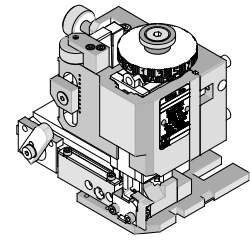


**FineAdjust
Applicator**



**Application Tooling
Specification Sheet**



Order No. 63904-1800

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

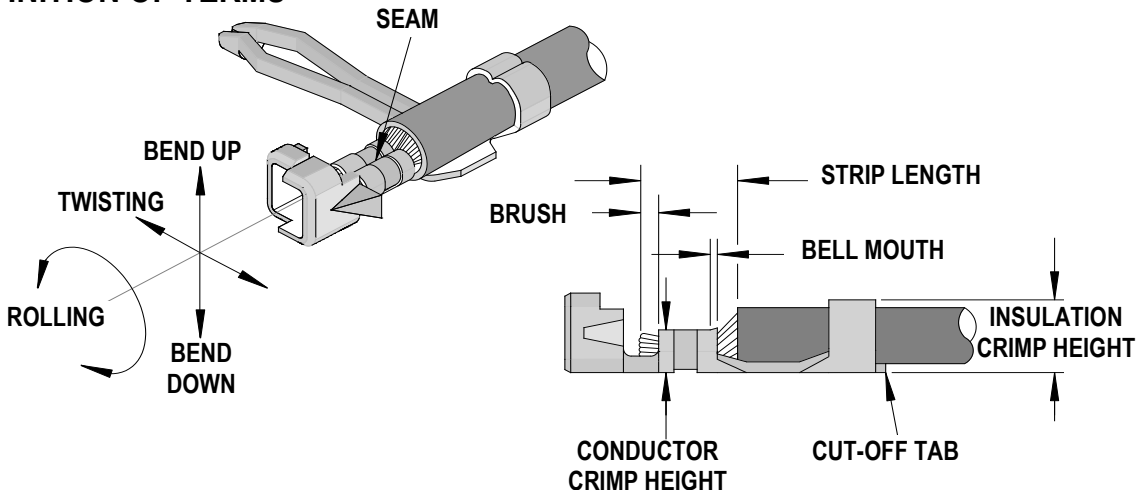
SCOPE

Products: Right Angle, 2.50mm (.098") Board-In Terminal for 22-28 AWG.

Terminal Series No.	Terminal Order No.	Wire Size		Insulation Diameter				Strip Length	
				IPC/WHMA-A620 (1)		Terminal Max (2)			
		AWG	mm ²	mm	In.	mm	In.	mm	In.
35021	35021-1001	22	--	1.25-1.70	.049-.067	1.90	.075	1.80-2.20	.071-.087
	35021-1100	24	--	1.15-1.50	.045-.059	1.90	.075	1.80-2.20	.071-.087
	35021-1101	26	--	1.15-1.35	.045-.053	1.90	.075	1.80-2.20	.071-.087
	35021-1110	28	--	1.15-1.20	.045-.047	1.90	.075	1.80-2.20	.071-.087
	35021-1160								

(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.
35021	0.20-0.50	.008-.020	0.30	.012	0.0-1.0	0.0-.039

Terminal Series No.	Bend up	Bend down	Twist	Roll	Punch Width mm (Ref)				Seam Seam shall not be open and no wire allowed out of the crimping area
					Conductor		Insulation		
	Degree		Degree		mm	In	mm	In	
35021	3	3	3	3	1.20	.047	1.70	.067	

After crimping, the conductor profile should measure the following.

Terminal Series No.	Wire Size		Conductor			
			Crimp Height		Crimp Width (Ref)	
	AWG	mm ²	mm	In.	mm	In.
35021	22	--	0.88-0.93	.035-.037	1.20	.047
	24	--	0.79-0.84	.031-.033	1.20	.047
	26	--	0.73-0.78	.029-.031	1.20	.047
	28	--	0.67-0.72	.026-.028	1.20	.047

Terminal Series No.	Wire Size		Insulation				Pull Force Minimum	
			Crimp Height (Ref) (2.05mm Max)		Crimp Width (Ref)			
	AWG	mm ²	mm	In.	mm	In.	N	Lb.
35021	22	--	2.00	.079	1.75	.069	39.2	8.80
	24	--	1.80	.071	1.73	.068	29.4	6.60
	26	--	1.75	.069	1.73	.068	19.6	4.40
	28	--	1.65	.065	1.72	.068	9.8	2.20

