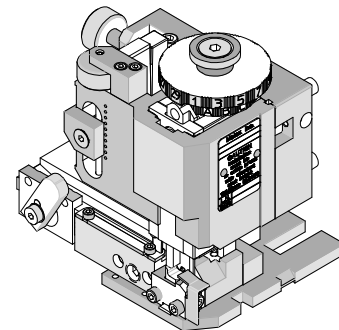




FineAdjust Applicator Specification Sheet Order No. 63901-1700



FEATURES

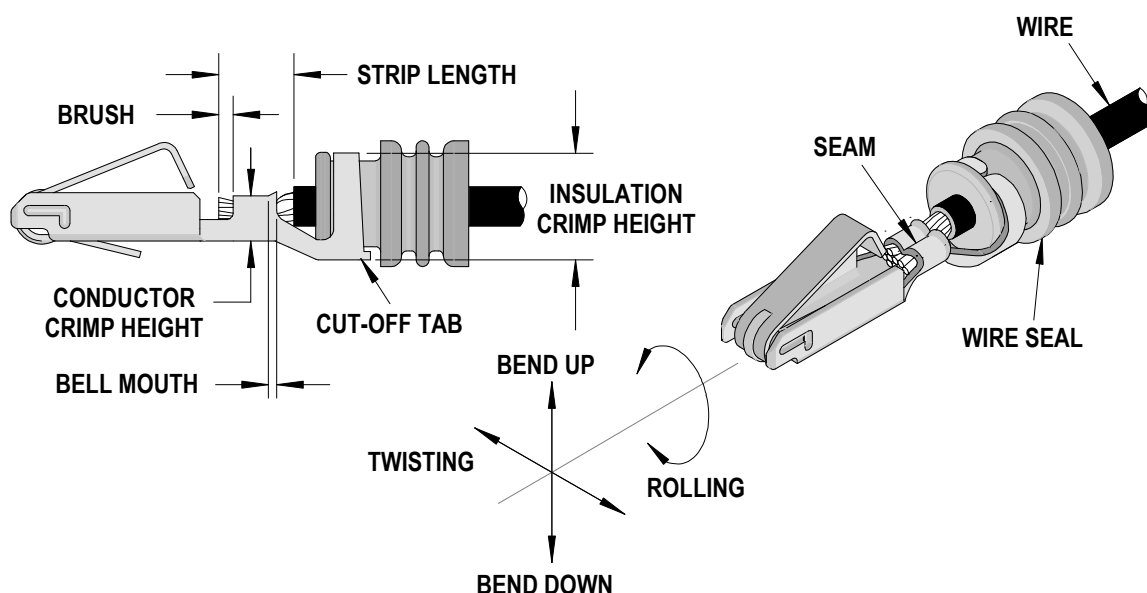
- Directly adapts to most automatic wire processing machines
- Quick punch removal with the push of a button for fast and easy tooling change
- Applicator designed to industry standard mounting and shut height 135.80mm (5.346")
- Quick set-up time; plus the crimp height, track and feed adjustments can 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: Sealed PT-Bulb Socket Earth Terminal, 0.50-0.85mm².

Terminal Series No.	Terminal Order No.	Wire Size		Insulation Diameter		Strip Length	
				Terminal♦			
		AWG	mm²	mm	In.	mm	In.
35465	35465-8000	AVS-0.50	0.50	2.00-2.10	.079-.083	4.80-5.20	.188-.205
		AVS-0.85	0.85	2.20-2.30	.087-.091		
		AVSS-0.50	0.50	1.60-1.70	.063-.067		
		AVSS-0.85	0.85	1.80-1.90	.071-.075		
♦ Overall insulation OD specification for terminal.							

DEFINITION OF TERMS



CRIMP SPECIFICATION

Terminal Series No.	Bell mouth		Cut-off Tab Maximum		Conductor Brush	
	mm	In.	mm	In.	mm	In.
35465	0.30-0.60	.012-.024	N/A	N/A	0.30-0.80	.012-.031

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 (Max)		Degree (Max)		mm	In	mm	In	
35465	3	3	3	5	2.10	.083	4.50	.177	

After crimping, the conductor profile should measure the following.

Terminal Series No.	Wire Size	Actual mm ²	Conductor Crimp				Pull Force Minimum	
			Crimp Height		Crimp Width (Ref.)			
			mm	In.	mm	In.	N	Lb.
35465	0.50	0.50	0.90-1.10	.035-.043	2.00-2.20	.079-.087	88.3	19.8
	0.85	0.85	1.00-1.20	.039-.047	2.00-2.20	.079-.087	127.5	28.7

Terminal Series No.	Wire Size	Actual mm ²	Wire Rear Seal		Insulation			
					Crimp Height Maximum		Crimp Width (Ref.)	
			Order No.	Color	mm	In.	mm	In.
35465	0.50	0.50	35903-0075	Blue	4.20	.165	4.40-4.60	.173-.181
	0.85	0.85			4.20	.165	4.40-4.60	.173-.181

