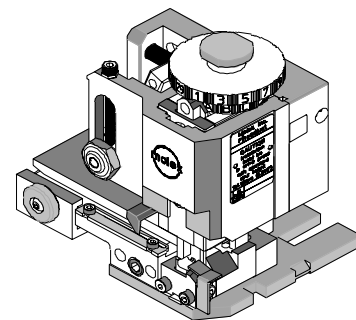




FineAdjust Applicator Specification Sheet Part No. 63866-8000



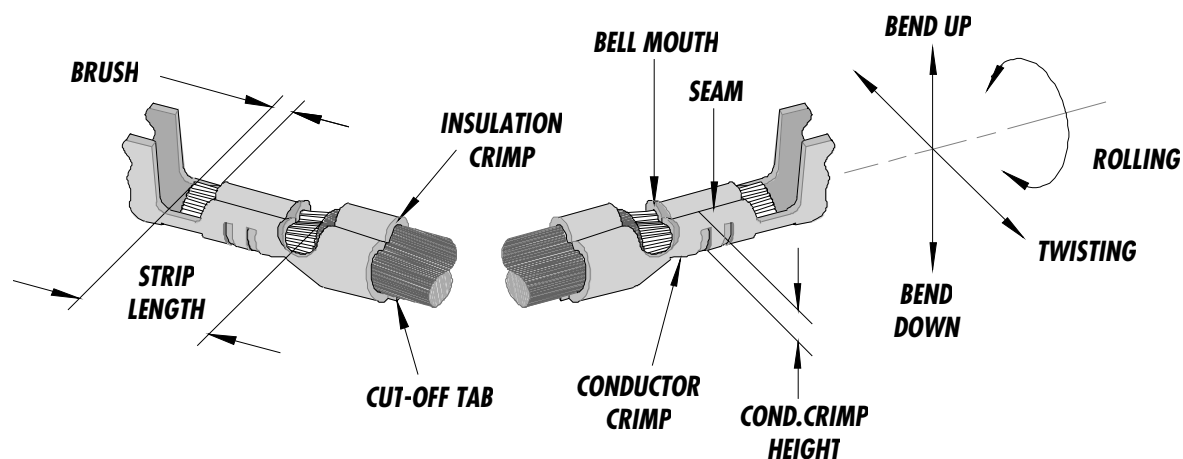
FEATURES

- 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

| Terminal Series No. | Wire Size | | Insulation Diameter | | Strip Length | |
|---------------------|-----------|-----------------|---------------------|-----------|--------------|-----------|
| | AWG | mm ² | mm | In. | mm | In. |
| 94529-1203 | 16-20 | 1.00-0.50 | 2.80 Max. | .110 Max. | 4.10-4.60 | .161-.181 |

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 Max. | | Conductor Brush | |
|---------------------|------------|-------------|------------------|------|-----------------|-------------|
| | mm | In. | mm | In. | mm | In. |
| 94529-1203 | .20-.30 | .008 - .012 | .30 | .012 | .50 – 1.20 | .020 - .047 |

| 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 | |
| 94529-1203 | 3 | 3 | 4 | 8 | 1.78 | .070 | 3.00 | .118 | |

After crimping, the conductor profile should measure the following.

| Terminal Series No. | Wire Size | | Conductor | | | | Insulation | | | | Pull Force Min. | |
|---------------------|-----------|-----------------|--------------|-----------|-------------------|-----------|--------------|-----------|-------------------|-----------|-----------------|-------|
| | | | Crimp Height | | Crimp Width (Ref) | | Crimp Height | | Crimp Width (Ref) | | | |
| | AWG | mm ² | mm | In. | mm | In. | mm | In. | mm | In. | N | Lb. |
| 94529-1203 | 16 | 1.00 | 1.40-1.50 | .055-.059 | 1.90 Max. | .075 Max. | 3.15-3.25 | .124-.128 | 3.15 Max. | .124 Max. | 117.7 | 26.46 |
| 94529-1203 | 18 | 0.75 | 1.30-1.40 | .051-.055 | 1.90 Max. | .075 Max. | 3.05-3.15 | .120-.124 | 3.15 Max. | .124 Max. | 98.1 | 22.05 |
| 94529-1203 | 20 | 0.50 | 1.25-1.30 | .049-.051 | 1.90 Max. | .075 Max. | 2.95-3.05 | .116-.120 | 3.15 Max. | .124 Max. | 68.6 | 15.43 |

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

The above specifications are guidelines to an optimum crimp.

