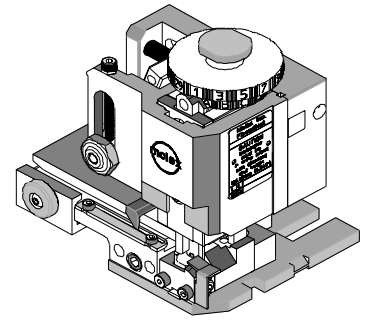




FineAdjust Applicator Specification Sheet Part No. 63866-9000



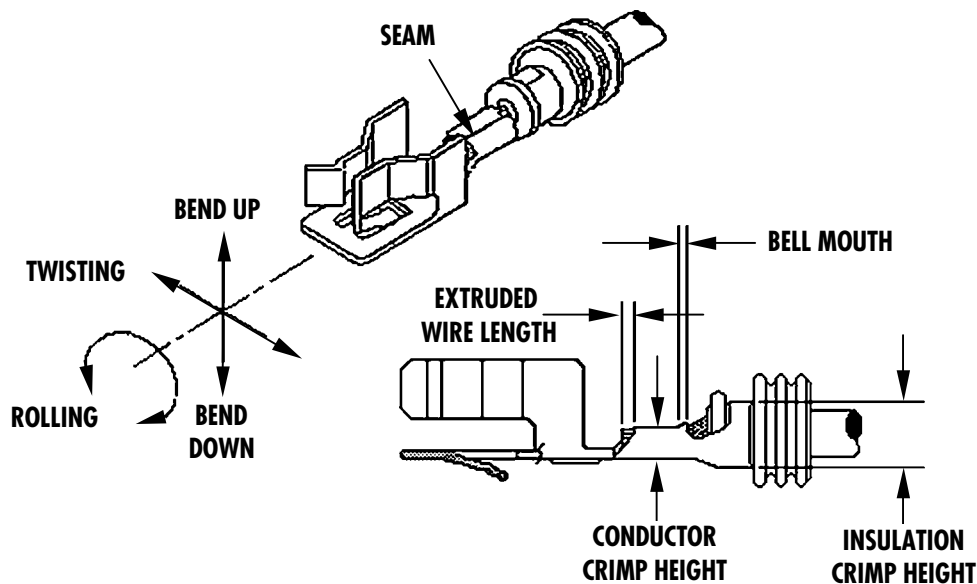
FEATURES

- 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 0.15mm (.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

Terminal Series No.	Wire Size		Insulation Diameter		Strip Length	
	AWG	mm ²	mm	In.	mm	In.
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
Terminal will accommodate the following wire specification: AVS 0.50 mm ² 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 Max.		Conductor Brush	
	mm	In.	mm	In.	mm	In.
35477-9002	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	
35477-9002	3	3	3	5	2.05	.081	4.55	.179	

After crimping, the conductor profile should measure the following.

Terminal Part No.	Wire Size		Conductor Crimp			
			Height		Width	
	AWG	mm ²	mm	In.	mm	In.
35477-9002		0.50	1.25-1.35	.049-.053	2.00-2.20	.079-.087
35477-9002	20	0.56	1.25-1.35	.049-.053	2.00-2.20	.079-.087

Terminal Part No.	Wire Size		Insulation Crimp				Pull Force Min.	
			Height		Width			
	AWG	mm ²	mm	In.	mm	In.	N	Lb.
35477-9002		0.50	4.20 Max.	.165 Max.	4.40-4.60	.173-.181	88.2	19.84
35477-9002	20	0.56	4.20 Max.	.165 Max.	4.40-4.60	.173-.181	88.2	19.84

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

The above specifications are guidelines to an optimum crimp.

PARTS LIST

Item	Order No	Engineering No.	Description	Quantity
	63866-9000	63866-9000	FineAdjust Applicator (Fig. 1)	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
7	63700-0539	63700-0539	Cut-off Plunger Spring	1
8	63866-9008	63866-9008	Front Plunger Striker	1
9	63443-0021	63443-0021	Lower Tooling Key	1
10	63830-0113	63830-0113	Rear Cover	1
11	11-18-4083	60707-8	Front Cover	1
12	63866-9012	63866-9012	Anvil Mount	1
13	63443-4033	63443-4033	Wire Stop	1
14	63443-0009	63443-0009	Scrape Chute	1
15	63801-3100	63801-3100	Fine Adjust Applicator Frame	1
16	63821-0024	63821-0024	"L" Feed Finger	1
17	N/A	N/A	M3 by 6Lg. SHCS	2**
18	N/A	N/A	M4 by 6Lg. SHCS	1**
19	N/A	N/A	M4 by 12Lg. BHCS	2**
20	N/A	N/A	M4 by 16Lg SHCS	1**
21	N/A	N/A	M4 by 50Lg. SHCS	2**
22	N/A	N/A	3MM by 6Lg. Roll Pin	1**
23	N/A	N/A	#10-32 by 1/4"Lg. BHCS	1**
	63866-9070	63866-9070	Tool Kit (All Y Items)	REF

