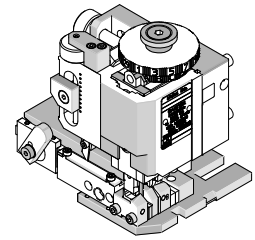




**FineAdjust  
Applicator**

**Application Tooling  
Specification Sheet**



**Order No. 63900-1500**

**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

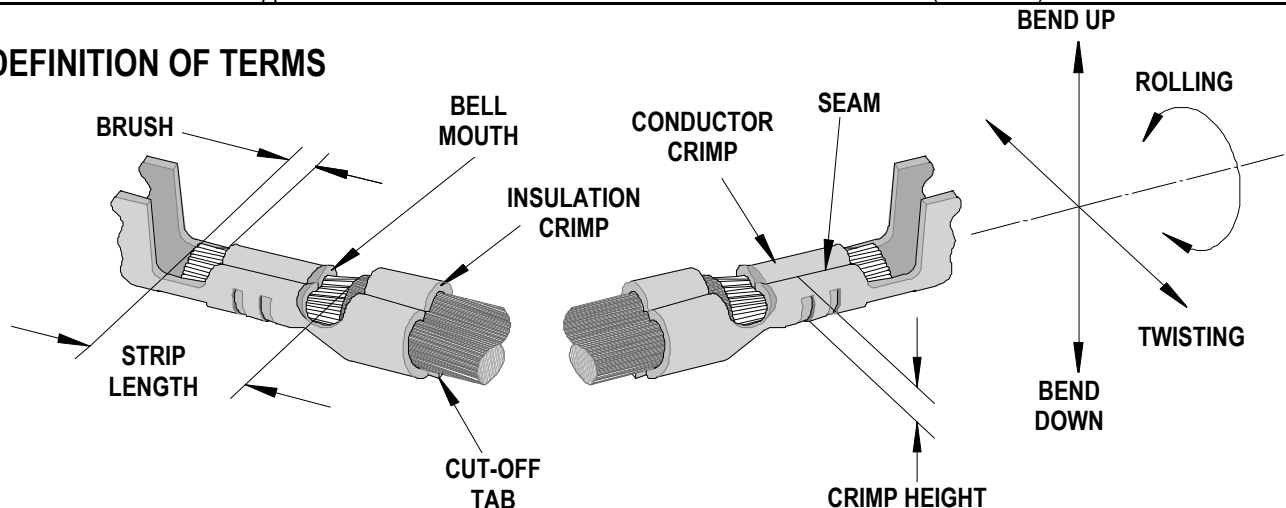
**SCOPE**

Products: SL™ Female Crimp Terminal, 24-30 AWG.

Terminal Series No	Terminal Order No.			Wire Size		* Insulation Diameter		Strip Length	
				AWG	mm <sup>2</sup>	mm	In.	mm	In.
70058	016-02-0069	016-02-0137	70058-0069	24-30	0.20-0.05	0.63-1.00	.025-.039	3.17-3.56	.125-.140
	016-02-0082	016-02-0139	70058-0082						
	016-02-0083	016-02-0150	70058-0083						
			70058-4069						
71851	016-02-0119	016-02-1113	71851-0119	24-30	0.20-0.05	0.63-1.00	.025-.039	3.17-3.56	.125-.140
	016-02-1112								

The Insulation Diameter specification for the terminals listed, is 1.01-1.52mm (.040-.060")  
 \* This Applicator will crimp small wire insulation diameter below the terminals specification limits.  
 Applicator 63900-3100 should be used for insulation OD 1.01-1.52mm (.040-.060").

**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	
			Front		Rear			
	mm	In.	mm	In.	mm	In.	mm	In.
70058	0.20-0.50	.008-.020	0.13	.005	.08	.003	0.00-1.00	.000-.039
71851	0.20-0.50	.008-.020	0.13	.005	.08	.003	0.00-1.00	.000-.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	mm	In			
70058	3	3	3	8	1.00	.039	1.40	.055	
71851	3	3	3	8	1.00	.039	1.40	.055	

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.
70058	24	0.20	0.79-0.84	.031-.033	22.2	5.0
	26	0.12	0.74-0.79	.029-.031	13.3	3.0
	28	0.08	0.71-0.76	.028-.030	8.9	2.0
	30	0.05	0.66-0.71	.026-.028	6.7	1.5
71851	24	0.20	0.79-0.84	.031-.033	22.2	5.0
	26	0.12	0.74-0.79	.029-.031	13.3	3.0
	28	0.08	0.71-0.76	.028-.030	8.9	2.0
	30	0.05	0.66-0.71	.026-.028	6.7	1.5

