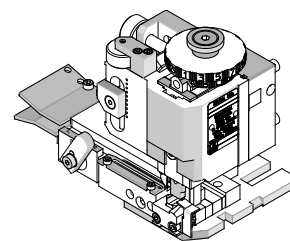


**FineAdjust
Applicator****molex****Application Tooling
Specification Sheet****Order No. 63904-0300****FEATURES**

- 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

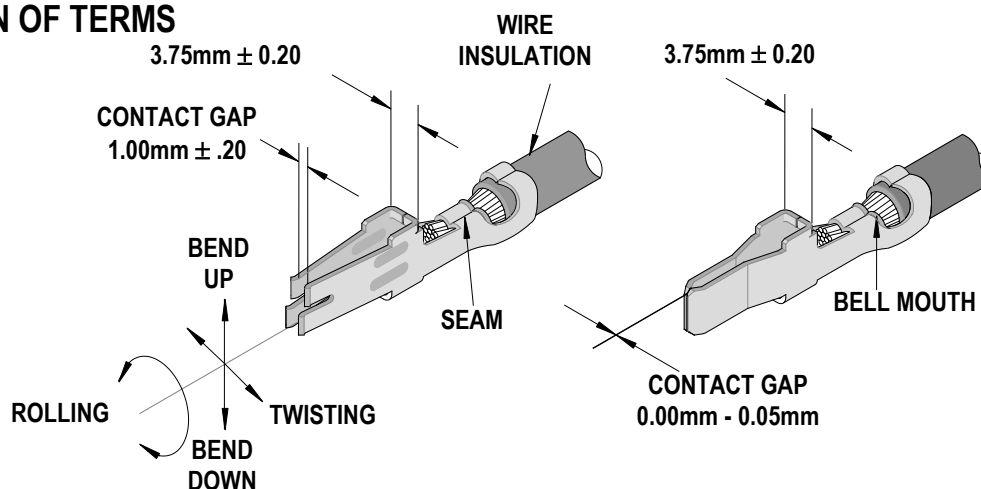
SCOPE

Products: Mini-Fit Sr.™ Male and Female Crimp Terminals, Metric Wire Crimping only.

Terminal Series No.	Terminal Order No.		Wire Size and Type		Insulation Diameter				Strip Length	
					IPC/WHMA-A620 (1)		Terminal (2)			
			mm²	Type	mm	In.	mm	In.	mm	In.
42815	42815-0010	42815-0011	6.0	37 strands of 0.45 diameter	4.00-4.20	.157-.165	3.50-5.30	.138-.209	7.5-8.5	.295-.355
	42815-0012	42815-0019	6.0	84 strands of 0.29 diameter						
			5.0	65 strands of 0.32 diameter						
42817	42817-0010	42817-0011	6.0	37 strands of 0.45 diameter	4.00-4.20	.157-.165	3.50-5.30	.138-.209	7.5-8.5	.295-.355
	42817-0012	42817-0019	6.0	84 strands of 0.29 diameter						
	42817-0110	42817-0111	6.0	84 strands of 0.29 diameter						
	42817-0112		5.0	65 strands of 0.32 diameter						

(1) To achieve optimum IPC-A620 insulation crimps, use this insulation OD range

(2) Overall insulation OD specification for terminal.

DEFINITION OF TERMS

CRIMP SPECIFICATIONS

Terminal Series No.	Bell mouth		Cut-off Tab Maximum		Conductor Brush	
	mm	In.	mm	In.	mm	In.
42815	.20-.50	.008-.020	.50	.020	3.50-4.50	.138-.177
42817	.20-.50	.008-.020	.50	.020	3.50-4.50	.138-.177

Terminal Series No.	Bend up Bend down		Twist Roll		Punch Width			
					Conductor		Insulation	
	Degree		Degree		mm	In	mm	In
42815	3	3	4	8	3.60	.142	5.30	.209
42817	3	3	4	8	3.60	.142	5.30	.209
Seam Seam shall not be open and no wire allowed out of the crimping area.								

After crimping, the conductor profile should measure the following.

Terminal Series No.	Wire Size and Type		Conductor				Pull Force Minimum	
			Crimp Height		Crimp Width (Ref)			
	mm²	Type	mm	In.	mm	In.	N	Lb.
42815	6.0	37 strands of 0.45 diameter	3.15-3.30	.124-.130	4.00	.157	355	80.0
	6.0	84 strands of 0.29 diameter	3.09-3.25	.122-.128	4.00	.157	355	80.0
	5.0	65 strands of 0.32 diameter	2.97-3.07	.117-.121	3.95	.156	311	70.0
42817	6.0	37 strands of 0.45 diameter	3.15-3.30	.124-.130	4.00	.157	355	80.0
	6.0	84 strands of 0.29 diameter	3.09-3.25	.122-.128	4.00	.157	355	80.0
	5.0	65 strands of 0.32 diameter	2.97-3.07	.117-.121	3.95	.156	311	70.0

