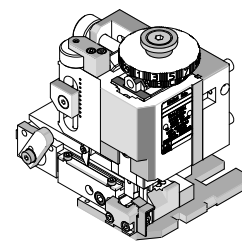


FineAdjust
Applicator**molex**Application Tooling
Specification Sheet

Order No. 63866-1000

FEATURES

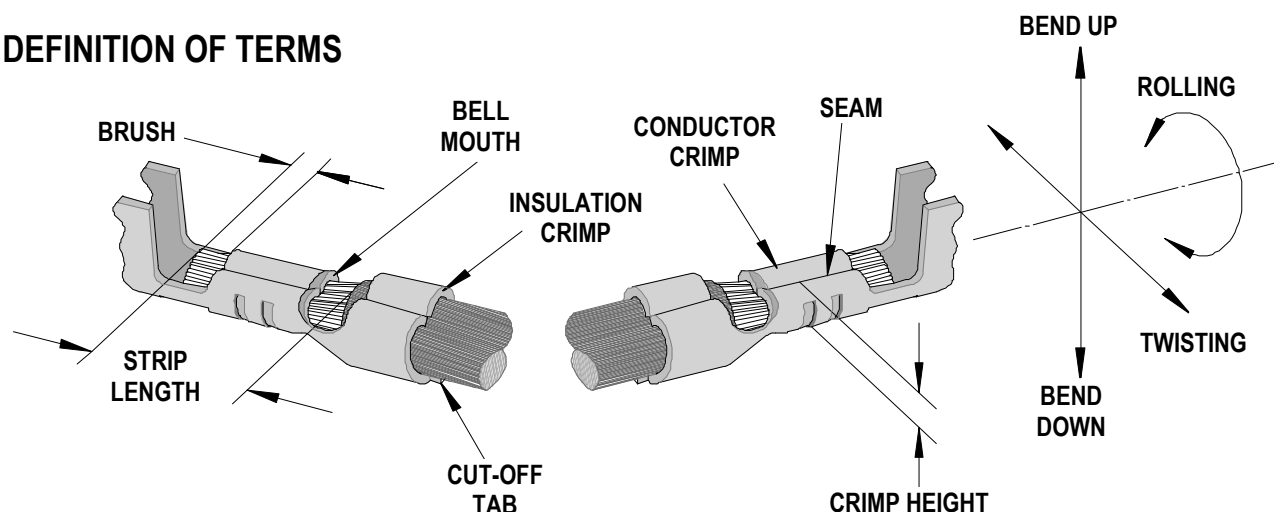
- Quick punch removal with the push of a button for fast and easy tooling change
- Applicator designed to industry standard mounting and shut height 135.80mm (5.346")
- Quick set-up time; plus the crimp height, track and feed adjustments can be set without removing the applicator from the press
- Fine 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

Products: 1.27mm (.050") Pitch SATA Crimp Power Terminal, 18-22 AWG.

Terminal Series No.	Terminal Order No.	Wire Size		Insulation Diameter				Strip Length	
				IPC/WHMA-A620 (1)		Terminal (2)			
		AWG	mm²	mm	In.	mm	In.	mm	In.
47634	47634-1000	18	0.83	2.00-2.40	.079-.095	2.00-2.40	.079-.095	2.50-3.50	.098-.138
	47634-1001	20	0.52	1.65-1.95	.065-.077	1.55-1.95	.061-.077	2.50-3.50	.098-.138
	47634-1002	22	0.32	1.65-1.80	.065-.071	1.40-1.80	.055-.071	2.50-3.50	.098-.138
67581	67581-0010	18	0.83	2.00-2.40	.079-.095	2.00-2.40	.079-.095	2.50-3.50	.098-.138
	67581-0011	20	0.52	1.65-1.95	.065-.077	1.55-1.95	.061-.077	2.50-3.50	.098-.138
	67581-0012	22	0.32	1.65-1.80	.065-.071	1.40-1.80	.055-.071	2.50-3.50	.098-.138
(1) To achieve optimum IPC-A620 Class 2 insulation crimps. For smaller wire diameter use Applicator order no. 63902-3500.									
(2) Overall insulation OD specification for terminal.									

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.
47634	0.20-0.50	.008-.020	0.30	.012	0.00-1.00	.000-.039
67581	0.20-0.50	.008-.020	0.30	.012	0.00-1.00	.000-.039

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		Degree		Conductor		Insulation		
					mm	In	mm	In	
47634	8	3	4	8	1.60	.063	2.50	.098	
67581	8	3	4	8	1.60	.063	2.50	.098	

After crimping, the conductor profile should measure the following.

Terminal Series No.	Wire Size		Conductor Crimp Height		Insulation Crimp Height		Pull Force Minimum	
	AWG	mm ²	mm	In.	mm	In.	N	Lb.
47634	18	0.83	1.15-1.25	.045-.049	2.25-2.55	.088-.100	88.2	19.82
	20	0.52	1.10-1.20	.043-.047	---	---	58.8	13.21
	22	0.32	1.05-1.15	.041-.045	---	---	39.2	8.80
67581	18	0.83	1.15-1.25	.045-.049	2.25-2.55	.088-.100	88.2	19.82
	20	0.52	1.10-1.20	.043-.047	---	---	58.8	13.21
	22	0.32	1.05-1.15	.041-.045	---	---	39.2	8.80

