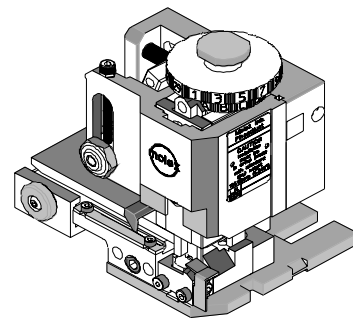




## FineAdjust Applicator Specification Sheet Part No. 63865-2000



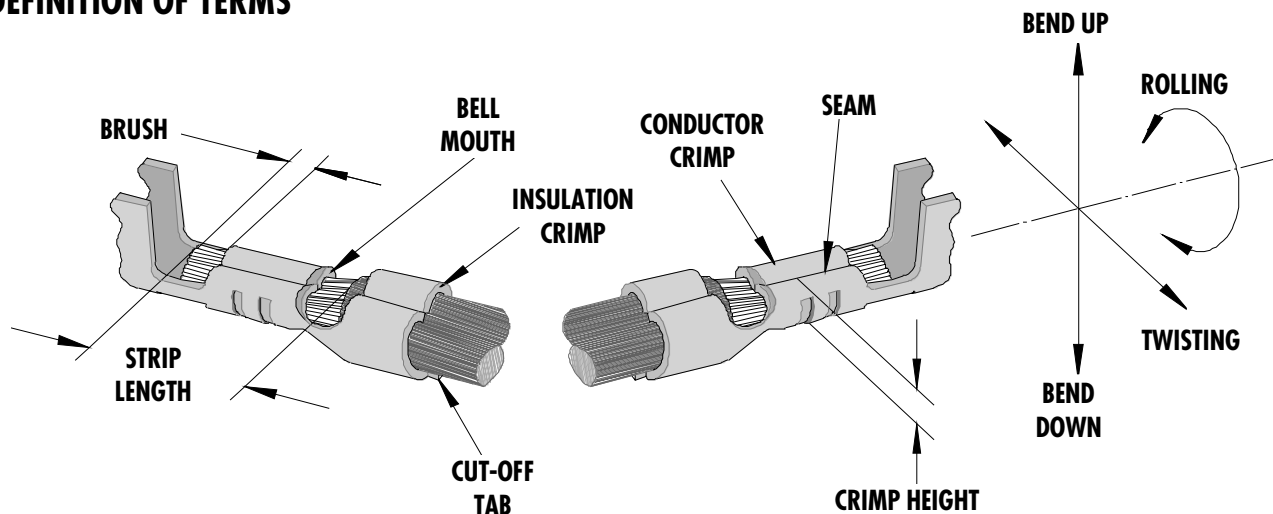
### FEATURES

- 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 <sup>2</sup> | mm                  | In.      | mm           | In.       |
| 90198-0002                                                                                                                                                 | 22 - 26   | 0.35-0.12       | 1.52 Max            | .060 Max | 2.00-2.50    | .079-.098 |
| <b>Terminal will accommodate the following wire specification:</b><br>22 AWG-Solid Wire or Fused Wire<br>24-26 AWG Solid Wire, Fused Wire or Stranded Wire |           |                 |                     |          |              |           |

### DEFINITION OF TERMS



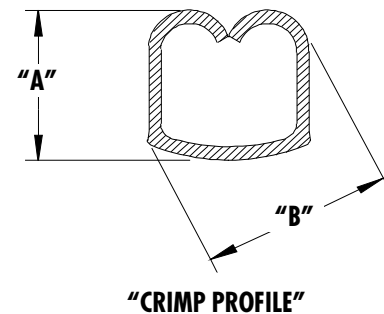
The above terminal drawing is a generic terminal representation. It is not an image of a terminal listed in the scope.

