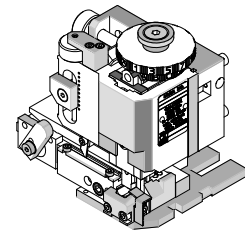


**FineAdjust
Applicator**



**Application Tooling
Specification Sheet**



Order No. 63902-2400

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

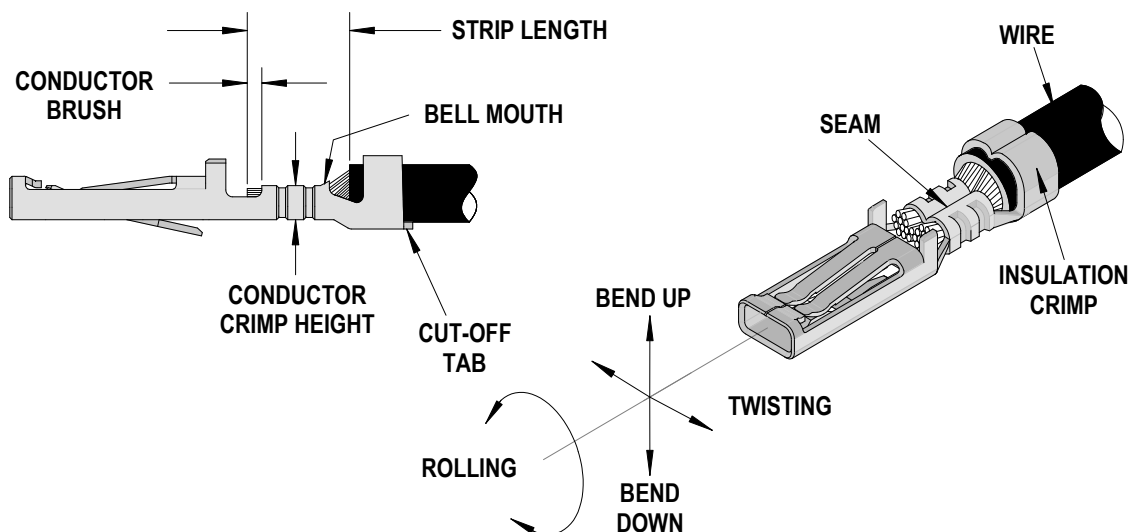
Products: Robot Conn 36P Crimp Terminals, 16-18 AWG.

Terminal Series No.	Terminal Order No.	Wire Size		Insulation Diameter				Strip Length	
				IPC/WHMA-A620 (1)		Terminal (2)			
		AWG	mm ²	mm	In.	mm	In.	mm	In.
503195	503195-1000	16-18	0.81-1.38	2.30-2.50	.090-.098	2.00-2.50	.079-.098	3.90-4.40	.154-.173
503196	503196-1000	16-18	0.81-1.38	2.30-2.50	.090-.098	2.00-2.50	.079-.098	3.90-4.40	.154-.173

UL1007 or equivalent.

(1) To achieve optimum IPC-A620 Class 2 insulation crimps, use this insulation OD.
 (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.
503195	0.10-0.60	.004-.024	0.00-0.20	.008	0.10-1.00	.004-.039
503196	0.10-0.60	.004-.024	0.00-0.20	.008	0.10-1.00	.004-.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 Maximum	Degree Maximum	Degree Maximum	Degree Maximum	Conductor		Insulation		
					mm	In	mm	In	
503195	2	2	3	5	2.20	.087	3.20	.126	
503196	2	2	3	5	2.20	.087	3.20	.126	

After crimping, the conductor profile should measure the following.

