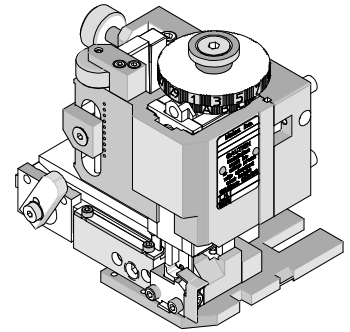




## FineAdjust Applicator Applicator Tooling Specification Sheet Order No. 63901-1100



### FEATURES

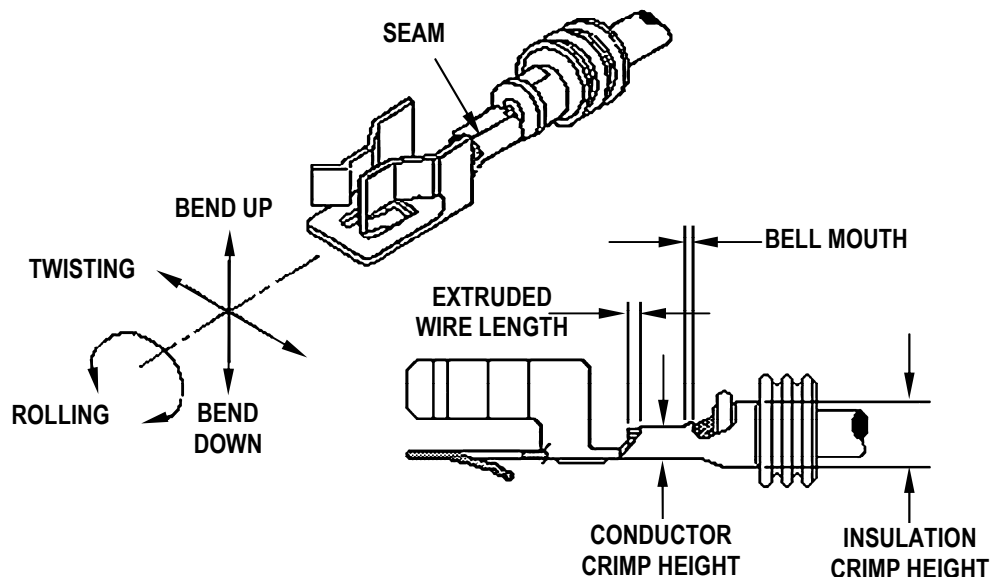
- Quick punch removal with the push of a button for fast and easy tooling change
- Applicator designed to industry standard mounting and shut height 135.80mm (5.346")
- Quick set-up time; plus the crimp height, track and feed adjustments can be set without removing the applicator from the press
- Fine 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: 14.50mm (0.57") Pitch Wedge Terminal, 0.50, 0.75, 0.85 metric and 20 AWG.

Terminal Series No.	Terminal Order No.	Wire Size		Insulation Diameter		Strip Length	
		AWG	mm <sup>2</sup>	mm	In.	mm	In.
35477	35477-9002		0.50	2.00-2.10	.079-.083	5.00-5.50	.197-.217
	35477-9002	20	0.56	2.00-2.10	.079-.083	5.00-5.50	.197-.217
	35477-9002		0.75	1.60-2.10	.063-.083	5.00-5.50	.197-.217
	35477-9002		0.85	2.20-2.30	.086-.091	5.00-5.50	.197-.217
Terminal will accommodate the following wire specification: AVS 0.50, AVS 0.75, 0.85 mm <sup>2</sup> or equivalent wires: 20 AWG GXL wire -7 strands.							

### 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.
35477	0.30-0.60	.012-.024	0.40	.016	0.30-0.80	.012-.031

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	
35477	3	3	3	5	2.05	.081	4.55	.179	

After crimping, the conductor profile should measure the following.

Terminal Series No	Wire Size		Conductor Crimp			
			Height		Width	
	AWG	mm <sup>2</sup>	mm	In.	mm	In.
35477		0.50	1.25-1.35	.049-.053	2.00-2.20	.079-.087
	20	0.56	1.25-1.35	.049-.053	2.00-2.20	.079-.087
		0.75	1.40-1.50	.055-.059	2.00-2.20	.079-.087
		0.85	1.45-1.55	.057-.061	2.00-2.20	.079-.087

Terminal Series No.	Wire Size		Insulation Crimp (Ref)				Pull Force Minimum	
			Height Maximum		Width			
	AWG	mm <sup>2</sup>	mm	In.	mm	In.	N	Lb.
35477		0.50	4.20	.165	4.40-4.60	.173-.181	88.2	19.84
	20	0.56	4.20	.165	4.40-4.60	.173-.181	88.2	19.84
		0.75	4.20	.165	4.40-4.60	.173-.181	107.9	24.25
		0.85	4.20	.165	4.40-4.60	.173-.181	127.5	28.66

