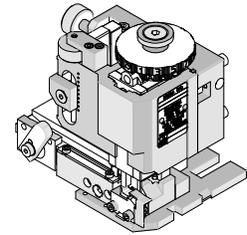


**FineAdjust  
Applicator**



**Application Tooling  
Specification Sheet**



**Order No. 63902-0500**

**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

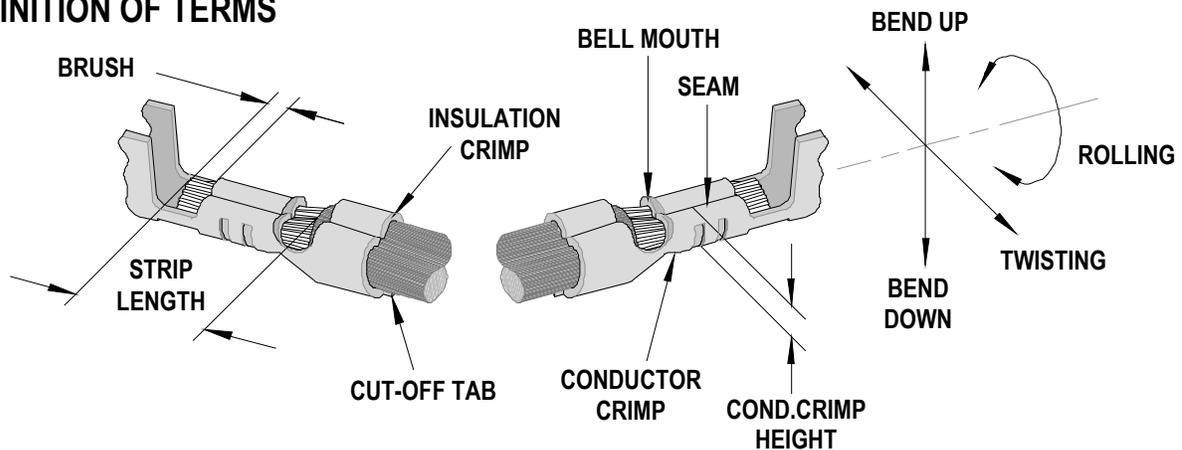
**SCOPE**

Products: 2.5 Mini Splash Proof Wire-to-Wire Crimp Terminal 20-22 AWG.

Terminal Series No.	Terminal Order No.	Wire Size		Insulation Diameter				Strip Length	
				IPC/WHMA-A620 (1)		Terminal (2)			
		AWG	mm <sup>2</sup>	mm	In.	mm	In.	mm	In.
50147 50148	50147-8000 50148-8000	22	---	1.40-1.60	.055-.063	1.40-1.90	.055-.075	2.00-2.50	.078-.098
			AVSS-0.3						
			CAVS-0.3						
			CAVUS-0.3						
		20	---						
			AVSS-0.5						
	CAVS-0.5								
		CAVUS-0.5							

(1) To achieve optimum IPC-A620 insulation crimps, use this insulation OD range.  
 (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 any terminal listed in the scope.

### CRIMP SPECIFICATION

Terminal Series No.	Bell mouth		Cut-off Tab Maximum		Conductor Brush	
	mm	In.	mm	In.	mm	In.
50147	0.00-0.30	.000-.012	0.00-0.30	.000-.012	0.10-0.90	.004-.035
50148						

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
					Conductor		Insulation		
	Degree	Degree	mm	In.	mm	In.			
50147	2	3	3	10	1.40	.055	1.80	.071	
50148									

After crimping, the crimp profiles should measure the following:

Terminal Series No.	Wire Size		Conductor Crimp Height		Insulation Crimp Height Maximum		Pull Force Minimum		
	AWG	mm <sup>2</sup>	mm	In.	mm	In.	N	Lb.	
50147 50148	22	---	0.94-0.99	.037-.039	1.90	.075	49.0	11.0	
		AVSS-0.3	0.94-0.99	.037-.039	1.90	.075	49.0	11.0	
		CAVS-0.3							
		20	---	0.96-1.06	.038-.042	1.90	.075	53.9	12.1
			AVSS-0.5	0.96-1.06	.038-.042	1.90	.075	53.9	12.1
			CAVS-0.5						
		CAVUS-0.3	0.94-0.99	.037-.039	1.90	.075	49.0	11.0	
		CAVUS-0.5	0.96-1.06	.038-.042	1.90	.075	53.9	12.1	

