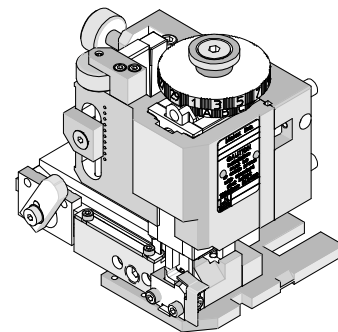




## FineAdjust Applicator Applicator Tooling Specification Sheet Order No. 63901-8500



### FEATURES

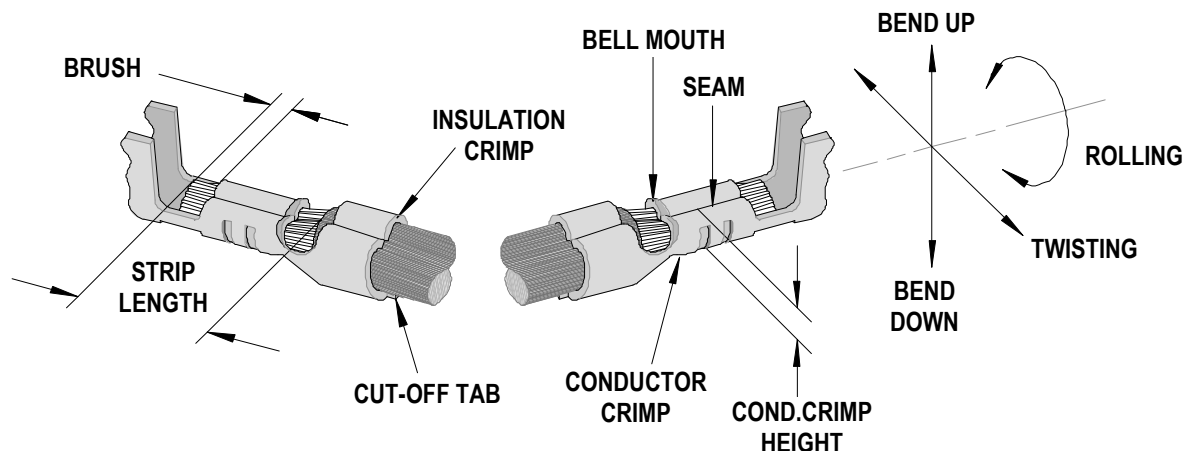
- Quick punch removal with the push of a button for fast and easy tooling change
- Applicator designed to industry standard mounting and shut height 135.80mm (5.346")
- Quick set-up time; plus the crimp height, track and feed adjustments can be set without removing the applicator from the press
- Fine 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: 2.50mm (.098") Pitch Mini-Lock™ Crimp Terminal

Terminal Series No.	Terminal Order No.	Wire Size		Insulation Diameter				Strip Length	
				IPC/WHMA-A60 (1)		Terminal (2)			
		AWG	mm <sup>2</sup>	mm	In.	mm	In.	mm	In.
50837	50837-8000	22-28	0.35-0.08	1.15-1.80	.045-.071	1.15-1.80	.045-.071	2.30-2.80	.091-.110
(1) To achieve optimum IPC-A620 Class 2 insulation crimps									
(2) 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.
50837	0.05-0.40	.002-.016	0.20	.008	0.00-0.80	.000-.032

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	
50837	3	3	3	6	1.20		1.80		

After crimping, the crimp profiles should measure the following:

Terminal Series No.	Wire Size		Conductor				Pull Force Minimum	
			Crimp Height		Crimp Width (Ref.)			
	AWG	mm <sup>2</sup>	mm	In.	mm	In.	N	Lb.
50837	22	0.35	0.84-0.89	.033-.035			39.2	8.8
	24	0.20	0.76-0.81	.030-.032			29.4	6.6
	26	0.12	0.71-0.76	.028-.030			19.6	4.4
	28	0.08	0.67-0.72	.026-.028			9.8	2.2

