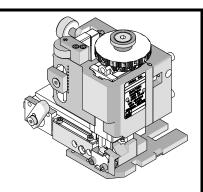


# FineAdjust Applicator Specification Sheet Order No. 63901-1900



### **FEATURES**

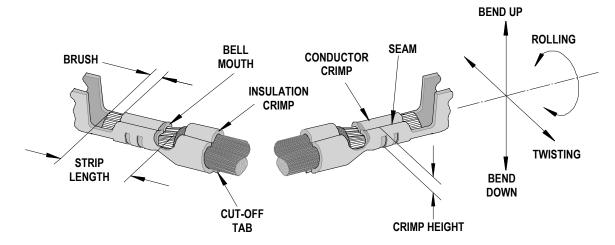
- Directly adapts to most automatic wire processing machines
- Quick punch removal with the push of a button for fast and easy tooling change
- Applicator designed to industry standard mounting and shut height 135.80mm (5.346")
- Quick set-up time; plus the crimp height, track and feed adjustments can 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

<u>Products:</u> Wire to Motor Connector Crimp Terminals, 0.30-0.50mm<sup>2</sup>.

Terminal Series No.		Wire Size			Insulation	Strip Length				
	Terminal Order No.			IPC/WHMA-A620◆		Terminal <b>◆ ◆</b>		Strip Length		
		AWG	mm²	mm	ln.	mm	ln.	mm	ln.	
59323	59323-8000	N/A	0.30-0.50	1.40-1.80	.055071	1.10-1.90	.043075	2.00-2.60	.079102	
◆ To achieve optimum IPC-A620 insulation crimps, use this insulation OD range.										
	♦ ◆ Overall insulation OD specification for terminal.									

#### **DEFINITION OF TERMS**



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

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### **CRIMP SPECIFICATION**

Terminal Series No.	Bell n	nouth	Cut-off Tab Maximum			Conductor Brush		
Terminal Series No.	Mm	ln.	mm	ln.	mm	ln.		
59323	0.10-0.50	.004020	0.30	.012	0.00-1.00	0.00039		

	Rand un	Twist Roll -		Punc	h Widt	th mm (Ref)		Seam		
Terminal Series No.	Bend up Bend down			Conductor		Insulation		Seam shall not be open		
	Degree			mm	ln	mm	ln	and no wire allowed out		
59323	4 4		4	10	1.60	.063	2.00	.079	of the crimping area	

After crimping, the conductor profile should measure the following.

Tarminal			Wire Type		Pull Force				
Terminal Series No.	Wire Size	mm²		Crimp	Height	Crimp Wi	Minimum		
Selles No.				mm	ln.	mm	ln.	N	Lb.
		0.30	AVSS	0.94-0.99	.037039	1.60	.063	49.0	11.0
59323		0.30	CAVUS	0.94-0.99	.037039	1.60	.063	49.0	11.0
39323		0.30	AVS	0.94-0.99	.037039	1.60	.063	49.0	11.0
		0.50	CAVS	0.99-1.09	.039043	1.60	.063	49.0	11.0

Tarminal	Wire Size	mm²	Wire Type	Insulation					
Terminal Series No.				Crimp He	ight (Ref.)	Crimp Width (Ref.)			
Series No.				mm	ln.	mm	ln.		
		0.30	AVSS	1.90	.075	2.00	.079		
59323		0.30	CAVUS	1.90	.075	2.00	.079		
39323		0.30	AVS	2.05	.081	2.00	.079		
		0.50	CAVS	2.10	.083	2.00	.079		