Terminal Order No.	Wire Size		Conductor				Pull Force Minimum	
			Crimp Height		Crimp Width (Ref.)			
	AWG	mm ²	mm	In.	mm	In.	N	Lb.
503195	16	1.38	1.38-1.48	.054-.058	2.20	.087	127.0	28.55
	18	0.81	1.21-1.31	.047-.051	2.20	.087	88.2	19.83
503196	16	1.38	1.38-1.48	.054-.058	2.20	.087	127.0	28.55
	18	0.81	1.21-1.31	.047-.051	2.20	.087	88.2	19.83

Terminal Order No.	Wire Size		Insulation			
			Crimp Height		Crimp Width (Ref.)	
	AWG	mm ²	mm	In.	mm	In.
503195	16	1.38	3.10	.122	3.20	.126
	18	0.81	3.00	.118	3.20	.126
503196	16	1.38	3.10	.122	3.20	.126
	18	0.81	3.00	.118	3.20	.126

*** 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 63902-2400				
Item	Order No	Engineering No.	Description	Quantity
Perishable Tooling				
	63902-2470	63902-2470	Tool Kit (All "Y" Items)	REF
1	63444-2215	63444-2215	Conductor Punch	1 Y
2	63445-2247	63445-2247	Conductor Anvil	1 Y
3	63446-3227	63446-3227	Insulation Punch	1 Y
4	63445-3240	63445-3240	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				
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	Plunger Striker	1
11	63443-0093	63443-0093	Shank - Terminal Hold Down	1
12	63443-0009	63443-0009	Front Scrap Chute	1
13	63443-0024	63443-0024	Key	1
14	63443-0090	63443-0090	Wire Stop	1
15	63443-1727	63443-1727	Height Spacer	1
16	63443-1743	63443-1743	Height Spacer	1
17	63443-2204	63443-2204	Coarse Spacer (3.50mm)	1
18	63443-2205	63443-2205	Coarse Spacer (5.0mm)	1
19	63443-2310	63443-2310	Fine Spacer (4.00mm)	1
20	63443-6115	63443-6115	Rear Cover	1
21	63443-7116	63443-7116	Terminal Hold Down	1
Frame				
22	63800-4901	63800-4901	Top	1
23	63801-3281	63801-3281	Base	1
24	63801-4650	63801-4650	Track	1
Hardware				
25	N/A	N/A	M3 by 6 Long SHCS	2**
26	N/A	N/A	M3 by 6 Long FHCS	1**
27	N/A	N/A	M4 by 6 Long SHCS	2**
28	N/A	N/A	M4 by 12 Long BHCS	2**
29	N/A	N/A	M4 by 50 Long SHCS	2**
30	N/A	N/A	M5 by 12 Lg SHCS	1**
31	N/A	N/A	M3 by 8 Long SHCS	1**
32	N/A	N/A	#10-32 by 3/8" Long Flat Point SSS	1**
33	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

