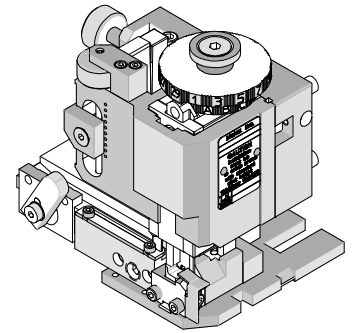




FineAdjust Applicator Specification Sheet Order No. 63865-5100



FEATURES

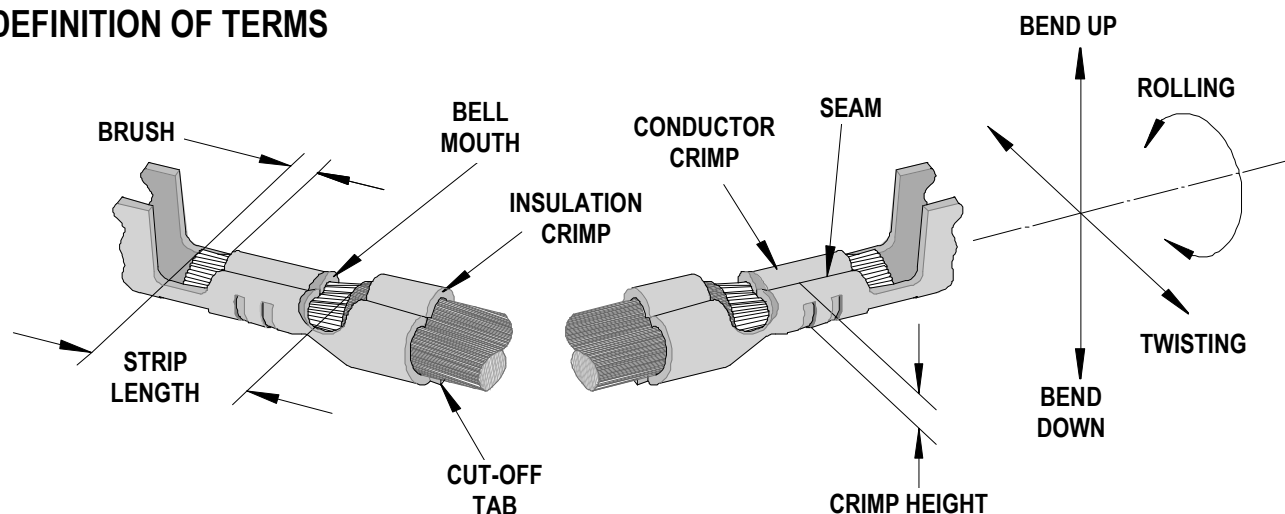
- Directly adapts to most automatic wire processing machines
- Quick punch removal with the push of a button for fast and easy tooling change
- Applicator designed to industry standard mounting and shut height 135.80mm (5.346")
- Quick set-up time; plus the crimp height, track and feed adjustments can 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: CRC™ (Compact Robot Connector) Shielded Rectangular I/O Crimp pins and sockets, 24-28 AWG.

Terminal Series No.	Terminal Order No.			Wire Size		Insulation Diameter Maximum		Strip Length	
				AWG	mm ²	mm	In.	mm	In.
56116	56116-8090	56116-8099	56116-8228	24-28	0.22-0.08	1.60	.063	2.70-3.20	.106-.126
	56116-8290	56116-8299							
56118	56118-8090	56118-8099	56118-8228	24-28	0.22-0.08	1.60	.063	2.70-3.20	.106-.126
	56118-8290	56118-8299							
56120	56120-8090	56120-8099	56120-8228	24-28	0.22-0.08	1.60	.063	2.70-3.20	.106-.126
	56120-8290	56120-8299	56120-8428						
	56120-8490	56120-8499	56120-8628						
	56120-8699	56120-8690							

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.
56116	0.10-0.60	.004-.024	0.25	.010	0.00-0.50	.000-.020
56118	0.10-0.60	.004-.024	0.25	.010	0.00-0.50	.000-.020
56120	0.10-0.60	.004-.024	0.25	.010	0.00-0.50	.000-.020

Terminal Series No.	Bend up Bend down		Twist Roll		Punch Width mm (Ref)				Seam
					Conductor		Insulation		
	Degree		Degree		mm	In	mm	In	
56116	4	3	4	8	1.20	.047	1.80	.070	Seam shall not be open and no wire allowed out of the crimping area
56118	4	3	4	8	1.20	.047	1.80	.070	
56120	4	3	4	8	1.20	.047	1.80	.070	

After crimping, the conductor profile should measure the following.

Terminal Series No.	Wire Size		Crimp Height		Pull Force Minimum	
	AWG	mm²	mm	In.	N	Lb.
56116	24	0.20	0.72-0.77	.028-.030	29.4	6.60
	26	0.12	0.67-0.72	.026-.028	19.6	4.40
	28	0.08	0.64-0.69	.025-.027	9.8	2.20
56118	24	0.20	0.72-0.77	.028-.030	29.4	6.60
	26	0.12	0.67-0.72	.026-.028	19.6	4.40
	28	0.08	0.64-0.69	.025-.027	9.8	2.20
56120	24	0.20	0.72-0.77	.028-.030	29.4	6.60
	26	0.12	0.67-0.72	.026-.028	19.6	4.40
	28	0.08	0.64-0.69	.025-.027	9.8	2.20

