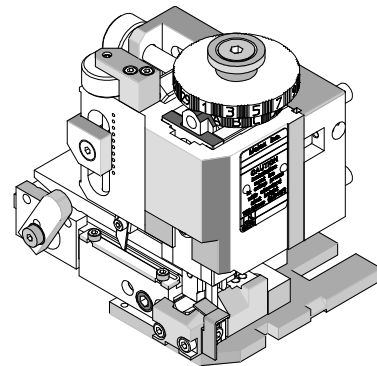




# FineAdjust Applicator Specification Sheet Order No. 63862-6100



## FEATURES

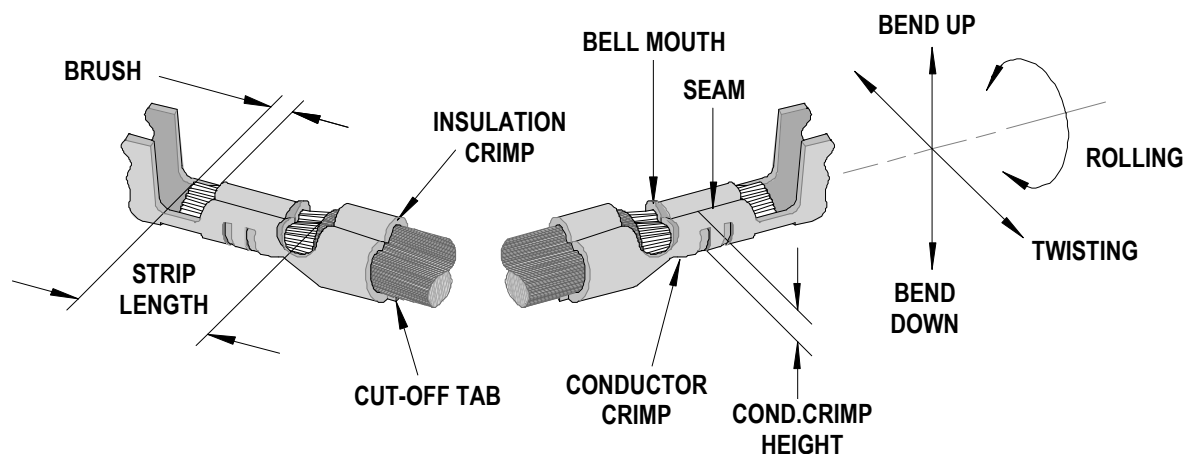
- Quick punch removal with the push of a button for fast and easy tooling change
- Applicator designed to industry standard mounting and shut height 135.80mm (5.346")
- Quick set-up time; plus the crimp height, track and feed adjustments can be set without removing the applicator from the press
- Fine adjustment allows users to achieve target with little effort by adjusting in increments of 0.15mm (.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: 2.00mm (.079") Pitch Crimp Terminal, 14-18 AWG.

Terminal Series No.	Terminal Order No.		Wire Size		Insulation Diameter Maximum		Strip Length	
			AWG	mm <sup>2</sup>	mm	In.	mm	In.
50637	50637-0028	50637-0049	14-18	2.00-0.80	3.80	.150	3.90-4.40	.154-.173
50638	50638-9028	50638-9049	14-18	2.00-0.80	3.80	.150	3.90-4.40	.154-.173
50674	50674-9049	50674-9099	14-18	2.00-0.80	3.80	.150	3.90-4.40	.154-.173

## 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.
50637	0.10-0.60	.004-.024	0.30	.012	0.00-1.00	.000-.039
50638	0.10-0.60	.004-.024	0.30	.012	0.00-1.00	.000-.039
50674	0.10-0.60	.004-.024	0.30	.012	0.00-1.00	.000-.039

Terminal Series No.	Bend up	Bend down	Twist	Roll	Punch Width (Ref)				Seam
					Conductor		Insulation		
	mm	In	mm	In	mm	In			
50637	5	4	4	8	2.60	.102	4.00	.157	Seam shall not be open and no wire allowed out of the crimping area
50638	5	4	4	8	2.60	.102	4.00	.157	
50674	5	4	4	8	2.60	.102	4.00	.157	

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.
50637	14	2.00	1.59-1.69	.063-.067	147.0	33.1
	16	1.30	1.39-1.49	.055-.059	127.4	28.7
	18	0.80	1.22-1.32	.048-.052	88.2	19.8
50638	14	2.00	1.59-1.69	.063-.067	147.0	33.1
	16	1.30	1.39-1.49	.055-.059	127.4	28.7
	18	0.80	1.22-1.32	.048-.052	88.2	19.8
50674	14	2.00	1.59-1.69	.063-.067	147.0	33.1
	16	1.30	1.39-1.49	.055-.059	127.4	28.7
	18	0.80	1.22-1.32	.048-.052	88.2	19.8