■ 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**

<b>FineAdjust Applicator 63902-0500</b>				
<b>Item</b>	<b>Order No</b>	<b>Engineering No.</b>	<b>Description</b>	<b>Quantity</b>
<b>Perishable Tooling</b>				
	63902-0570	63902-0570	Tool Kit (All "Y" Items)	REF
1	63444-1407	63444-1407	Conductor Punch	1 Y
2	63445-1430	63445-1430	Conductor Anvil	1 Y
3	63454-0038	63454-0038	Insulation Punch	1 Y
4	63445-1805	63445-1805	Insulation Anvil	1 Y
5	63443-0002	63443-0002	Cut-Off Plunger Front	1 Y
6	63443-0012	63443-0012	Plunger Retainer Front	1 Y
<b>Other Components</b>				
7	11-18-4083	60707-8	Feed Guide	1
8	11-24-1067	4996-4	Cut-off Plunger Spring	1
9	63443-0009	63443-0009	Scrap Chute Front	1
10	63443-0024	63443-0024	Key	1
11	63443-0090	63443-0090	Wire Stop	1
12	63443-1718	63443-1718	Height Spacer	1
13	63443-2216	63443-2216	Course Spacer (16.00mm)	1
14	63443-2316	63443-2316	Fine Spacer (3.80mm)	1
15	63443-2802	63443-2802	Front Plunger Striker	1
16	63443-2906	63443-2906	Wire hold down Plunger	1
17	63443-6111	63443-6111	Rear Cover	1
18	63600-1057	63600-1057	Striker Plunger Spring	1
<b>Frame</b>				
19	63800-4901	63800-4901	Top	1
20	63801-3281	63801-3281	Base	1
21	63801-4650	63801-4650	Track	1
<b>Hardware</b>				
22	N/A	N/A	M3 by 6 Long SHCS	2**
23	N/A	N/A	M3 by 6 Long FHCS	1**
24	N/A	N/A	M4 by 6 Long SHCS	2**
25	N/A	N/A	M4 by 12 Long BHCS	2**
26	N/A	N/A	M4 by 45 Long SHCS	2**
27	N/A	N/A	M5 by 12 Long SHCS	2**
28	N/A	N/A	#10-32 by 3/8" Long Flat Point SSS	1**
29	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

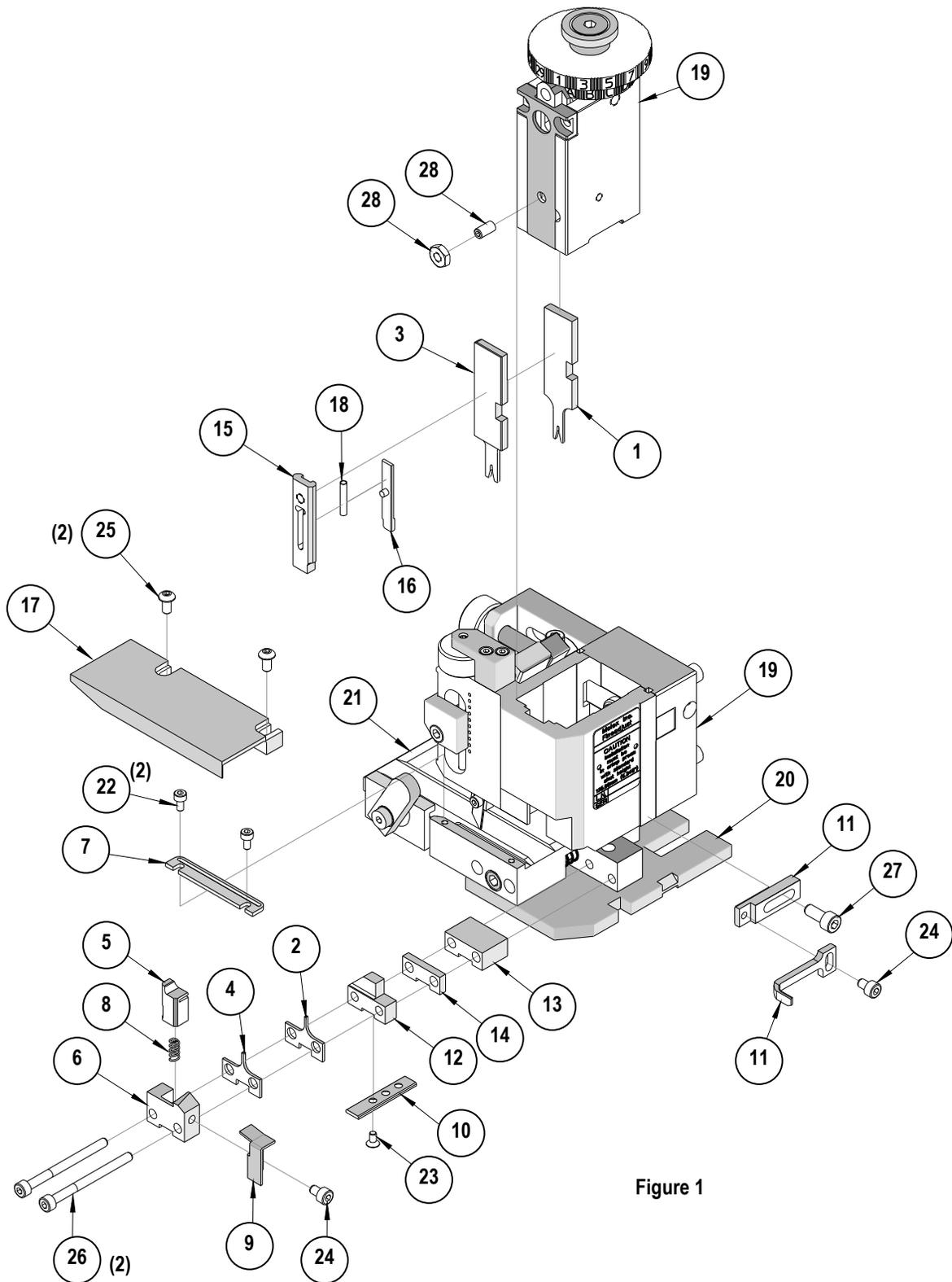


Figure 1

## 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.

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

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