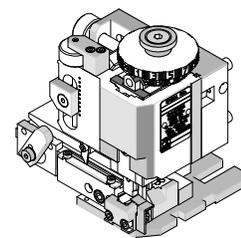




**FineAdjust  
Applicator**

**Application Tooling  
Specification Sheet**



**Order No. 63902-7400**

**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

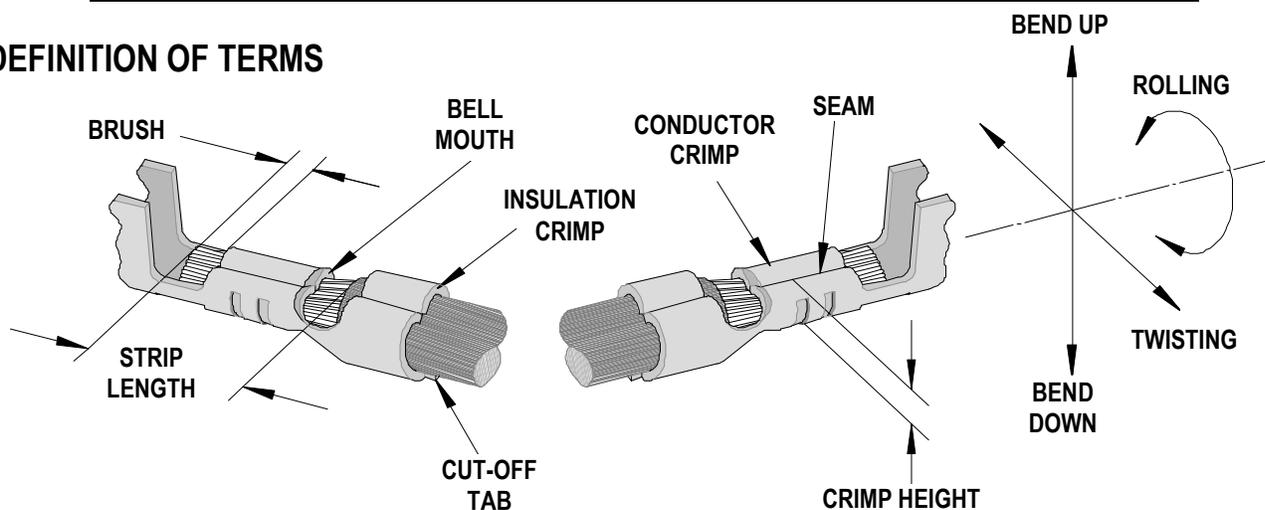
**SCOPE**

Products: 2.3mm (.090") Slip-On Receptacle Terminal, 1.25-2.00mm<sup>2</sup>.

Terminal Series No.	Terminal Order No.	Wire Size		Insulation Diameter				Strip Length	
				IPC/WHMA-A620 ♦		Terminal ♦♦			
		Type	mm <sup>2</sup>	mm	In.	mm	In.	mm	In.
35768	35768-0210	AVSS	1.25	2.10-2.70	.083-.106	2.10-2.70	.083-.106	5.00-5.60	.197-.220
		AVSS	2.00						

♦ To achieve optimum IPC-A620 insulation crimps, use this insulation OD range.  
♦♦ Overall insulation OD specification for terminal.

**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.
35768	0.30-0.60	.012-.024	0.50	.020	0.30-1.00	.012-.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
					Conductor		Insulation		
	Degree (Max)		Degree (Max)		mm	In	mm	In	
35768	3	3	3	5	2.40	.095	2.90	.114	

After crimping, the conductor profile should measure the following.

Terminal Series No.	Wire Size	Conductor Crimp				Pull Force Minimum	
		Crimp Height		Crimp Width (Ref.)		N	Lb.
		mm	In.	mm	In.		
35768	1.25	1.30-1.40	.051-.055	2.40-2.50	.095-.098	58.8	13.2
	2.00	1.60-1.70	.063-.067	2.40-2.50	.095-.098	58.8	13.2

Terminal Series No.	Wire Size	Insulation			
		Crimp Height (Ref.)		Crimp Width (Ref.)	
		mm	In.	mm	In.
35768	1.25	3.00	.118	2.90-3.10	.114-.122
	2.00	3.30	.130	2.90-3.10	.114-.122

Tool Qualification Notes:

1. Pull Force should be measured with no influence from the insulation crimp.  
The above specifications are guidelines to an optimum crimp.