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 63904-1800				
Item	Order No	Engineering No.	Description	Quantity
Perishable Tooling				
	63904-1870	63904-1870	Tool Kit (All "Y" Items)	REF
1	63457-1208	63457-1208	Conductor Punch	1 Y
2	63455-1204	63455-1204	Conductor Anvil	1 Y
3	63454-1703	63454-1703	Insulation Punch	1 Y
4	63445-1783	63445-1783	Insulation Anvil	1 Y
5	63443-0005	63443-0005	Cut-Off Plunger	1 Y
6	63443-0012	63443-0012	Front Plunger Retainer	1 Y
Other Components				
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	Scrape Chute	1
10	63443-0024	63443-0024	Lower Tooling Key	1
11	63443-0090	63443-0090	Wire Stop	1
12	63443-1703	63443-1703	Height Spacer (17.30mm)	1
13	63443-2215	63443-2215	Coarse Spacer (15.00mm)	1
14	63443-2317	63443-2317	Fine Spacer (3.85mm)	1
15	63443-2805	63443-2805	Front Plunger Striker	1
16	63443-2906	63443-2906	Striker Plunger	1
17	63443-6109	63443-6109	Rear Cover	1
18	63600-0021	63600-0021	Striker Plunger Spring	1
Frame				
19	63800-4901	63800-4901	Top	1
20	63801-3281	63801-3281	Base	1
21	63801-4650	63801-4650	Track	1
Hardware				
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	1**
28	N/A	N/A	#10-32 by 3/8" Long Flat 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

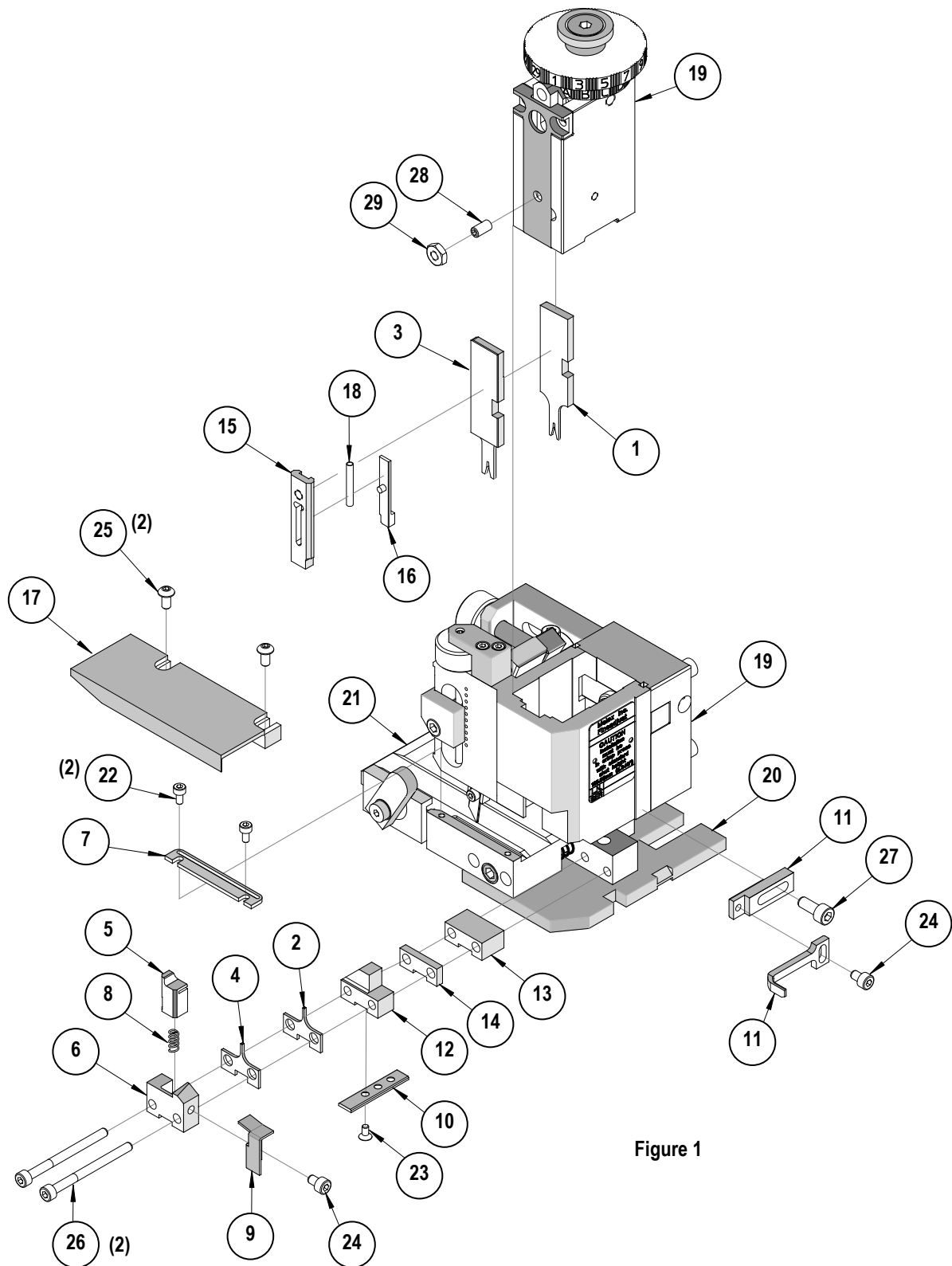


Figure 1

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 135.8mm (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>

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