26	0.13	0.82-0.87	.032-.034	1.20-1.40	.047-.055
	28	0.09	0.80-0.85	.031-.033	1.20-1.40	.047-.055

Terminal Series No.	Wire Size		Insulation				Pull Force Minimum	
			Crimp Height (Ref)		Crimp Width (Ref)			
	AWG	mm <sup>2</sup>	mm	In.	mm	In.	N	Lb.
50639	22	0.35	1.80	.071	1.30-1.50	.051-.059	34.3	7.7
	24	0.20	1.80	.071	1.30-1.50	.051-.059	24.5	5.5
	26	0.13	1.70	.067	1.30-1.50	.051-.059	14.7	3.3
	28	0.09	1.70	.067	1.30-1.50	.051-.059	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 63863-5200</b>				
<b>Item</b>	<b>Order No</b>	<b>Engineering No.</b>	<b>Description</b>	<b>Quantity</b>
<b>Perishable Tooling</b>				
	63863-5270	63863-5270	Tool Kit (All "Y" Items)	REF
1	63444-1301	63444-1301	Conductor Punch	1 Y
2	63445-1324	63445-1324	Conductor Anvil	1 Y
3	63446-1414	63446-1414	Insulation Punch	1 Y
4	63445-1424	63445-1424	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 635250)</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	Scrape Chute	1
11	63443-0021	63443-0021	Lower Tooling Key	1
12	63443-2406	63443-2406	Anvil Mount	1
13	63443-4005	63443-4005	Wire Stop	1
14	63443-6003	63443-6003	Rear Cover	1
<b>Frame</b>				
15	63800-4901	63800-4901	Top	1
16	63801-3281	63801-3281	Base	1
17	63801-4650	63801-4650	Track	1
<b>Hardware</b>				
18	N/A	N/A	M3 by 6 Long SHCS	2**
19	N/A	N/A	M4 by 6 Long SHCS	1**
20	N/A	N/A	M4 by 12 Long BHCS	2**
21	N/A	N/A	M4 by 16 Long SHCS	1**
22	N/A	N/A	M4 by 20 Long SHCS	1**
23	N/A	N/A	M4 by 50 Long SHCS	1**
24	N/A	N/A	3mm by 6 Long Roll Pin	
25	N/A	N/A	#10-32 by 3/8" Long Flat Point SSS	1**
26	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

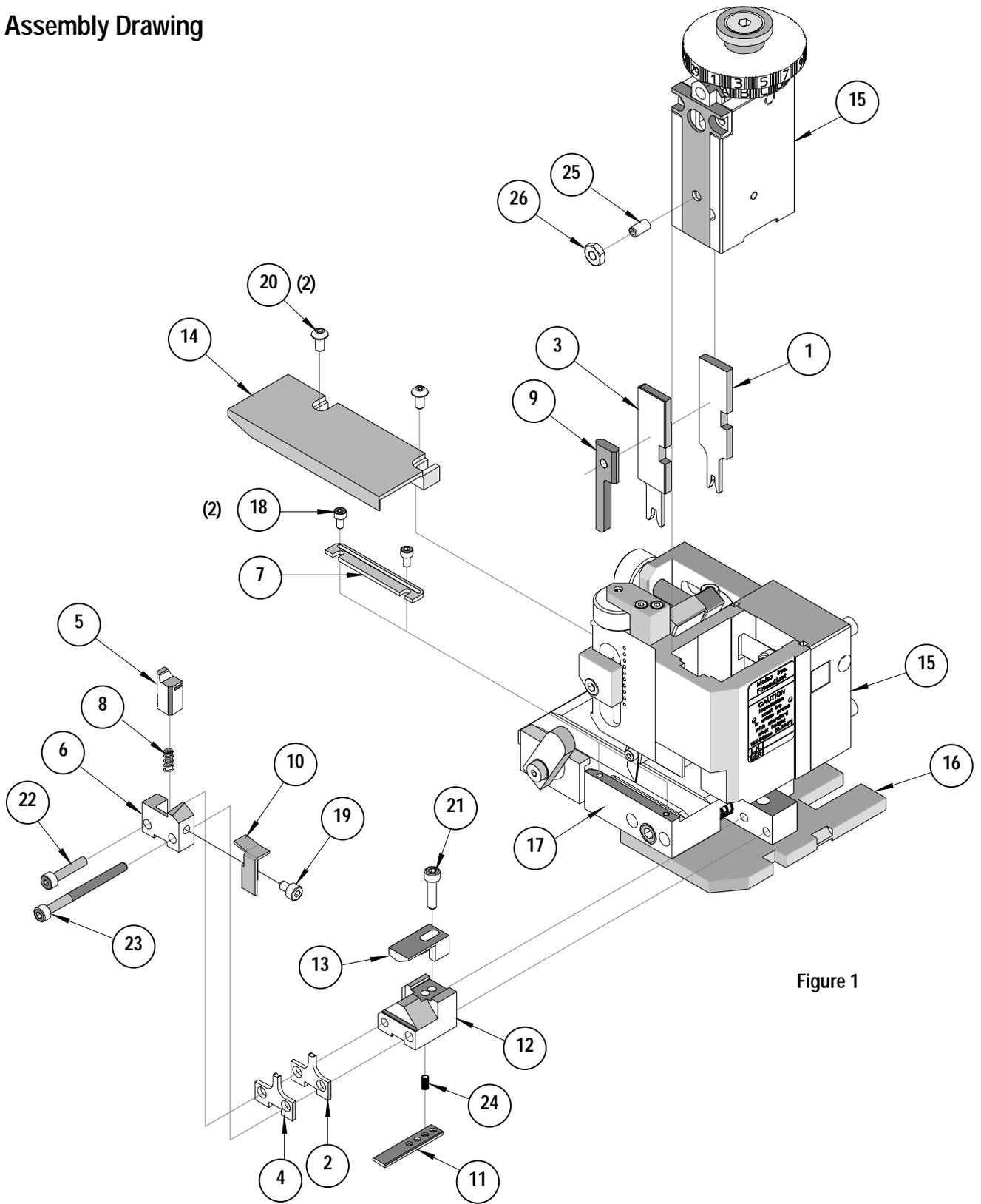


Figure 1

## 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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