**PARTS LIST**

<b>FineAdjust Applicator 63902-7400</b>				
<b>Item</b>	<b>Order No</b>	<b>Engineering No.</b>	<b>Description</b>	<b>Quantity</b>
<b>Perishable Tooling</b>				
	63902-7470	63902-7470	Tool Kit (All "Y" Items)	REF
1	63444-2437	63444-2437	Conductor Punch	1 Y
2	63455-0120	63455-0120	Conductor Anvil	1 Y
3	63454-0095	63454-0095	Insulation Punch	1 Y
4	63445-2948	63445-2948	Insulation Anvil	1 Y
5	63443-0005	63443-0005	Front Cut-Off Plunger	1 Y
6	63443-0012	63443-0012	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	63443-0009	63443-0009	Front Scrap Chute	1
11	63443-0025	63443-0025	Key	1
12	63443-0090	63443-0090	Wire Stop	1
13	63443-0093	63443-0093	Shank- Terminal Hold Down	1
14	63443-1717	63443-1717	Height Spacer	1
15	63443-2203	63443-2203	Coarse Spacer (3.00mm)	1
16	63443-2214	63443-2214	Coarse Spacer (14.00mm)	1
17	63443-3101	63443-3101	Front Plunger Striker	1
18	63443-6123	63443-6123	Rear Cover	1
19	63443-7105	63443-7105	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	M4 by 6 Long SHCS	3**
26	N/A	N/A	M4 by 12 Long BHCS	2**
27	N/A	N/A	M4 by 50 Long SHCS	2**
28	N/A	N/A	M5 by 12 Lg SHCS	1**
29	N/A	N/A	#10-32 by 3/8" Long Flat Point SSS	1**
30	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

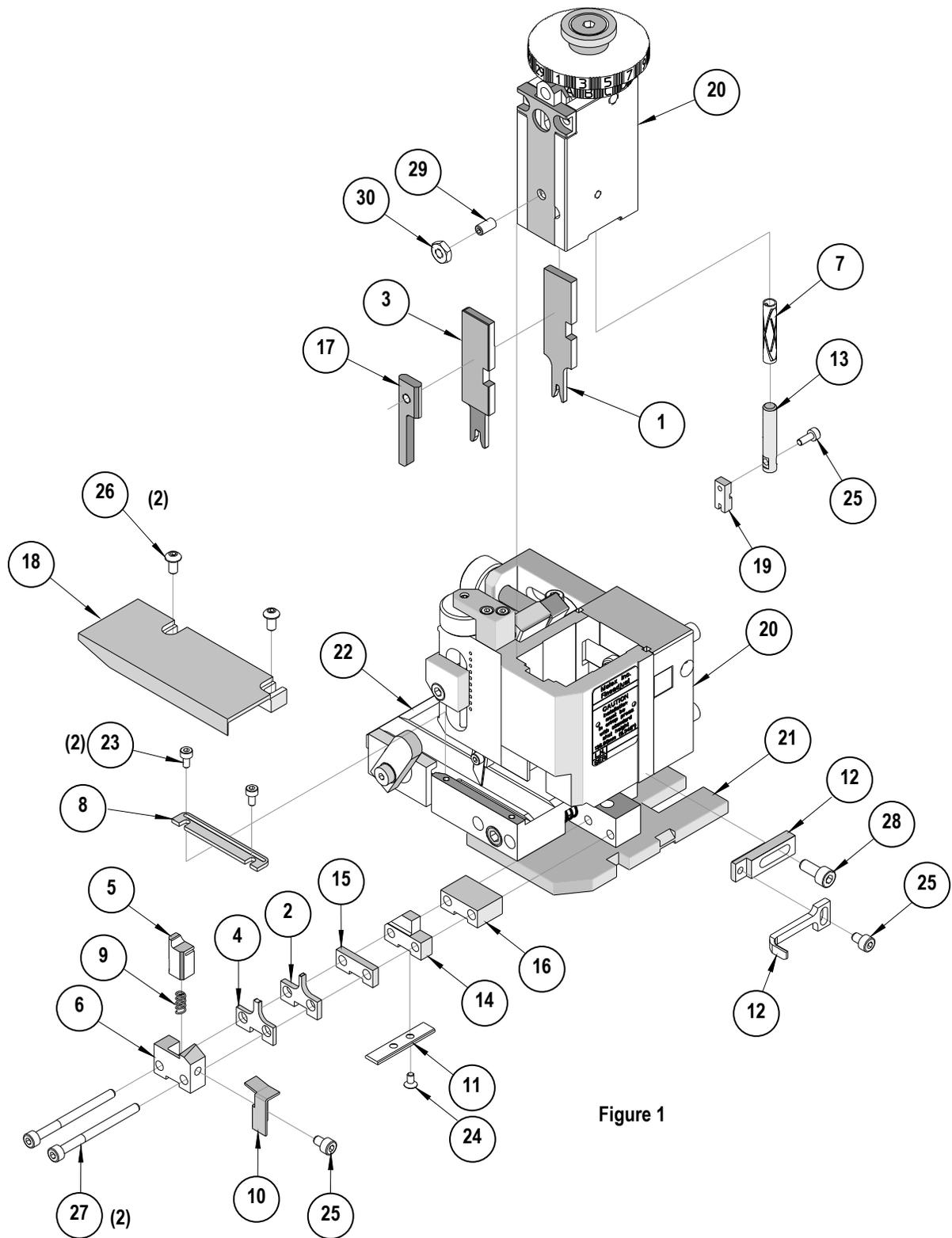


Figure 1

## 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.

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