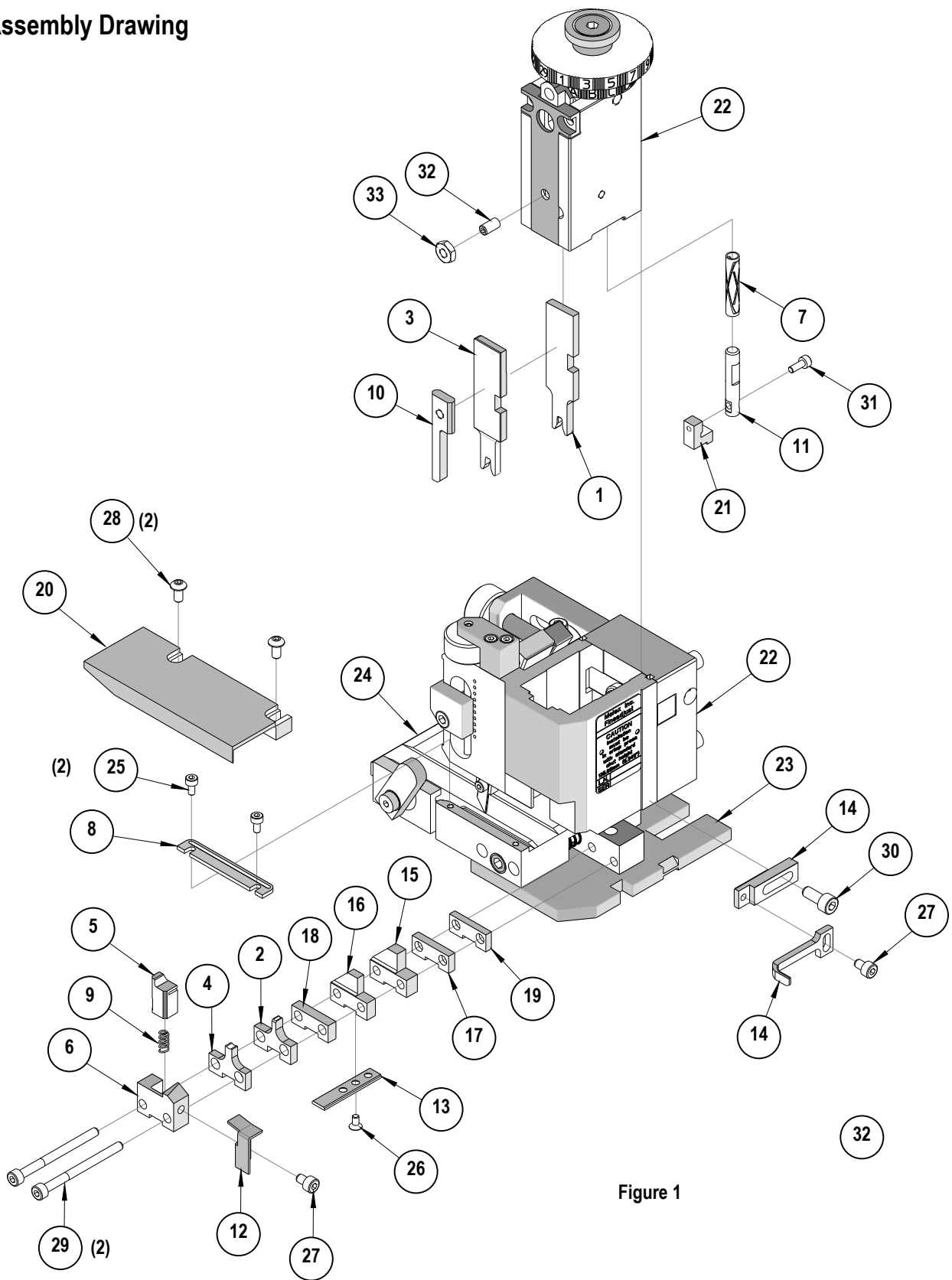


Figure 1

Optional Applicator Parts:

The following parts are *not included* with this Applicator and may be purchased separately.

63443-0017 Cut-Off Plunger Retainer

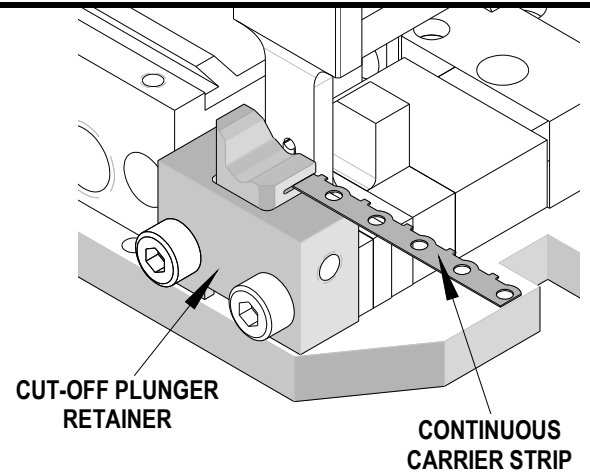
For wire processing applications:

It is recommended for fully automatic, high speed operations, where the press and the applicator are mounted to a wire processing machine.

Applicator down time for scrap clean-up may be reduced.

This cut-off plunger retainer leaves the scrap terminal carrier intact.

Not recommended for bench operation, where a continuous scrap strip can tangle or build up inside of the safety guards resulting in jams or tooling damage.



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.

<http://www.molex.com>