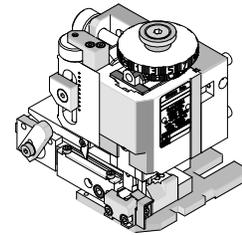


**FineAdjust
Applicator**



**Application Tooling
Specification Sheet**



Order No. 63902-8200

FEATURES

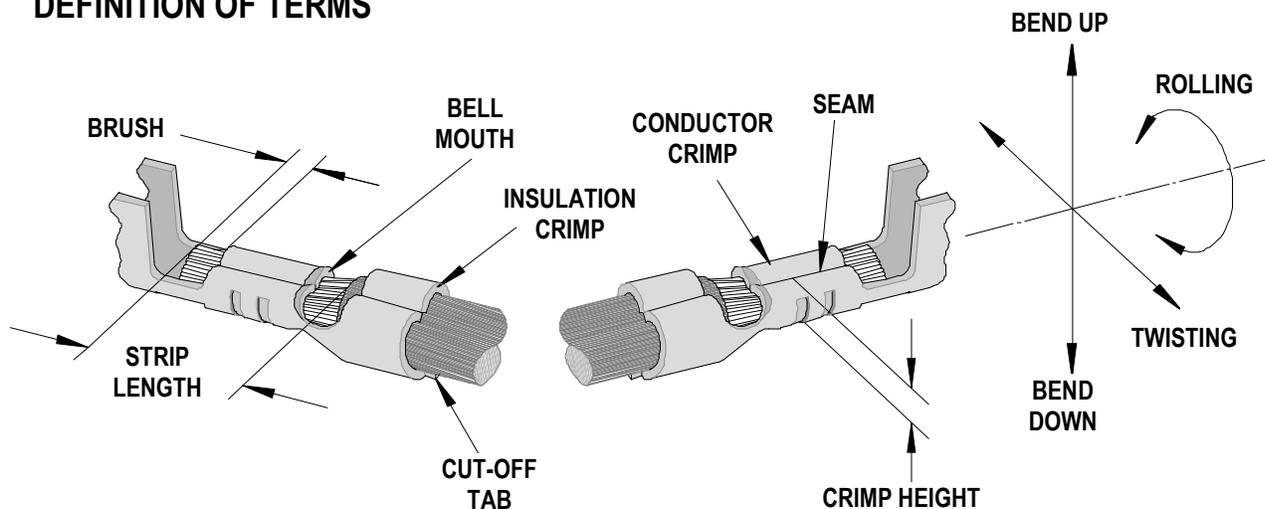
- Quick punch removal with the push of a button for fast and easy tooling change
- Applicator designed to industry standard mounting and shut height 135.80mm (5.346")
- Quick set-up time; plus the crimp height, track and feed adjustments can be set without removing the applicator from the press
- Fine 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: 2.50mm (.098") Pitch SPOX™ Female Crimp Terminal, 22 - 24 AWG, UL1007 Wire.

Terminal Series No.	Terminal Order No.	Wire Size		Insulation Diameter		Strip Length	
		AWG	mm ²	mm	In.	mm	In.
46626	46626-0100	22 - 24	0.35-0.20	1.40-1.70	.055-.067	2.00-2.60	.079-.102

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.
46626	0.10-0.40	.004-.016	0.30	.012	0.10-0.70	.004-.028

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 (Max)		Degree (Max)		Conductor		Insulation		
					mm	In	mm	In	
46626	3	3	4	8	1.40	.055	1.90	.075	

After crimping, the conductor profile should measure the following.

Terminal Series No.	Wire Size		Conductor Crimp Height		Conductor Crimp Width (Ref)		Pull Force Minimum	
	AWG	mm ²	mm	In.	mm	In.	N	Lb.
46626	22	0.35	0.77-0.85	.030-.033	1.40	.055	35.6	8.0
	24	0.20	0.71-0.80	.028-.031	1.40	.055	22.3	5.0

Terminal Series No.	Wire Size		Insulation Crimp Height (Max)		Insulation Crimp Width (Max)	
	AWG	mm ²	mm	In.	mm	In.
46626	22	0.35	2.30	.091	2.00	.079
	24	0.20	2.00	.079	2.00	.079

