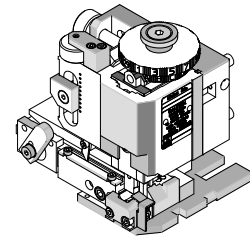




**FineAdjust
Applicator**

**Application Tooling
Specification Sheet**



Order No. 63901-9400

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

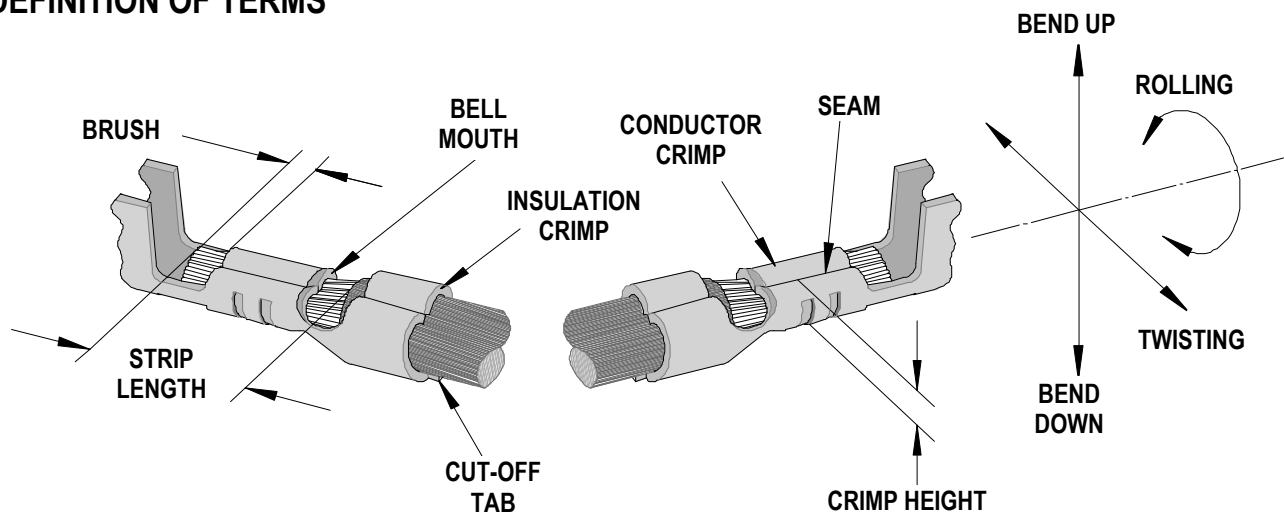
SCOPE

Products: 1.00mm (.039") Pitch Pico-Clasp™ Wire-to-Board Crimp Terminal, 28-32 AWG.

Terminal Series No.	Terminal Order No.			Wire Size		Insulation Diameter Maximum ♦		Strip Length	
				AWG	mm ²	mm	In.	mm	In.
501193	501193-2000	501193-3000	501193-0099	28-32	.086-.031	0.80	.031	1.00-1.30	.039-.051
501334	501334-0000			28-32	.086-.031	0.80	.031	1.00-1.30	.039-.051

♦ For optimum insulation crimp, use wire diameter below .69mm / .027"

DEFINITION OF TERMS



The above terminal drawing is a generic terminal representation. It is not an image of any terminal listed in the scope.

CRIMP SPECIFICATION

Terminal Series No.	Bell mouth		Cut-off Tab Maximum		Conductor Brush	
	mm	In.	mm	In.	mm	In.
501193	0.05-0.30	.002-.012	0.10	.004	0.10-0.50	.004-.020
501334	0.05-0.30	.002-.012	0.10	.004	0.10-0.50	.004-.020

Terminal Series No.	Bend up	Bend down	Twist	Roll	Punch Width (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	mm	In	
501193	3	3	3	6	0.70	.028	0.75	.030	
501334	3	3	3	6	0.70	.028	0.75	.030	

After crimping, the crimp profiles should measure the following:

Terminal Series No.	Wire Size		Crimp Height				Pull Force Minimum	
			Conductor		Insulation (Ref)			
	AWG	mm ²	mm	In.	mm	In.	N	Lb.
501193	28	.086	0.44-0.48	.017-.019	1.00	.039	9.8	2.20
	30	.055	0.41-0.45	.016-.018	0.95	.037	4.9	1.10
	32	.031	0.39-0.43	.015-.017	0.90	.035	3.4	0.76
501334	28	.086	0.44-0.48	.017-.019	1.00	.039	9.8	2.20
	30	.055	0.41-0.45	.016-.018	0.95	.037	4.9	1.10
	32	.031	0.39-0.43	.015-.017	0.90	.035	3.4	0.76

★ 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.
3. Using the oiler (63890-0719) when crimping gold-plated terminals is recommended. See 63800-4900 FineAdjust Manual.

