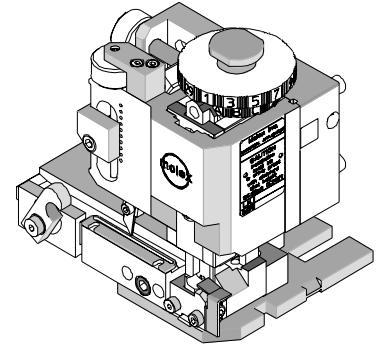




# FineAdjust Applicator Specification Sheet Part No. 63861-8100



## 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

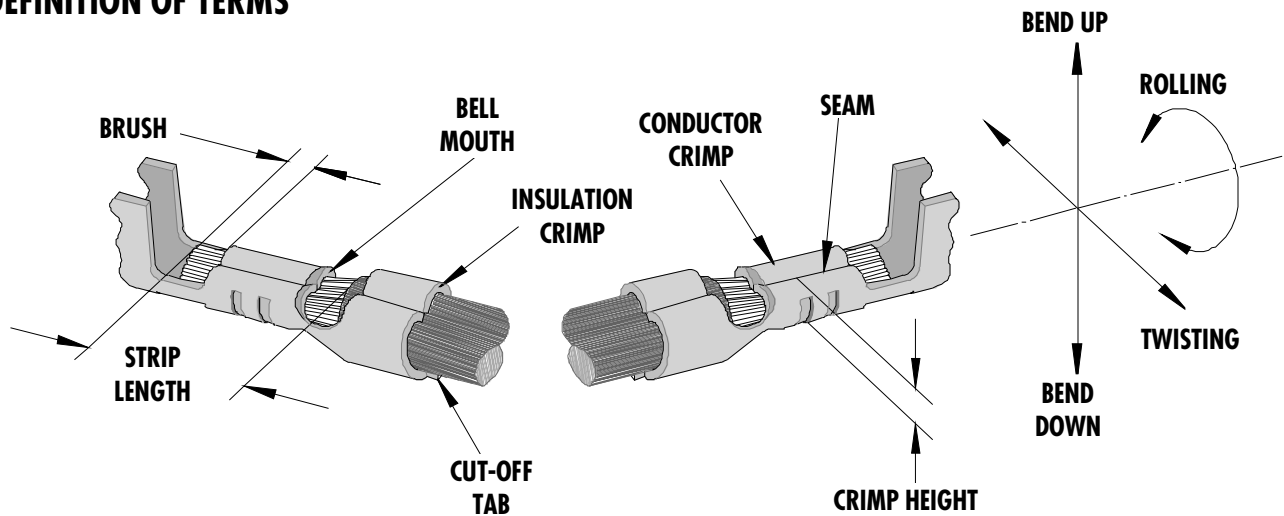
## SCOPE

Products: 2.00mm (.079") Wire to Board Dual Grid Connector Receptacle Terminal

Terminal Order No.	Wire Size		Insulation Diameter		Strip Length	
	AWG	mm <sup>2</sup>	mm	In.	mm	In.
501648-1000	26-28	0.08-0.13	0.85-1.40	.033-.055	2.10-2.50	.083-.098

**Note: Terminal will accommodate the UL1007 wires**

## 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 Order No.	Bell mouth		Cut-off Tab Max.		Conductor Brush	
	mm	In.	mm	In.	mm	In.
501648-1000	0.10-0.45	.004-.018	0.25	.010	0.10-0.90	.004-.035

Terminal Order 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	mm	In	mm	In	
501648-1000	3	3	3	8	1.00	.039	1.50	.059	

After crimping, the crimp profiles should measure the following:

Terminal Order No.	Wire Size		Conductor			
			Crimp Height		Crimp Width (Ref)	
	AWG	mm <sup>2</sup>	mm	In.	mm	In.
501648-1000	26	0.13	0.66-0.71	.026-.028	1.07	.042
501648-1000	28	0.08	0.63-0.68	.025-.027	1.07	.042

Terminal Order No.	Wire Size		Insulation				Pull Force Min.	
			Crimp Height (Ref)		Crimp Width (Ref)			
	AWG	mm <sup>2</sup>	mm	In.	mm	In.	N	Lb.
501648-1000	26	0.13	1.55	.061	1.60	.063	19.6	4.4
501648-1000	28	0.08	1.50	.059	1.60	.063	9.8	2.2

\* Tool Qualification Notes:

1. This Applicator was qualified to the above specifications with UL1007 wire.
2. Pull Force should be measured with no influence from the insulation crimp.
3. The above specifications are guidelines to an optimum crimp.

