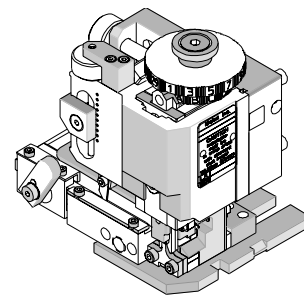




FineAdjust Applicator Specification Sheet Part No. 63900-6400



FEATURES

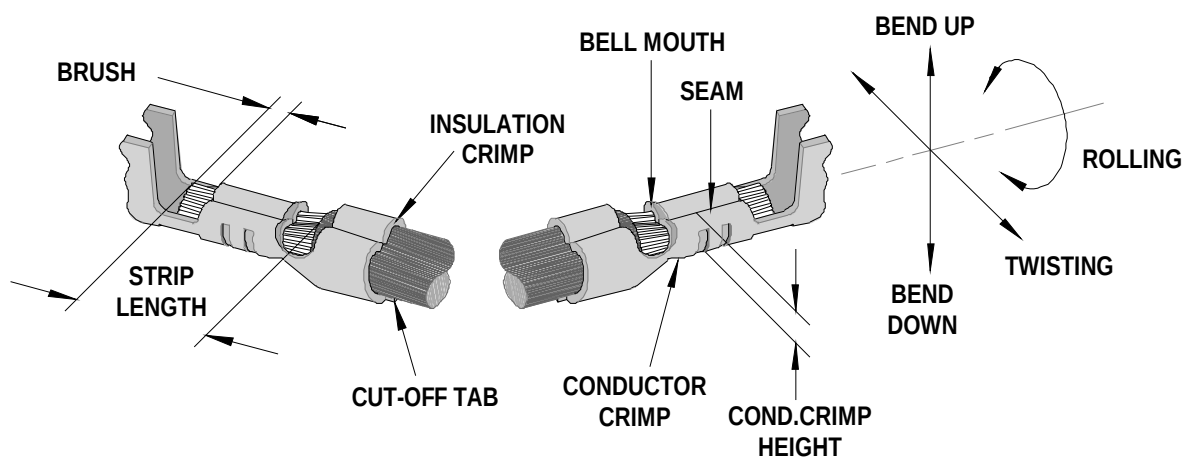
- Quick punch removal with the push of a button for fast and easy tooling change
- Applicator designed to industry standard mounting and shut height 135.80mm (5.346")
- Quick set-up time; plus the crimp height, track and feed adjustments can be set without removing the applicator from the press
- Fine adjustment allows users to achieve target with little effort by adjusting in increments of .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
- Directly adapts to most automatic wire processing machines

SCOPE

Products: 2.00mm (.079") Pitch, Wire-to-Board, Crimp Terminal, 24-30 AWG.

Terminal Series No.	Terminal Order No.	Wire Size		* Insulation Diameter		Strip Length	
		AWG	mm ²	mm	In.	mm	In.
48105	48105-0001	24-30	0.20-0.05	1.10-1.50	.043-.059	1.90-2.50	.075-.099
* Note: 1) Insulation OD: 1.10-1.20mm will provide optimum A-620-Class 2 crimps 2) Insulation OD: 1.25-1.35mm will provide optimum A-620-Class 1 crimps 3) Insulation OD: 1.40-1.50mm will not provide optimum A-620 crimps							

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.
48105	0.10-0.30	.004-.012	0.50	.020	0.30-0.60	.012-.024

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
					Conductor		Insulation		
	Degree		Degree		mm	In	mm	In	
48105	6	6	5	7	1.10	.043	1.50	.059	

After crimping, the conductor profile should measure the following.

Terminal Series No.	Wire Size		Conductor Crimp				Insulation Crimp Maximum				Pull Force Minimum	
			Height		Width (Ref)		Height		Width (Ref)			
	AWG	mm ²	mm	In.	mm	In.	mm	In.	mm	In.	N	Lb.
48105	24	0.20	0.62-0.67	.024-.026	1.15	.045	1.70	.067	1.55	.061	29.4	6.62
	26	0.13	0.57-0.62	.023-.025	1.15	.045	1.60	.063	1.55	.061	19.6	4.41
	28	0.08	0.55-0.60	.022-.024	1.15	.045	1.50	.059	1.55	.061	14.7	3.31
	30	0.05	0.52-0.57	.021-.023	1.15	.045	1.50	.059	1.55	.061	7.8	1.76

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 63900-6400				
Item	Order No	Engineering No.	Description	Quantity
Perishable Tooling				
	63900-6470	63900-6470	Tool Kit (All "Y" Items)	REF
1	63444-1104	63444-1104	Conductor Punch	1 Y
2	63445-1110	63445-1110	Conductor Anvil	1 Y
3	63454-0070	63454-0070	Insulation Punch-Overlap	1 Y
4	63445-1505	63445-1505	Insulation Anvil	1 Y
5	63443-0002	63443-0002	Front Cut-Off Plunger	1 Y
6	63443-0012	63443-0012	Front Plunger Retainer	1 Y
Other Components (REF 006450)				
7	11-18-4083	60707-8	Feed Guide	1
8	11-24-1067	4996-4	Cut-Off Plunger Spring	1
9	11-40-4039	8302-5	Plunger Striker	1
10	63443-0009	63443-0009	Front Scrap Chute	1
11	63443-0025	63443-0025	Key	1
12	63443-0090	63443-0090	Wire Stop	1
13	63443-1719	63443-1719	18.90mm Height Spacer	1
14	63443-2201	63443-2201	1.00mm Coarse Spacer	1
15	63443-2216	63443-2216	16.00mm Coarse Spacer	1
16	63443-2301	63443-2301	3.05mm Fine Spacer	1
17	63443-6111	63443-6111	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 SHCS	2**
22	N/A	N/A	M3 by 6 Long FHCS	1**
23	N/A	N/A	M4 by 6 Long SHCS	2**
24	N/A	N/A	M4 by 12 Long BHCS	2**
25	N/A	N/A	M4 by 50 Long SHCS	2**
26	N/A	N/A	M5 by 12 Long SHCS	1**
27	N/A	N/A	#10-32 by 3/8" Long Flat Point SSS	1**
28	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