** The following purchased parts are available from an Industrial supply company such as MSC (1-800-645-7270).

Assembly Drawing

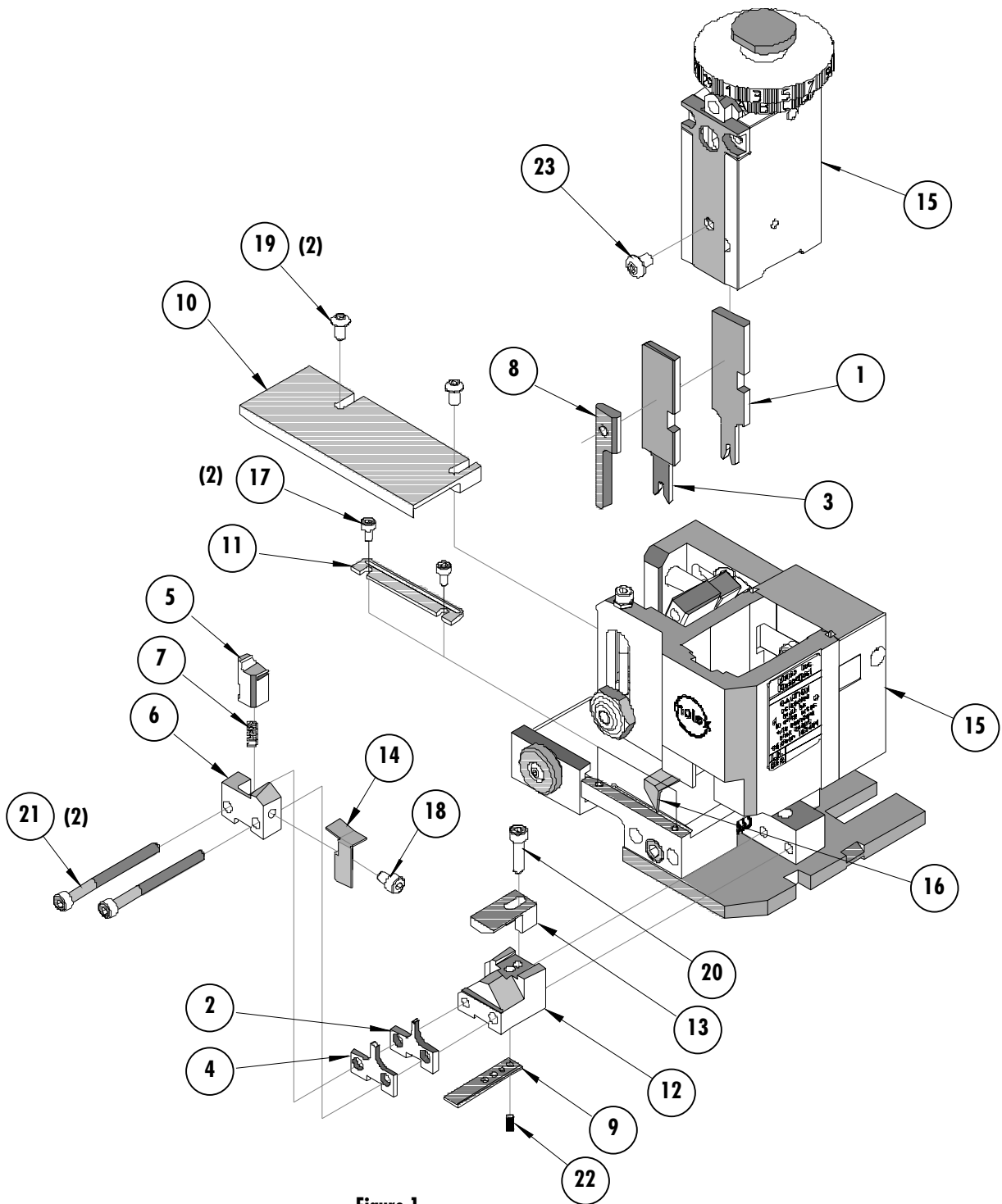


Figure 1

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.

Molex Application Tooling Group

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Visit our Web site at <http://www.molex.com>

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