**PARTS LIST**

<b>FineAdjust Applicator 63861-8100</b>				
<b>Item</b>	<b>Order No</b>	<b>Engineering No.</b>	<b>Description</b>	<b>Quantity</b>
<b>Perishable Tooling</b>				
	63861-8170	63861-8170	Tool Kit (All "Y" Items)	REF
1	63444-1009	63444-1009	Conductor Punch	1 Y
2	63445-1013	63445-1013	Conductor Anvil	1 Y
3	63446-1510	63446-1510	Insulation Punch	1 Y
4	63445-1503	63445-1503	Insulation Anvil	1 Y
5	63443-0003	63443-0003	Cut-Off Plunger Front	1 Y
6	63443-0012	63443-0012	Plunger Retainer Front	1 Y
<b>Other Components (18050)</b>				
7	11-24-1067	4996-4	Cut-off Plunger Spring	1
8	11-40-4039	8302-5	Plunger Striker Front	1
9	63443-0021	63443-0021	Lower Tooling Key	1
10	63443-6003	63443-6003	Rear Cover	1
11	11-18-4083	60707-8	Front Cover	1
12	63443-2404	63443-2404	Anvil Mount	1
13	63443-4025	63443-4025	Wire Stop	1
14	63443-0009	63443-0009	Scrap Chute Front	1
<b>Frame</b>				
15	63800-4901	63800-4901	Top	1
16	63801-3281	63801-3281	Base	1
17	63801-4650	63801-4650	Track	1
<b>Hardware</b>				
18	N/A	N/A	M3 by 6 Long SHCS	2**
19	N/A	N/A	M4 by 6 Long SHCS	1**
20	N/A	N/A	M4 by 12 Long BHCS	2**
21	N/A	N/A	M4 by 16 Long SHCS	1**
22	N/A	N/A	M4 by 20 Long SHCS	1**
23	N/A	N/A	M4 by 50 Long SHCS	1**
24	N/A	N/A	3MM by 6 Long Roll Pin	1**
25	N/A	N/A	#10-32 by 1/4" Long BHCS	1**
** Available from an industrial supply company such as MSC (1-800-645-7270).				

# Assembly Drawing

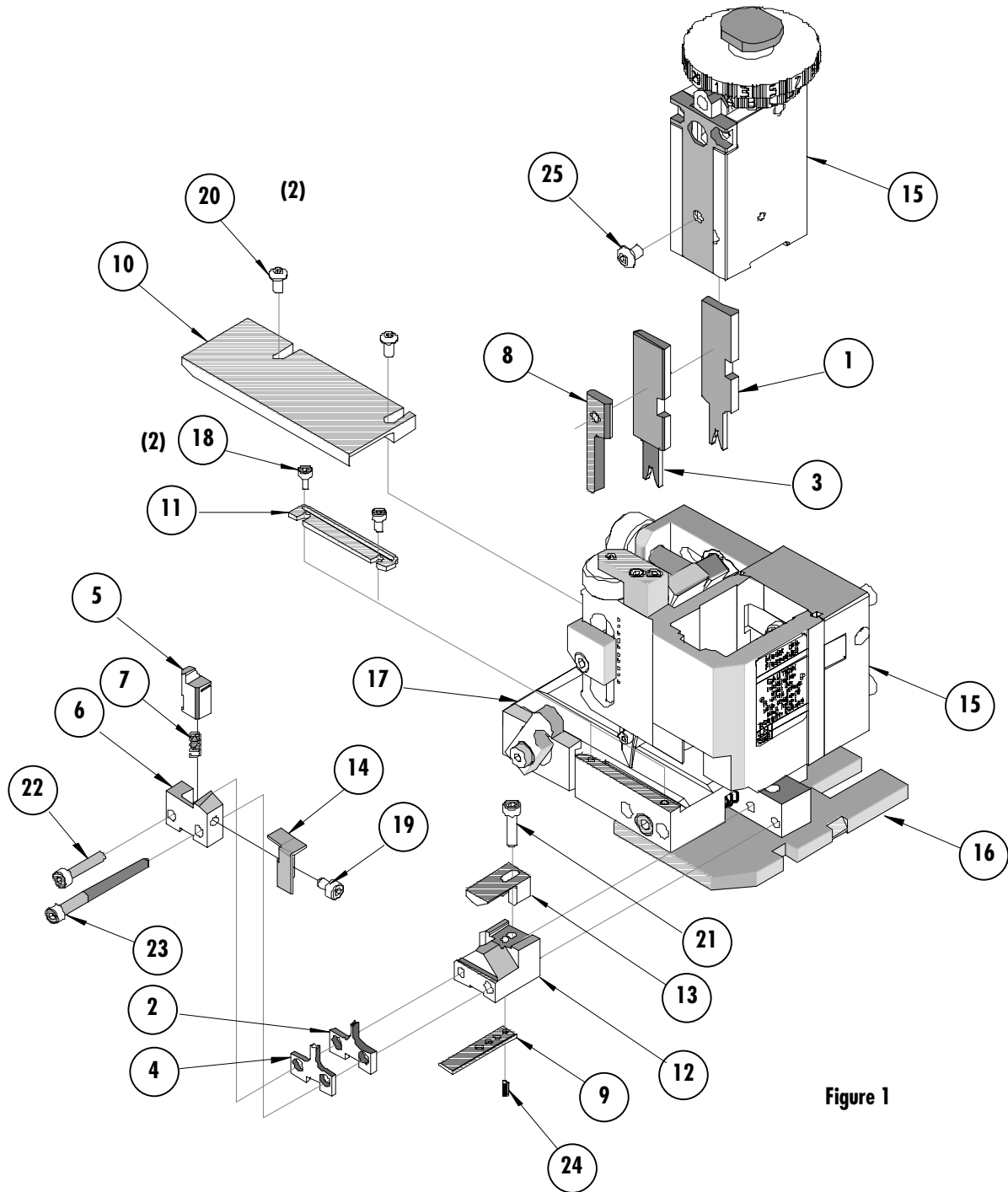


Figure 1

## 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.

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