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 63866-1000				
Item	Order No.	Engineering No.	Description	Quantity
Perishable Tooling				
	63866-1070	63866-1070	Tool Kit (All "Y" Items)	REF
1	63444-1604	63444-1604	Conductor Punch	1 Y
2	63445-1641	63445-1641	Conductor Anvil	1 Y
3	63446-2502	63446-2502	Insulation Punch	1 Y
4	63445-2511	63445-2511	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	Front Cover	1
8	11-24-1067	4996-4	Cut-off Plunger Spring	2
9	11-40-4039	8302-5	Front Plunger Striker	1
10	63443-0009	63443-0009	Scrape Chute	1
11	63443-0021	63443-0021	Lower Tooling Key	1
12	63443-2409	63443-2409	Anvil Mount	1
13	63443-4018	63443-4018	Wire Stop	1
14	63443-6004	63443-6004	Rear Cover	1
Frame				
15	63800-4901	63800-4901	Top	1
16	63801-3281	63801-3281	Base	1
17	63801-4650	63801-4650	Track	1
Hardware				
18	N/A	N/A	M3 by 6 Long SHCS	2**
19	N/A	N/A	M4 by 6 Long SHCS	1**
20	N/A	N/A	M4 by 12 Long BHCS	2**
21	N/A	N/A	M4 by 16 Lg SHCS	1**
22	N/A	N/A	M4 by 20 Long SHCS	1**
23	N/A	N/A	M4 by 50 Long SHCS	1**
24	N/A	N/A	3MM by 6 Long Roll Pin	1**
25	N/A	N/A	#10-32 by 3/8" Long Flat Point SSS	1**
26	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

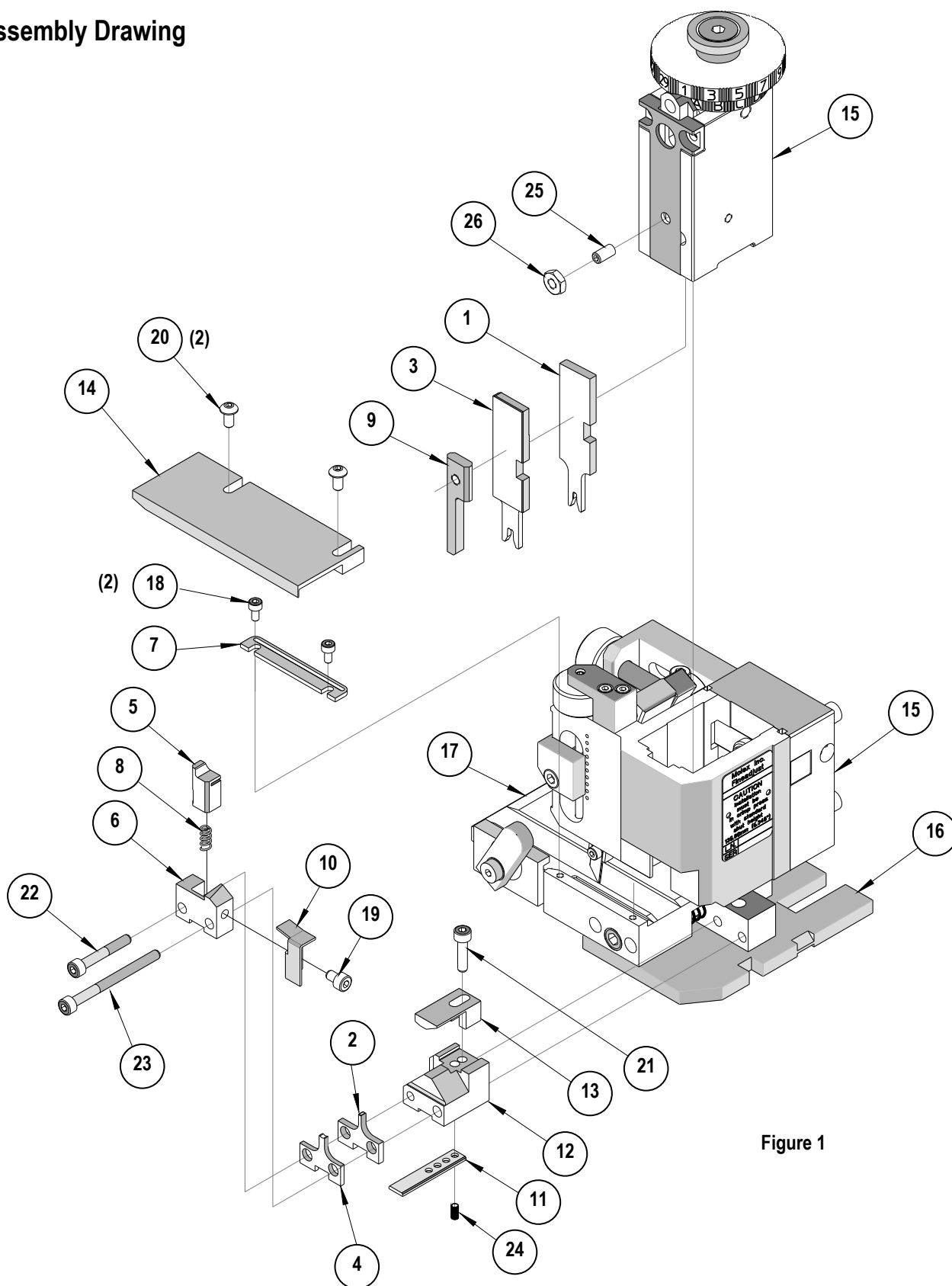


Figure 1

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.

<http://www.molex.com>

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Тел: +7 (812) 336 43 04 (многоканальный)

Email: org@lifeelectronics.ru

www.lifeelectronics.ru