PARTS LIST

FineAdjust Applicator 63901-9400				
Item	Order No	Engineering No.	Description	Quantity
Perishable Tooling				
	63901-9470	63901-9470	Tool Kit (All "Y" Items)	REF
1	63444-0705	63444-0705	Conductor Punch	1 Y
2	63445-0718	63445-0718	Anvil	1 Y
3	63454-0115	63454-0115	Insulation Punch	1 Y
4	63443-0003	63443-0003	Cut-Off Plunger Front	1 Y
5	63443-0012	63443-0012	Plunger Retainer Front	1 Y
Other Components				
6	11-18-4083	60707-8	Feed Guide	1
7	11-24-1067	4996-4	Cut-off Plunger Spring	1
8	63443-0009	63443-0009	Scrap Chute Front	1
9	63443-0021	63443-0021	Lower Tooling Key	1
10	63443-2516	63443-2516	Anvil Mount	1
11	63443-2805	63443-2805	Front Plunger Striker	1
12	63443-2903	63443-2903	Wire Hold Down Plunger	1
13	63443-4029	63443-4029	Wire Stop	1
14	63443-6001	63443-6001	Rear Cover	
15	63600-0021	63600-0021	Wire Hold Down Spring	1
Frame				
16	63800-4901	63800-4901	Top	1
17	63801-3281	63801-3281	Base	1
18	63801-4650	63801-4650	Track	1
Hardware				
19	N/A	N/A	M3 by 6 Long SHCS	2**
20	N/A	N/A	M4 by 6 Long SHCS	1**
21	N/A	N/A	M4 by 12 Long BHCS	2**
22	N/A	N/A	M4 by 16 Lg SHCS	1**
23	N/A	N/A	M4 by 50 Long SHCS	2**
24	N/A	N/A	3MM by 6 Long Roll Pin	1**
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

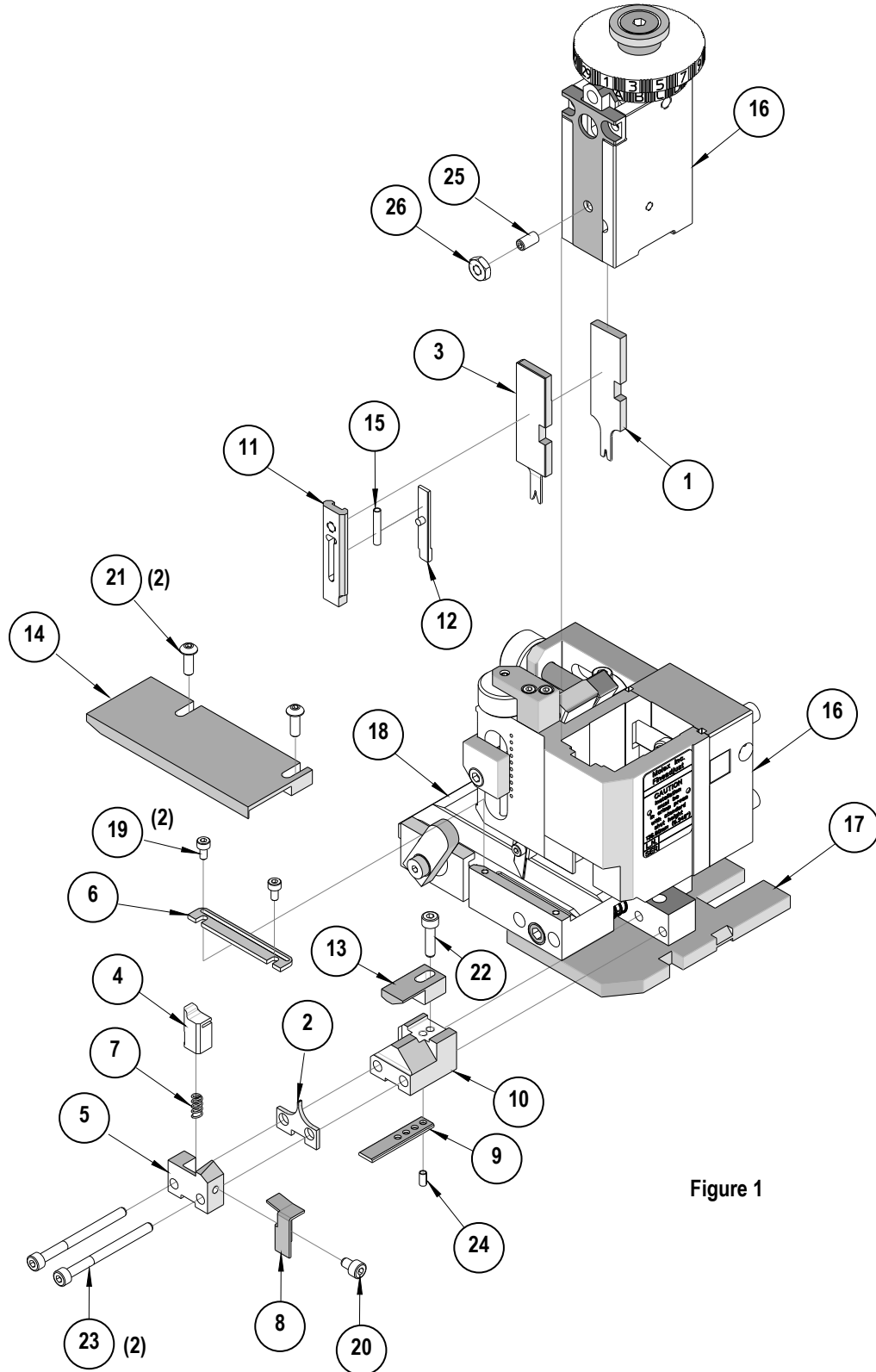


Figure 1

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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