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

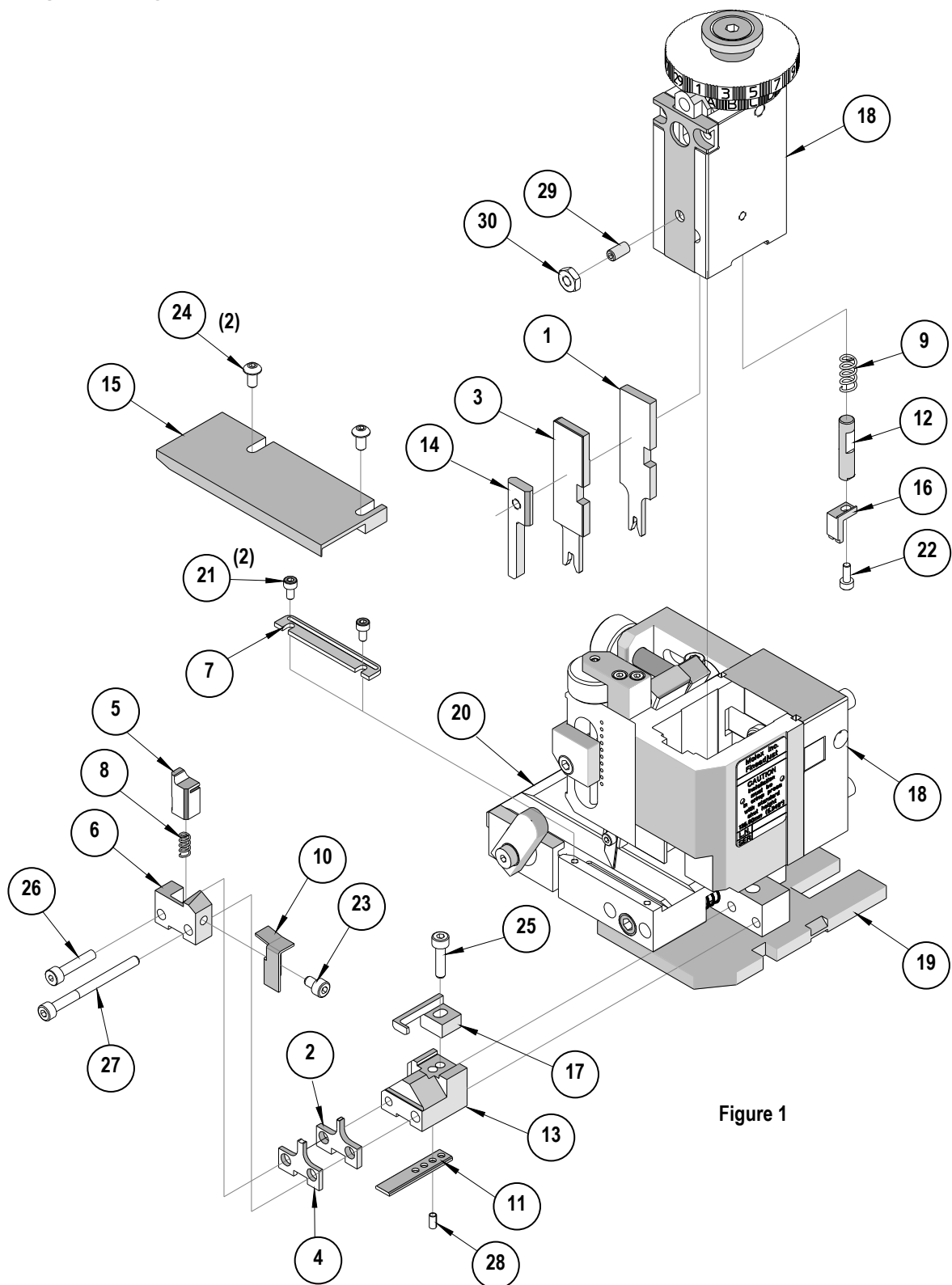
The above specifications are guidelines to an optimum crimp.

PARTS LIST

FineAdjust Applicator 63865-5100				
Item	Order No	Engineering No.	Description	Quantity
Perishable Tooling				
	63865-5170	63865-5170	Tool Kit (All "Y" Items)	REF
1	63444-1217	63444-1217	Conductor Punch	1 Y
2	63445-1229	63445-1229	Conductor Anvil	1 Y
3	63446-1812	63446-1812	Insulation Punch	1 Y
4	63445-1813	63445-1813	Insulation Anvil	1 Y
5	63443-0003	63443-0003	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	11-24-1082	4996-20	Compression Spring	1
10	63443-0009	63443-0009	Scrape Chute	1
11	63443-0021	63443-0021	Lower Tooling Key	1
12	63443-0043	63443-0043	Shank	1
13	63443-2422	63443-2422	Anvil Mount	1
14	63443-3101	63443-3101	Front Plunger Striker	1
15	63443-6003	63443-6003	Rear Cover	1
16	63865-5101	63865-5101	Terminal Hold Down	1
17	63865-5102	63865-5102	Wire Stop	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 SHCS	2**
22	N/A	N/A	M3 by 8 Long SHCS	1**
23	N/A	N/A	M4 by 6 Long SHCS	1**
24	N/A	N/A	M4 by 12 Long BHCS	2**
25	N/A	N/A	M4 by 16 Long SHCS	1**
26	N/A	N/A	M4 by 20 Long SHCS	1**
27	N/A	N/A	M4 by 50 Long SHCS	1**
28	N/A	N/A	3MM by 6 Long Roll Pin	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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