## CRIMP SPECIFICATION

| Terminal Series No. | Bell mouth |      | Cut-off Tab Max. |      | Conductor Brush |           |
|---------------------|------------|------|------------------|------|-----------------|-----------|
|                     | mm         | In.  | mm               | In.  | mm              | In.       |
| 90198-0002          | None       | None | 0.30             | .012 | 0.00-0.10       | .000-.004 |

| Terminal Series No. | Bend up    Bend down |     | Twist      Roll |     | Punch Width mm (Ref) |      |            |      | Seam<br>Seam shall not be open and<br>no wire allowed out<br>of the crimping area |
|---------------------|----------------------|-----|-----------------|-----|----------------------|------|------------|------|-----------------------------------------------------------------------------------|
|                     | Degree               |     | Degree          |     | Conductor            |      | Insulation |      |                                                                                   |
|                     |                      |     |                 |     | mm                   | In   | mm         | In   |                                                                                   |
| 90198-0002          | N/A                  | N/A | N/A             | N/A | 1.00                 | .039 | 1.80       | .070 |                                                                                   |

After crimping, the conductor profile should measure the following.



| Terminal Series No. | Wire Size |                 | "A" Crimp Height |          | "B" Diagonal Dim. |          | Pull Force Min. |     |
|---------------------|-----------|-----------------|------------------|----------|-------------------|----------|-----------------|-----|
|                     | AWG       | mm <sup>2</sup> | mm               | In       | mm                | In.      | N               | Lb. |
| 90198-0002          | 22        | 0.35            | 0.89 Ref         | .035 Ref | 1.19 Max          | .047 Max | 35.6            | 8.0 |
| 90198-0002          | 24        | 0.20            | 0.79 Ref         | .031 Ref | 1.14 Max          | .045 Max | 22.2            | 5.0 |
| 90198-0002          | 26        | 0.12            | 0.74 Ref         | .029 Ref | 1.14 Max          | .045 Max | 13.3            | 3.0 |

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   |
|------|-------------------|-------------------|---------------------------------------|------------|
|      | <b>63865-2000</b> | <b>63865-2000</b> | <b>FineAdjust Applicator (Fig. 1)</b> | <b>REF</b> |
| 1    | 63457-0013        | 63457-0013        | Conductor Punch                       | 1 Y        |
| 2    | 63445-1019        | 63445-1019        | Conductor Anvil                       | 1 Y        |
| 3    | 63454-0021        | 63454-0021        | Insulation Punch                      | 1 Y        |
| 4    | 63445-1834        | 63445-1834        | Insulation Anvil                      | 1 Y        |
| 5    | 63443-0003        | 63443-0003        | Cut-Off Plunger                       | 1 Y        |
| 6    | 63443-0012        | 63443-0012        | Front Plunger Retainer                | 1 Y        |
| 7    | 11-24-1067        | 4996-4            | Cut-off Plunger Spring                | 1          |
| 8    | 63443-3160        | 63443-3160        | Front Plunger Striker                 | 1          |
| 9    | 63443-0021        | 63443-0021        | Lower Tooling Key                     | 1          |
| 10   | 63443-6003        | 63443-6003        | Rear Cover                            | 1          |
| 11   | 11-18-4083        | 60707-8           | Front Cover                           | 1          |
| 12   | 63443-2405        | 63443-2405        | Anvil Mount                           | 1          |
| 13   | 63865-2005        | 63865-2005        | Wire Stop                             | 1          |
| 14   | 63443-0009        | 63443-0009        | Scrape Chute                          | 1          |
| 15   | 63800-4900        | 63800-4900        | Fine Adjust Applicator Frame          | 1          |
| 16   | 63443-0058        | 63443-0058        | Ejector Blade Assembly                | 1          |
| 17   | 63700-0223        | 63700-0223        | Ejector Blade Spring                  | 1          |
| 18   | N/A               | N/A               | M3 by 6Lg. SHCS                       | 2**        |
| 19   | N/A               | N/A               | M4 by 6Lg. SHCS                       | 1**        |
| 20   | N/A               | N/A               | M4 by 12Lg. BHCS                      | 2**        |
| 21   | N/A               | N/A               | M4 by 16Lg SHCS                       | 1**        |
| 22   | N/A               | N/A               | M4 by 20Lg. SHCS                      | 1**        |
| 23   | N/A               | N/A               | M4 by 50Lg. SHCS                      | 1**        |
| 24   | N/A               | N/A               | 3MM by 6Lg. Roll Pin                  | 1**        |
| 25   | N/A               | N/A               | #10-32 by 1/4"Lg. BHCS                | 1**        |
|      | <b>63865-2070</b> | <b>63865-2070</b> | <b>Tool Kit (All Y Items)</b>         | <b>REF</b> |