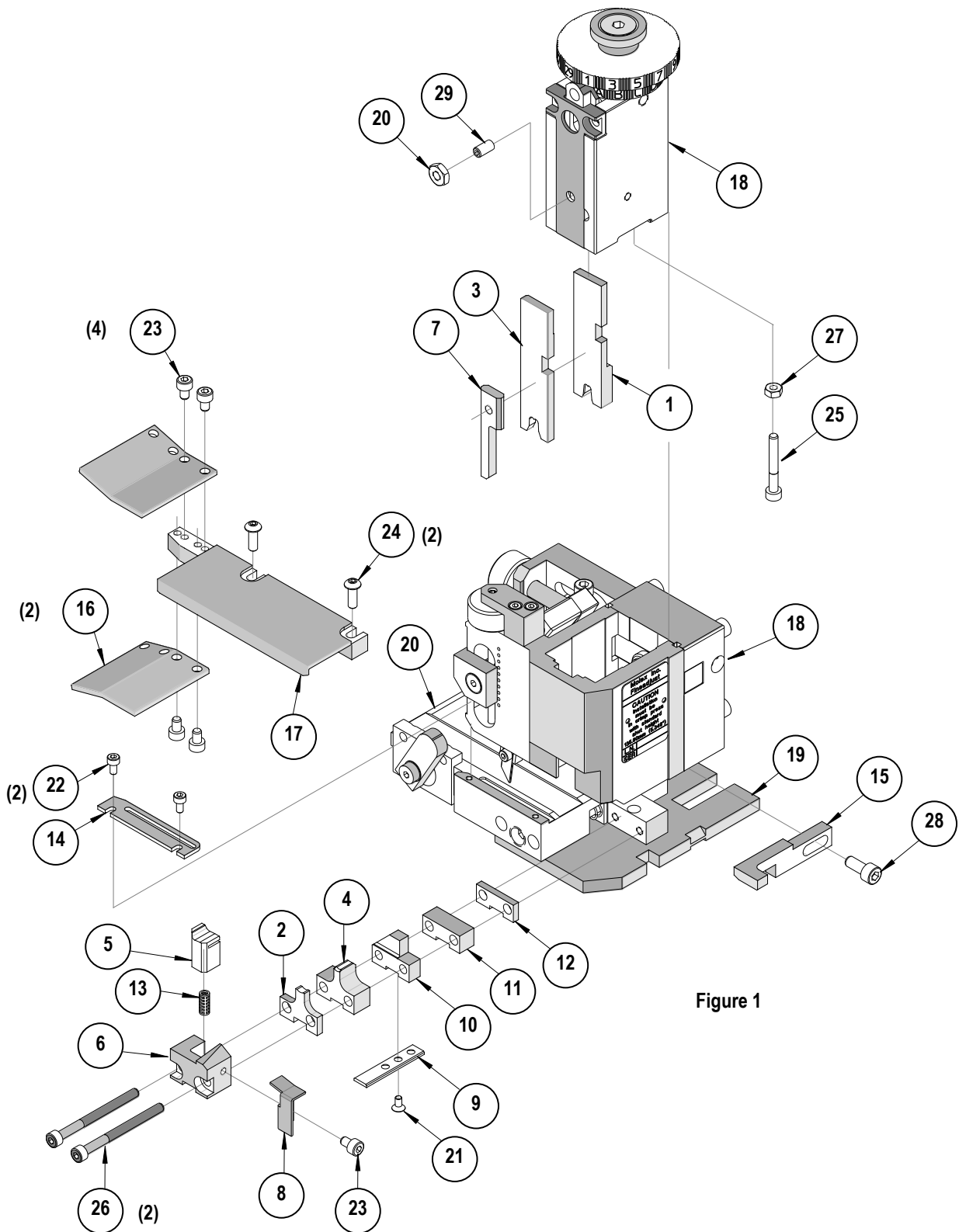
Tool Qualification Notes:

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 63904-0300				
Item	Order No	Engineering No.	Description	Quantity
Perishable Tooling				
	63904-0370	63904-0370	Tool Kit (All "Y" Items)	REF
1	63457-3601	63457-3601	Conductor Punch	1 Y
2	63895-3772	63895-3772	Conductor Anvil	1 Y
3	63446-5318	63446-5318	Insulation Punch	1 Y
4	63445-5309	63445-5309	Insulation Anvil	1 Y
5	63443-0045	63443-0045	Cut-Off Plunger Front	1 Y
6	63443-0046	63443-0046	Plunger Retainer Front	1 Y
Other Components				
7	11-40-4039	8302-5	Plunger Striker Front	1
8	63443-0009	63443-0009	Scrap Chute Front	1
9	63443-0024	63443-0024	Lower Tooling Key	1
10	63443-1715	63443-1715	Height Spacer (18.50mm)	1
11	63443-2209	63443-2209	Coarse Spacer (9.00mm)	1
12	63443-2305	63443-2305	Fine Spacer (3.25mm)	1
13	63700-0539	63800-0539	Cut-off Plunger Spring	
14	63821-0012	63821-0012	Front Cover	1
15	63821-0015	63821-0015	Wire Stop	1
16	63830-0117	63830-0117	Terminal Lead In	2
17	63830-0118	63830-0118	Rear Cover	1
Frame				
18	63800-4901	63800-4901	Top	1
19	63801-3281	63801-3281	Base	1
20	63801-4650	63801-4650	Track	1
Hardware				
21	N/A	N/A	M3 by 6 Long FHCS	1**
22	N/A	N/A	M3 by 6 Long SHCS	2**
23	N/A	N/A	M4 by 6 Long SHCS	5**
24	N/A	N/A	M4 by 12 Long BHCS	2**
25	N/A	N/A	M4 by 30 Long SHCS	1**
26	N/A	N/A	M4 by 55 Long SHCS	2**
27	N/A	N/A	M4 Hex Nut	1**
28	N/A	N/A	M5 by 12 Long SHCS	1**
29	N/A	N/A	#10-32 by 3/8" Long Flat Point SSS	1**
30	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



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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