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

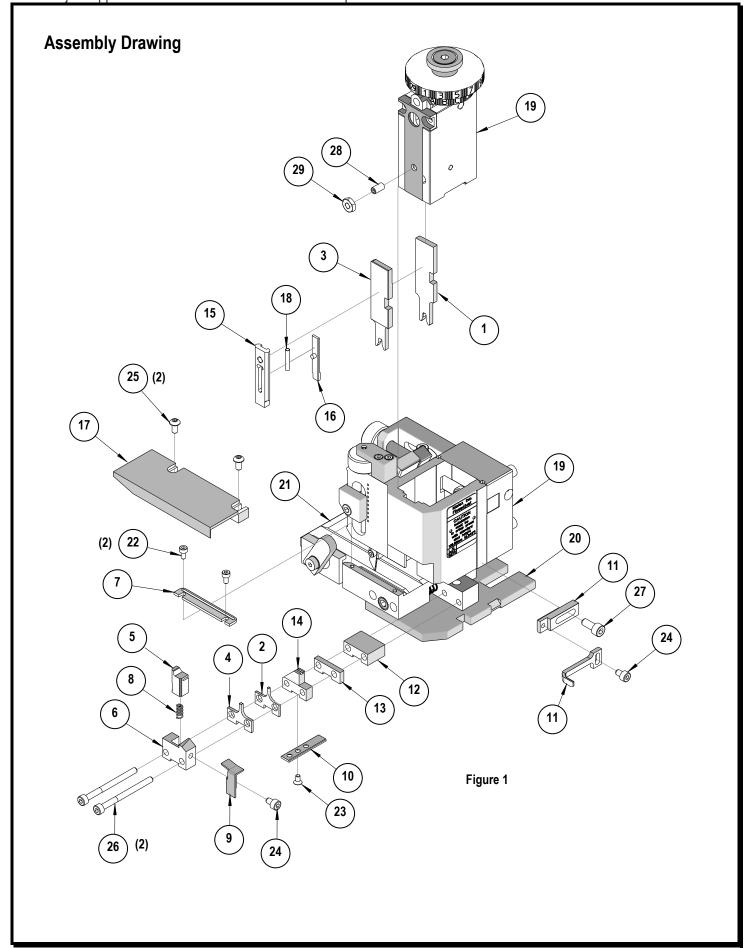
The above specifications are guidelines to an optimum crimp.

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## **PARTS LIST**

	FineAdjust Applicator 63901-1900									
Item	Order No	Engineering No.	Description	Quantity						
		Perish	nable Tooling							
	63901-1970	63901-1970	Tool Kit (All "Y" Items)	REF						
1	63444-1622	63444-1622	Conductor Punch	1 Y						
2	63445-1657	63445-1657	Conductor Anvil	1 Y						
3	63446-2038	63446-2038	Insulation Punch	1 Y						
4	63445-2006	63445-2006	Insulation Anvil	1 Y						
5	63443-0003	63443-0003	Front Cut-Off Plunger	1 Y						
6	63443-0012	63443-0012	Front Plunger Retainer	1 Y						
		Other Compo	onents(REF 011950)							
7	11-18-4083	60707-8	Feed Guide	1						
8	11-24-1067	4996-4	Cut-Off Plunger Spring	1						
9	63443-0009	63443-0009	Front Scrap Chute	1						
10	63443-0024	63443-0024	Key	1						
11	63443-0090	63443-0090	Wire Stop	1						
12	63443-2217	63443-2217	17.0mm Coarse Spacer	1						
13	63443-2318	63443-2318	3.90mm Fine Spacer	1						
14	63443-2601	63443-2601	19.0mm Height Spacer	1						
15	63443-2801	63443-2801	Front Plunger Striker	1						
16	63443-2907	63443-2907	Wire Hold Down Plunger	1						
17	63443-6111	63443-6111	Rear Cover	1						
18	63600-0021	63600-0021	Wire Hold Down Spring	1						
			Frame							
19	63800-4901	63800-4901	Тор	1						
20	63801-3281	63801-3281	Base	1						
21	63801-4650	63801-4650	Track Assembly	1						
		H	lardware							
22	N/A	N/A	M3 by 6 Long SHCS	2**						
23	N/A	N/A	M3 by 6 Long FHCS	1**						
24	N/A	N/A	M4 by 6 Long SHCS	2**						
25	N/A	N/A	M4 by 12 Long BHCS	2**						
26	N/A	N/A	M4 by 50 Long SHCS	2**						
27	N/A	N/A	M5 by 12 Lg SHCS	1**						
28	N/A	N/A	#10-32 by 3/8"Long Flat Point SSS	1**						
29	N/A	N/A	#10-32 Hex Jam Nut	1**						
*:	** Available from an industrial supply company such as MSC (1-800-645-7270).									

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#### **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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