**\* 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 63862-6100</b>				
<b>Item</b>	<b>Order No</b>	<b>Engineering No.</b>	<b>Description</b>	<b>Quantity</b>
<b>Perishable Tooling</b>				
	63862-6170	63862-6170	Tool Kit (All "Y" Items)	REF
1	63444-2612	63444-2612	Conductor Punch	1 Y
2	63445-2666	63445-2666	Conductor Anvil	1 Y
3	63446-4021	63446-4021	Insulation Punch	1 Y
4	63445-4031	63445-4031	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	11-18-4083	60707-8	Front Cover	1
8	11-24-1067	4996-4	Cut-off Plunger Spring	1
9	63443-0009	63443-0009	Scrap Chute Front	1
10	63443-0024	63443-0024	Lower Tooling Key	1
11	63443-1703	63443-1703	17.30mm Spacer	1
12	63443-2214	63443-2214	14.00mm Spacer	1
13	63443-2318	63443-2318	3.90mm Spacer	1
14	63443-3160	63443-3160	Front Plunger Striker	1
15	63443-0090	63443-0090	Wire Stop	1
16	63443-6011	63443-6011	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 FHCS	1**
21	N/A	N/A	M3 by 6 Long SHCS	2**
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

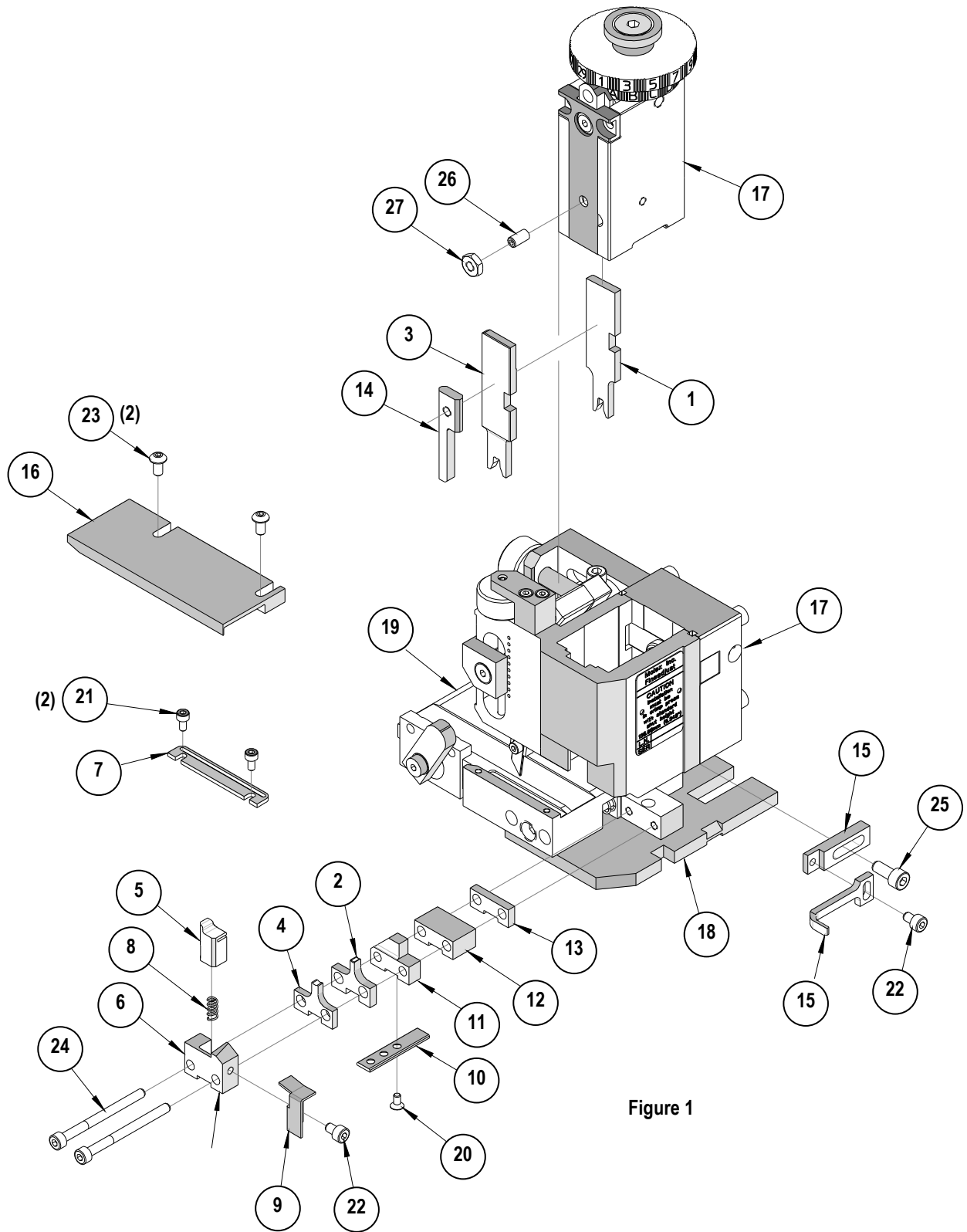


Figure 1

## 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.

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