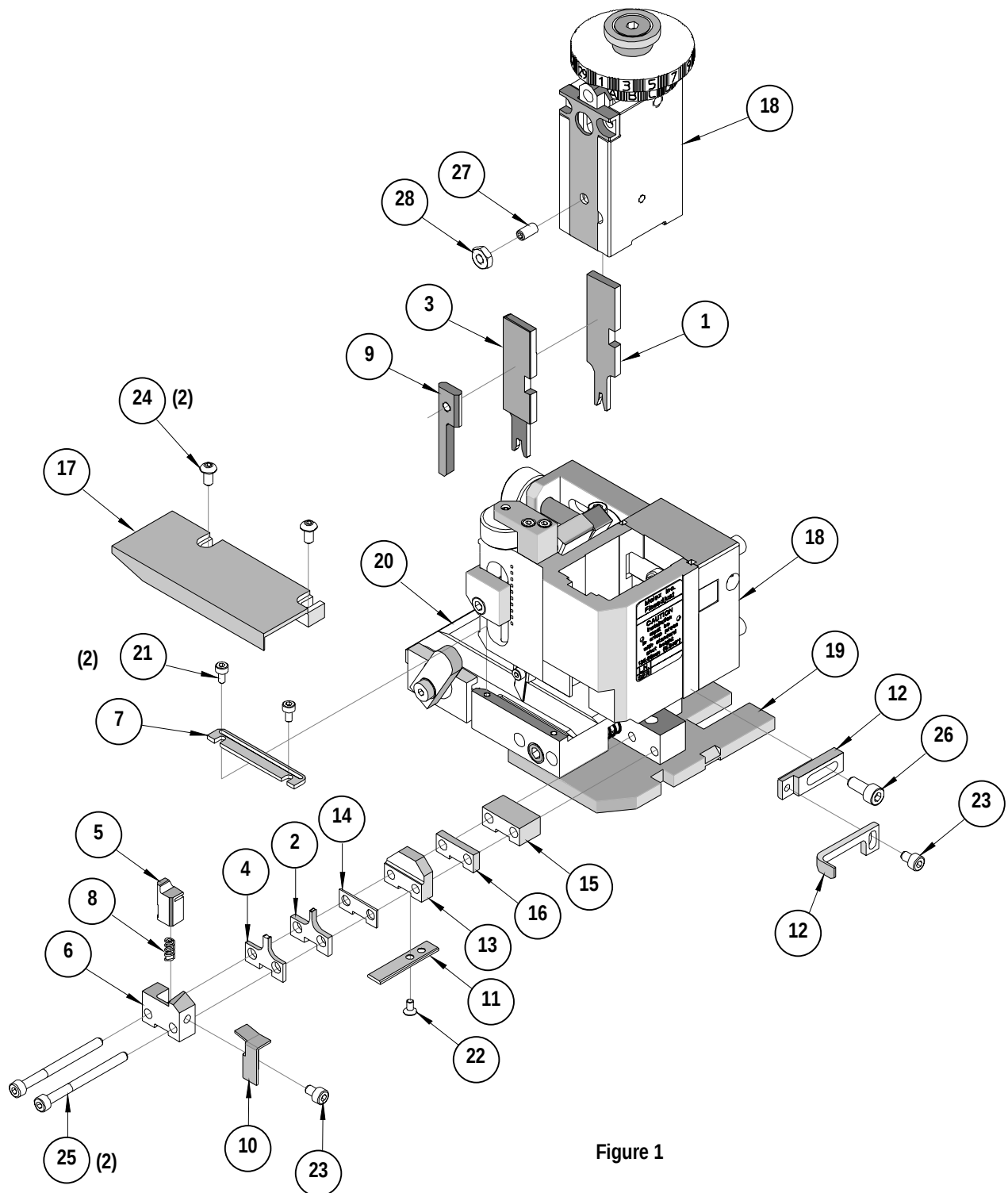


Figure 1

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 135.80 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.

Americas Headquarters
Lisle, Illinois 60532 U.S.A.
1-800-78MOLEX
amerinfo@molex.com

Far East North Headquarters
Yamato, Kanagawa, Japan
81-462-65-2324
feninfo@molex.com

Far East South Headquarters
Jurong, Singapore
65-6-268-6868
fesinfo@molex.com

European Headquarters
Munich, Germany
49-89-413092-0
eurinfo@molex.com

Corporate Headquarters
2222 Wellington Ct.
Lisle, IL 60532 U.S.A.
630-969-4550
Fax: 630-969-1352

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

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

Email: org@lifeelectronics.ru

www.lifeelectronics.ru