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

# Assembly Drawing

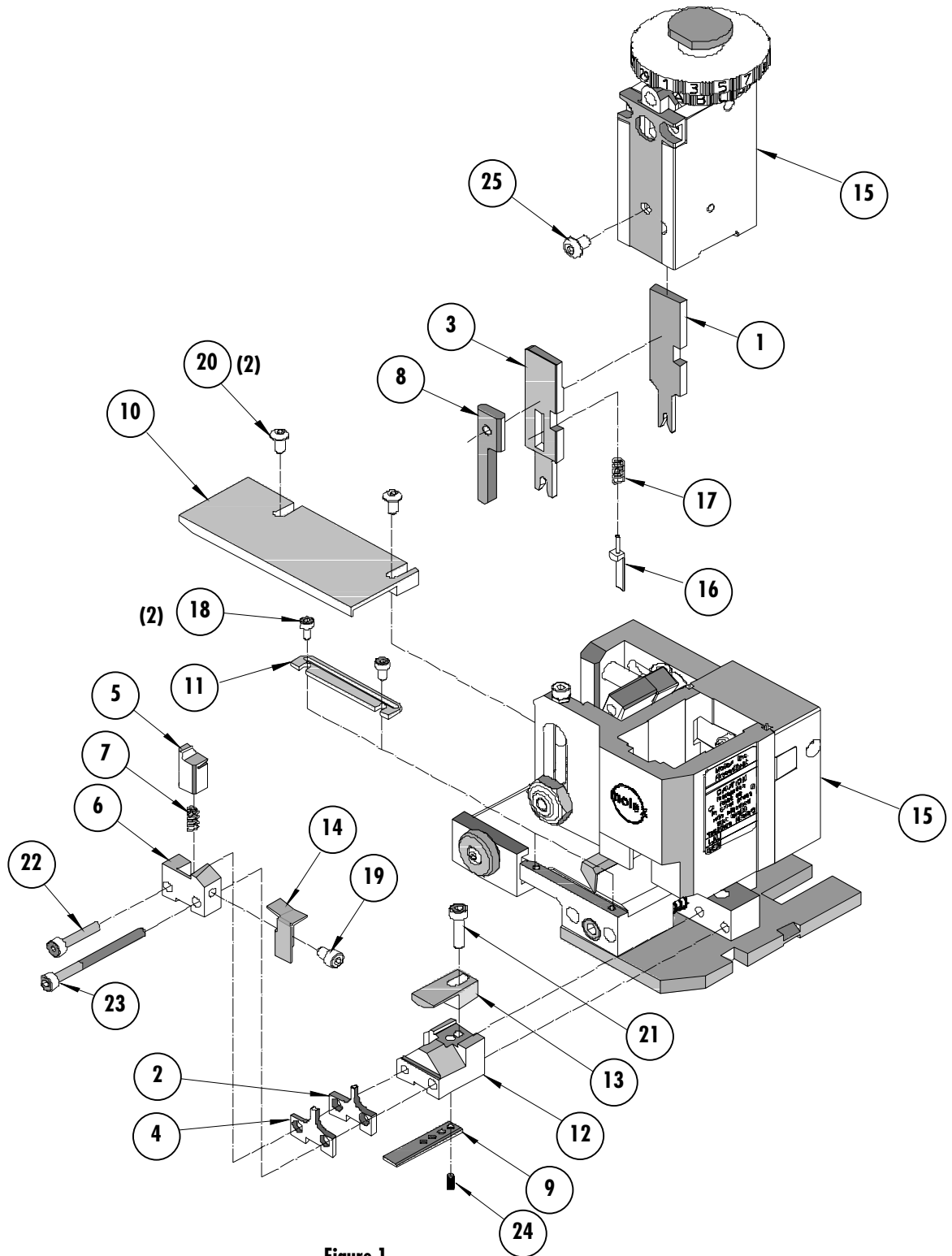


Figure 1

## 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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