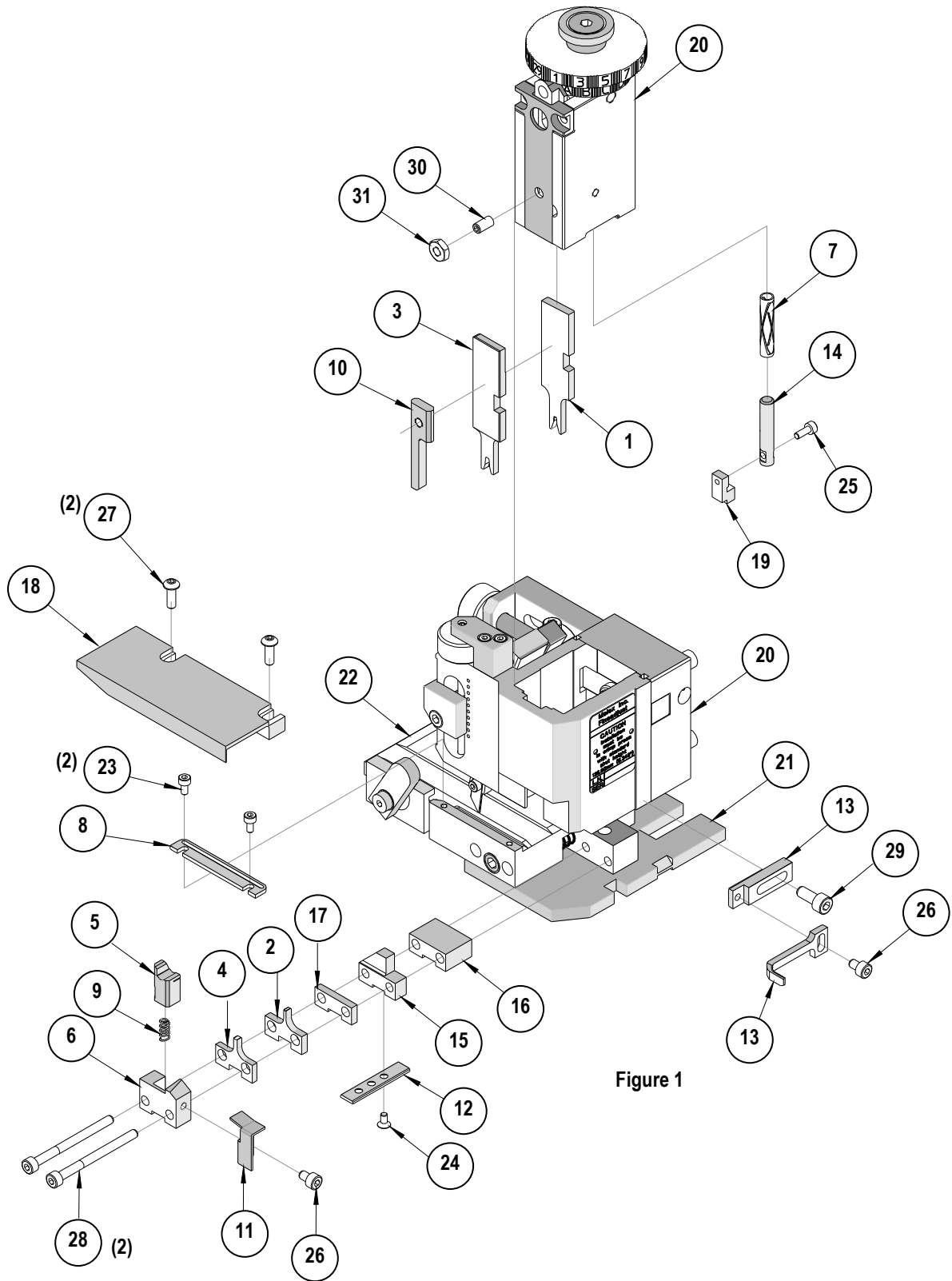
► Tool Qualification Notes:

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>Fine Adjust Applicator 63901-8500</b>				
<b>Item</b>	<b>Order No</b>	<b>Engineering No.</b>	<b>Description</b>	<b>Quantity</b>
<b>Perishable Tooling</b>				
	63901-8570	63901-8570	Tool Kit (All "Y" Items)	REF
1	634441210	634441210	Conductor Punch	1 Y
2	634451225	634451225	Conductor Anvil	1 Y
3	634461816	634461816	Insulation Punch	1 Y
4	634451819	634451819	Insulation Anvil	1 Y
5	634430002	634430002	Cut-Off Plunger	1 Y
6	634430012	634430012	Front Plunger Retainer	1 Y
<b>Other Components</b>				
7	11-17-0022	1739-21	Hold Down Spring	1
8	11-18-4083	60707-8	Feed Guide	1
9	11-24-1067	4996-4	Cut-off Plunger Spring	1
10	11-40-4039	8302-5	Front Plunger Striker	1
11	63443-0009	63443-0009	Scrap Chute	1
12	63443-0024	63443-0024	Key	1
13	63443-0090	63443-0090	Wire Stop	1
14	63443-0093	63443-0093	Shank	1
15	63443-1717	63443-1717	18.70mm Height Spacer	1
16	63443-2216	63443-2216	16.00mm Spacer	1
17	63443-2307	63443-2307	3.35mm Spacer	1
18	63443-6003	63443-6003	Rear Cover	1
19	63443-7114	63443-7114	Terminal Hold Down	1
<b>Frame</b>				
20	63800-4901	63800-4901	Top	1
21	63801-3281	63801-3281	Base	1
22	63801-4650	63801-4650	Track	1
<b>Hardware</b>				
23	N/A	N/A	M3 by 6 Long SHCS	2**
24	N/A	N/A	M3 by 6 Long FHCS	1**
25	N/A	N/A	M3 by 8 Long SHCS	1**
26	N/A	N/A	M4 by 6 Long SHCS	2**
27	N/A	N/A	M4 by 12 Long BHCS	2**
28	N/A	N/A	M4 by 50 Long SHCS	2**
29	N/A	N/A	M5 by 12 Long SHCS	1**
30	N/A	N/A	#10-32 by 3/8" Long Flat Point SSS	1**
31	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.

 <p><b>CAUTION</b></p>	<p>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</p> <p>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.</p>
 <p><b>CAUTION</b></p>	<p>Molex tooling crimp specifications are valid only when used with Molex terminals and tooling manufactured by Molex or authorized distributors ("Molex Tooling"). When using tooling other than Molex Tooling with specific Molex specific connector systems listed in our ATS documents, the Molex tooling qualification does not apply and the responsibility for full qualification of the connector system is that of the customer.</p> <p>Molex accepts no liability for connector performance or tooling support where tooling other than Molex Tooling is used, or where Molex Tooling is modified.</p>
 <p><b>CAUTION</b></p>	<p>A-620 and other industry standards do not supersede the manufacturer's specifications. Some terminals designed over 20 years ago may not meet the desired physical attributes for some of today's standards. However, these terminals will still perform electrically at an acceptable quality level based on the qualification testing and years of successful performance in the field.</p>

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