PARTS LIST

| Item | Order No | Engineering No. | Description | Quantity |
|-------------|-------------------|------------------------|---------------------------------------|-----------------|
| | 63866-8000 | 63866-8000 | FineAdjust Applicator (Fig. 1) | REF |
| 1 | 63457-0023 | 63457-0023 | Conductor Punch | 1 Y |
| 2 | 63455-0025 | 63455-0025 | Conductor Anvil | 1 Y |
| 3 | 63454-0037 | 63454-0037 | Insulation Punch | 1 Y |
| 4 | 63456-0031 | 63456-0031 | Insulation Anvil | 1 Y |
| 5 | 63443-0002 | 63443-0002 | Cut-Off Plunger | 1 Y |
| 6 | 63443-0012 | 63443-0012 | Front Plunger Retainer | 1 Y |
| 7 | 11-24-1067 | 4996-4 | Cut-Off Plunger Spring | 1 |
| 8 | 11-40-4039 | 8302-5 | Front Plunger Striker | 1 |
| 9 | 63443-0021 | 63443-0021 | Lower Tooling Key | 1 |
| 10 | 63443-6011 | 63443-6011 | Rear Cover | 1 |
| 11 | 11-18-4094 | 60709A111 | Front Cover | 1 |
| 12 | 63443-2515 | 63443-2515 | Anvil Mount | 1 |
| 13 | 63443-4005 | 63443-4005 | Wire Stop | 1 |
| 14 | 63443-0009 | 63443-0009 | Scrap Chute | 1 |
| 15 | 63800-4900 | 63800-4900 | FineAdjust Applicator | 1 |
| 16 | 63860-2015 | 63860-2015 | * Drag Frame | 1 |
| 17 | N/A | N/A | M3 by 6Lg. SHCS | 2** |
| 18 | N/A | N/A | M4 by 6Lg. SHCS | 1** |
| 19 | N/A | N/A | M4 by 12Lg. BHCS | 2** |
| 20 | N/A | N/A | M4 by 16Lg. SHCS | 1** |
| 21 | N/A | N/A | M4 by 50Lg. SHCS | 2** |
| 22 | N/A | N/A | 3MM by 6Lg. Roll Pin | 1** |
| 23 | N/A | N/A | #10-32 by 1/4"Lg. BHCS | 1** |
| | 63866-8070 | 63866-8070 | Tool Kit (All Y Items) | REF |

* Frame Part - To be modified

** The following purchased parts are available from an Industrial supply company such as MSC (1-800-645-7270).

Assembly Drawing

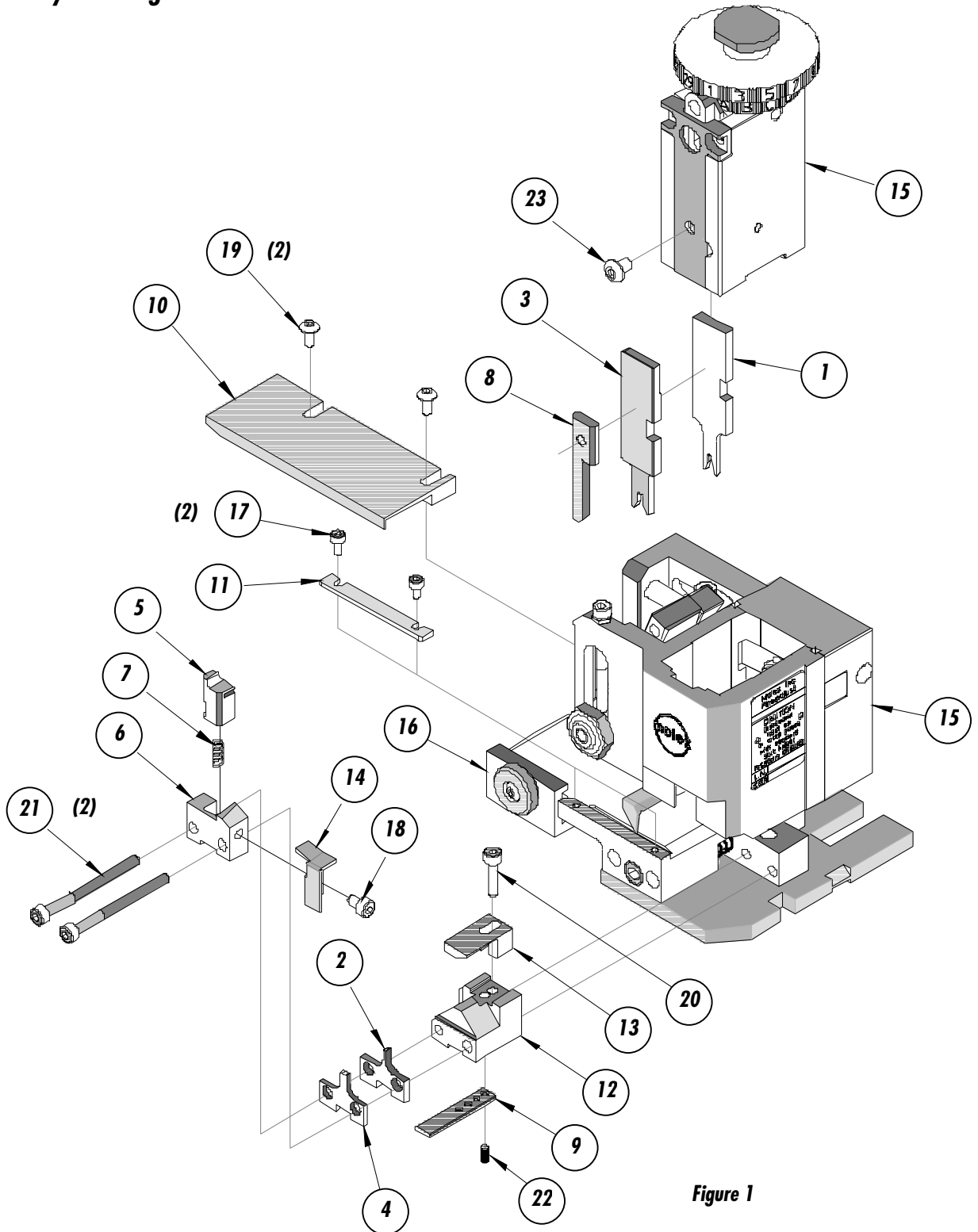


Figure 1

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.*

Molex Application Tooling Group
1150 E. Diehl Road
Naperville, IL 60563
Tel: (630) 969-4550
Fax: (630) 505-0049

Visit our Web site at <http://www.molex.com>