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 63900-1500</b>				
<b>Item</b>	<b>Order No</b>	<b>Engineering No.</b>	<b>Description</b>	<b>Quantity</b>
<b>Perishable Tooling</b>				
	63900-1570	63900-1570	Tool Kit (All "Y" Items)	REF
1	63444-1018	63444-1018	Conductor Punch	1 Y
2	63445-1031	63445-1031	Conductor Anvil	1 Y
3	63454-0112	63454-0112	Insulation Punch (Overlap)	1 Y
4	63445-1425	63445-1425	Insulation Anvil	1 Y
5	63443-0003	63443-0003	Cut-Off Plunger	2 Y
6	63443-0012	63443-0012	Front Plunger Retainer	1 Y
7	63443-1402	63443-1402	Cut-off Die Blade	1 Y
8	63443-1002	63443-1002	Rear Plunger Retainer	1 Y
<b>Other Components</b>				
9	11-17-0022	1739-21	Hold Down Spring	1
10	11-18-4094	60709A111	Front Cover	1
11	11-24-1067	4996-4	Cut-Off Plunger Spring	2
12	11-24-1149	4996-37	Shank	1
13	11-40-4274	8331-8	Hold Down Blade	1
14	63443-0025	63443-0025	Dual Carrier Key	1
15	63443-0090	63443-0090	Wire Stop	1
16	63443-2600	63443-2600	Front Spacer	1
17	63443-2205	63443-2205	5.0mm Spacer	1
18	63443-2306	63443-2306	3.30mm Spacer	1
19	63443-2801	63443-2801	Cut-Off Plunger Striker	1
20	63443-2907	63443-2907	Wire Hold-Down Plunger	1
21	63443-3060	63443-3060	Rear Plunger Striker	1
22	63443-6111	63443-6111	Rear Cover	1
23	63600-0021	63600-0021	Compression Spring	1
24	63860-2015	63860-2015	Drag Frame	1
<b>Frame</b>				
25	63800-4901	63800-4901	Top	1
26	63801-3281	63801-3281	Base	1
27	63801-4650	63801-4650	Track	1
<b>Hardware</b>				
28	N/A	N/A	M3 by 6 Long SHCS	2**
29	N/A	N/A	M3 by 6 Long FHCS	1**
30	N/A	N/A	M4 by 6 Long SHCS	1**
31	N/A	N/A	M4 by 10 Long SHCS	2**
32	N/A	N/A	M4 by 12 Long BHCS	2**
33	N/A	N/A	M4 by 50 Long SHCS	2**
34	N/A	N/A	M5 by 12 Long SHCS	1**
35	N/A	N/A	#5-40 by 3/8" Long SHCS	1**
36	N/A	N/A	#10-32 by 3/8" Long SSS	1**
37	N/A	N/A	#10-32 Hex Nut	1**

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

### Assembly Drawing

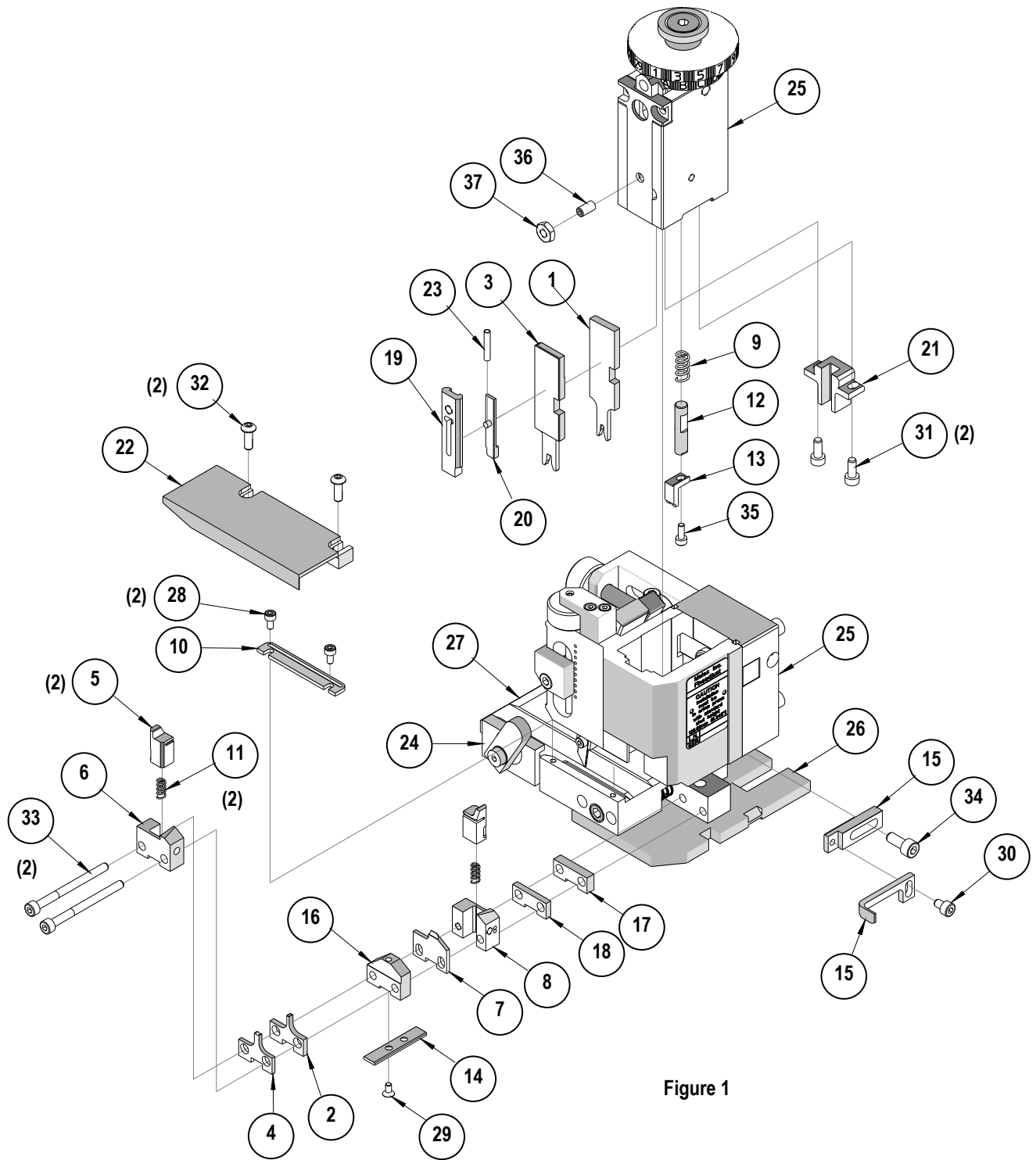


Figure 1

## 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.

<http://www.molex.com>