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

FineAdjust Applicator 63902-8200				
Item	Order No	Engineering No.	Description	Quantity
Perishable Tooling				
	63902-8270	63902-8270	Tool Kit (All "Y" Items)	REF
1	63444-1413	63444-1413	Conductor Punch	1 Y
2	63445-1426	63445-1426	Conductor Anvil	1 Y
3	63446-1913	63446-1913	Insulation Punch	1 Y
4	63445-1924	63445-1924	Insulation Anvil	1 Y
5	63443-0002	63443-0002	Front Cut-Off Plunger	1 Y
6	63443-0012	63443-0012	Front Plunger Retainer	1 Y
Other Components				
7	11-18-4083	60707-8	Feed Guide	1
8	11-24-1067	4996-4	Cut-Off Plunger Spring	1
9	11-40-4039	8302-5	Plunger Striker	1
10	63443-0009	63443-0009	Front Scrap Chute	1
11	63443-0024	63443-0024	Key	1
12	63443-0090	63443-0090	Wire Stop	1
13	63443-1703	63443-1703	17.30mm Height Spacer	1
14	63443-2216	63443-2216	Coarse Spacer (16.00mm)	1
15	63443-2312	63443-2312	Fine Spacer (3.60mm)	1
16	63443-6111	63443-6111	Rear Cover	1
Frame				
17	63800-4901	63800-4901	Top	1
18	63801-3281	63801-3281	Base	1
19	63801-4650	63801-4650	Track	1
Hardware				
20	N/A	N/A	M3 by 6 Long SHCS	2**
21	N/A	N/A	M3 by 6 Long FHCS	1**
22	N/A	N/A	M4 by 6 Long SHCS	2**
23	N/A	N/A	M4 by 12 Long BHCS	2**
24	N/A	N/A	M4 by 50 Long SHCS	2**
25	N/A	N/A	M5 by 12 Long SHCS	1**
26	N/A	N/A	#10-32 by 3/8" Long Flat Point SSS	1**
27	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

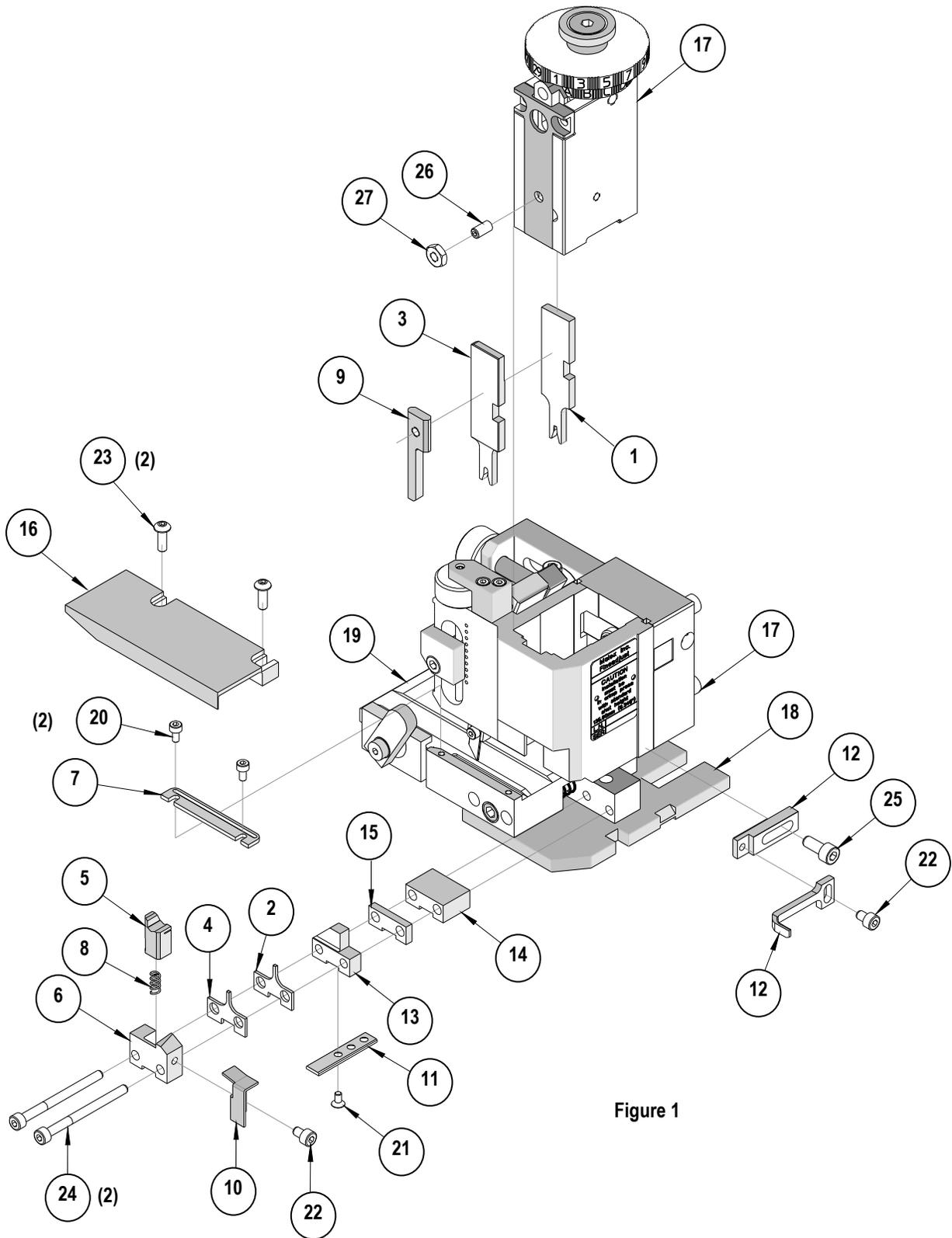


Figure 1

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 135.8 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.

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