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 63901-1100</b>				
<b>Item</b>	<b>Order No</b>	<b>Engineering No.</b>	<b>Description</b>	<b>Quantity</b>
<b>Perishable Tooling</b>				
	63901-1170	63901-1170	Tool Kit (All "Y" Items)	REF
1	63457-0022	63457-0022	Conductor Punch	1 Y
2	63455-0022	63455-0022	Conductor Anvil	1 Y
3	63454-0035	63454-0035	Insulation Punch	1 Y
4	63456-0030	63456-0030	Insulation Anvil	1 Y
5	63443-0035	63443-0035	Cut-Off Plunger	1 Y
6	63443-0049	63443-0049	Front Plunger Retainer	1 Y
<b>Other Components (REF 011150)</b>				
7	11-18-4083	60707-8	Feed Guide	1
8	63443-0009	63443-0009	Scrap Chute	1
9	63443-0024	63443-0024	Key	1
10	63443-0090	63443-0090	Wire Stop	1
11	63443-1720	63443-1720	19.00mm Height Spacer	1
12	63443-2207	63443-2207	7.00mm Coarse Spacer	2
13	63443-2308	63443-2308	3.40mm Fine Spacer	1
14	63700-0539	63700-0539	Cut-off Plunger Spring	1
15	63443-6140	63443-6140	Rear Cover	1
16	63866-9008	63866-9008	Front Plunger Striker	1
17	63866-9017	63866-9017	★ Checking Aid	REF
<b>Frame</b>				
18	63800-4901	63800-4901	Top	1
19	63801-3281	63801-3281	Base	1
20	63801-4650	63801-4650	Track	1
<b>Hardware</b>				
21	N/A	N/A	M3 by 6 Long SHCS	2**
22	N/A	N/A	M3 by 6 Long FHCS	1**
23	N/A	N/A	M4 by 6 Long SHCS	2**
24	N/A	N/A	M4 by 12 Long BHCS	2**
25	N/A	N/A	M4 by 50 Long SHCS	2**
26	N/A	N/A	M5 by 12 Long SHCS	1**
27	N/A	N/A	#10-32 by 3/8" Long Flat Point SSS	1**
28	N/A	N/A	#10-32 Hex Jam Nut	1**

\*\* Available from an industrial supply company such as MSC (1-800-645-7270).

★ The Seal Locator Checking Aid 63866-9017 to be ordered separately if required.  
 (This item is not included with the Applicator and is shown for Reference purpose only)

### Assembly Drawing

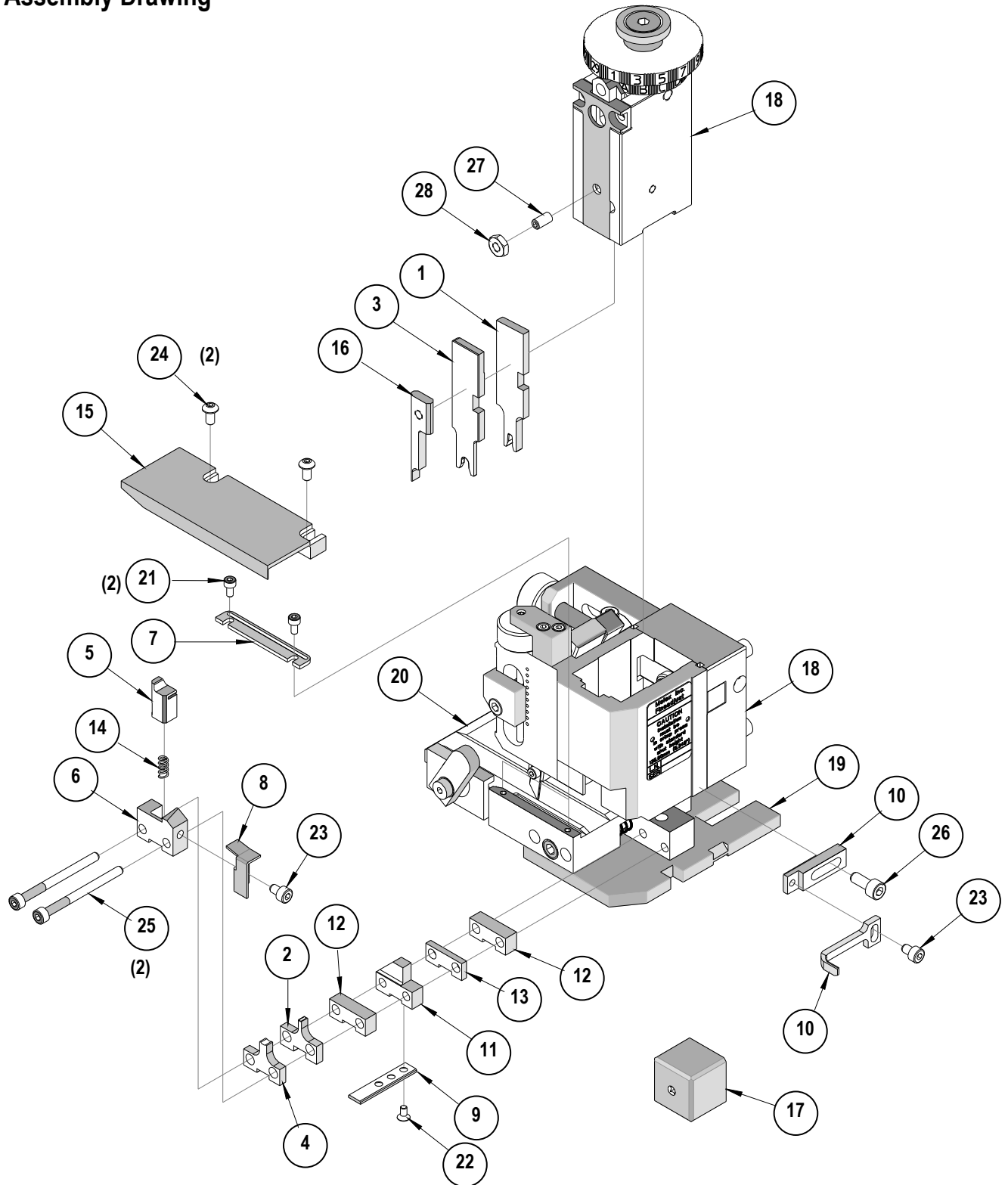


Figure 8

## 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 135.80 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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