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 63901-1700				
Item	Order No	Engineering No.	Description	Quantity
Perishable Tooling				
	63901-1770	63901-1770	Tool Kit (All "Y" Items)	REF
1	63457-0048	63457-0048	Conductor Punch	1 Y
2	63445-2107	63445-2107	Conductor Anvil	1 Y
3	63454-0083	63454-0083	Insulation Punch	1 Y
4	63456-0057	63456-0057	Insulation Anvil	1 Y
5	63443-0035	63443-0035	Front Cut-Off Plunger	1 Y
6	63443-0036	63443-0036	Front Plunger Retainer	1 Y
Other Components(REF 011750)				
7	11-18-4083	60707-8	Feed Guide	1
8	63443-0009	63443-0009	Front Scrap Chute	1
9	63443-0025	63443-0025	Key	1
10	63443-0090	63443-0090	Wire Stop	1
11	63443-1717	63443-1717	18.70mm Height Spacer	1
12	63443-2207	63443-2207	7.00mm Coarse Spacer	1
13	63443-2209	63443-2209	9.00mm Coarse Spacer	1
14	63443-2305	63443-2305	3.25mm Fine Spacer	1
15	63443-6123	63443-6123	Rear Cover	1
16	63700-0539	63700-0539	Cut-Off Plunger Spring	1
17	63890-0070	63890-0070	Front Plunger Striker	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 Lg 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

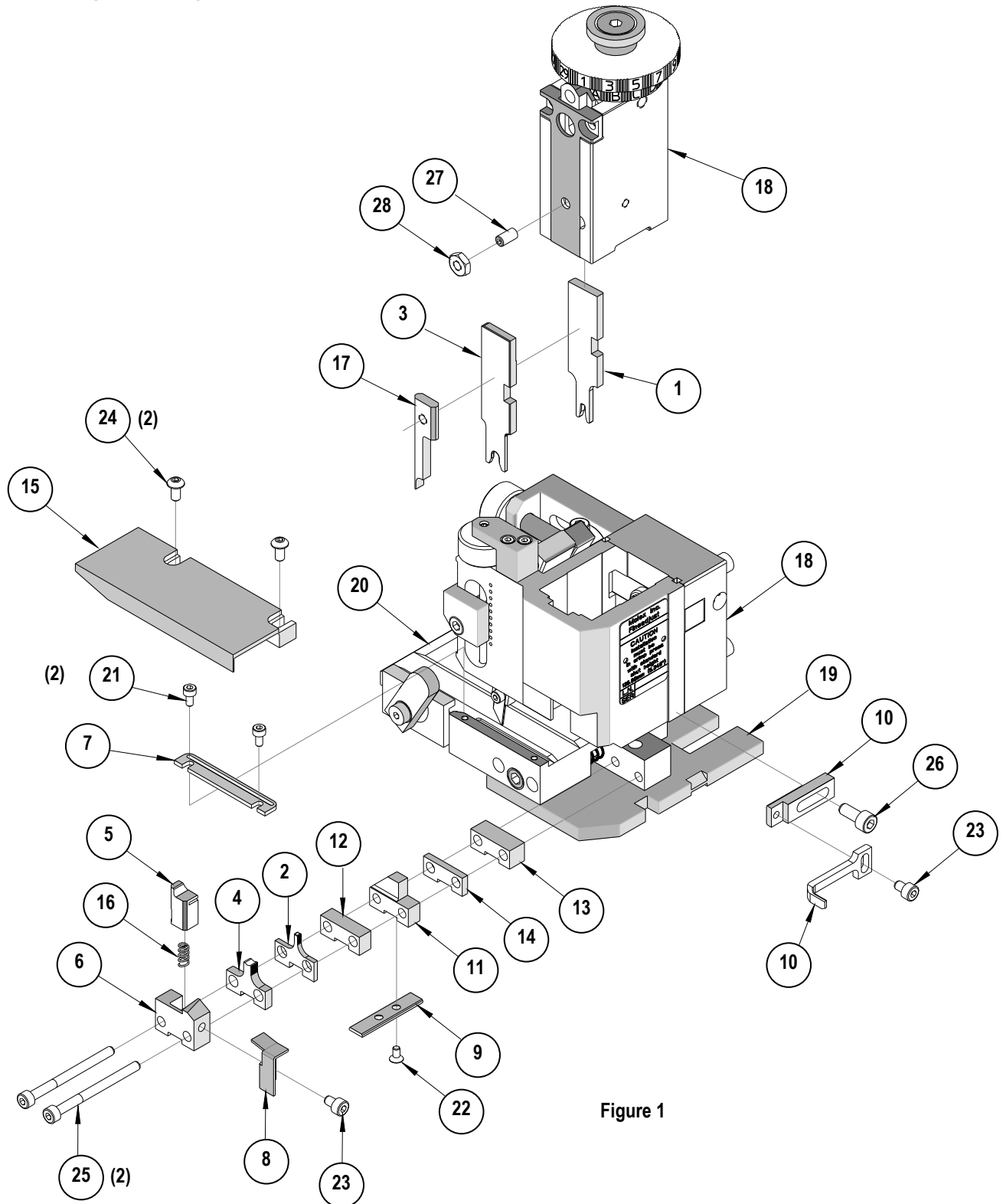


Figure 1

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 135.8mm (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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