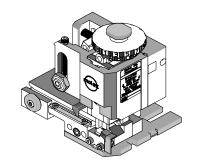


FineAdjust Applicator Specification Sheet Part No. 63866-3100



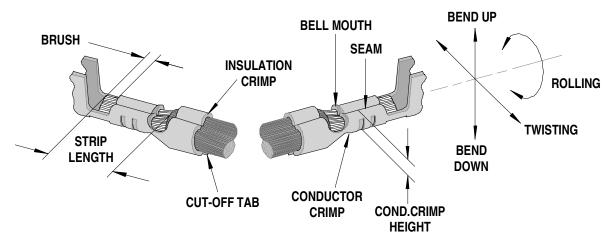
FEATURES

- 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 0.15mm (.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

Terminal	Wi	re Size	Insulation	Diameter	Strip Length		
Series No.	AWG	mm²	mm	ln.	mm	ln.	
42023-****	16-20	0.50-1.30	1.52-2.28	.060090	3.96-5.54	.156218	
42024-***	16-20	0.50-1.30	1.52-2.28	.060090	3.96-5.54	.156218	

DEFINITION OF TERMS



The above terminal drawing is a generic terminal representation. It is not an image of a terminal listed in the scope.

UNCONTROLLED COPY Release Date: 09-30-04 Page 1 of 5 Revision Date: 04-16-08

Doc No: ATS-638663100 Revision: C

CRIMP SPECIFICATION

Terminal	Bell	mouth	Cut-off	Tab Max.	Conductor Brush	
Series No.	mm	ln.	mm	ln.	mm	ln.
42023-****	.2551	.010020	.13	.005	.3870	.015027
42024-***	.2551	.010020	.13	.005	.3870	.015027

Terminal	Bend up Bend down		Twist	Roll	Punch Width mm (Ref)			Seam	
Series No.	Degree		Degree		Conductor		Insulation		Seam shall not be open
Selles No.					mm	In	mm	In	and no wire allowed out
42023-***	3	3	4	8	2.30	.090	3.20	.126	of the crimping area
42024-***	3	3	4	8	2.30	.090	3.20	.126	or the chimping area

After crimping, the conductor profile should measure the following.

	Wire Size			Pull Force Min.				
Terminal Series No.			Hei	ght	Wi	dth	Full I OICE WIII.	
	AWG	mm 2	mm	In	mm	In	N	Lb.
42023-****	16	1.30	1.45-1.55	.057061	2.31-2.51	.091099	200.2	45.0
42023-****	18	0.80	1.27-1.37	.050054	2.28-2.48	.090098	133.4	30.0
42023-****	20	0.50	1.14-1.24	.045049	2.24-2.44	.088096	62.3	14.0
42024-***	16	1.30	1.45-1.55	.057061	2.31-2.51	.091099	200.2	45.0
42024-***	18	0.80	1.27-1.37	.050054	2.28-2.48	.090098	133.4	30.0
42024-***	20	0.50	1.14-1.24	.045049	2.24-2.44	.088096	62.3	14.0

Pull Force should be measured with no influence from the insulation crimp.

The above specifications are guidelines to an optimum crimp.

Doc No: ATS-638663100 Revision: C Re

Release Date: 09-30-04 Revision Date: 04-16-08

PARTS LIST

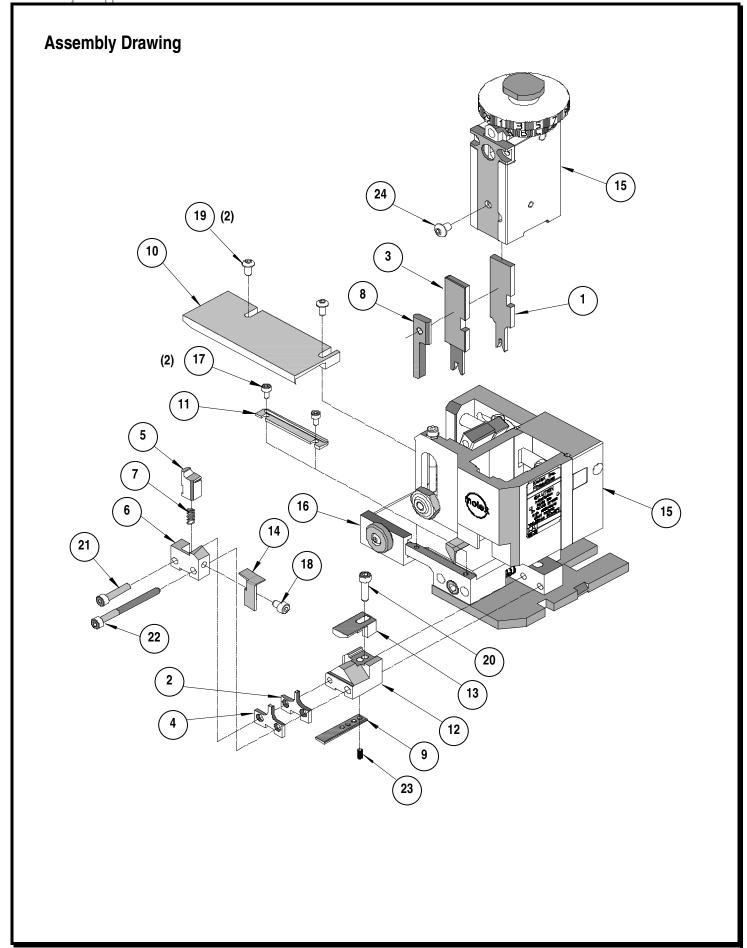
Item	Order No	Engineering No.	Description	Quantity
	63866-3100	63866-3100	FineAdjust Applicator (Fig. 1)	REF
1	63444-2313	63444-2313	Conductor Punch	1 Y
2	63445-2343	63445-2343	Conductor Anvil	1 Y
3	63446-3212	63446-3212	Insulation Punch	1 Y
4	63445-3216	63445-3216	Insulation Anvil	1 Y
5	63443-0002	63443-0002	Cut-Off Plunger	1 Y
6	63443-0012	63443-0012	Front Plunger Retainer	1 Y
7	11-24-1067	4996-4	Cut-off Plunger Spring	1
8	63443-3160	63443-3160	Front Plunger Striker	1
9	63443-0021	63443-0021	Lower Tooling Key	1
10	63443-6011	63443-6011	Rear Cover	1
11	11-18-4083	60707-8	Front Cover	1
12	63443-2415	63443-2415	Anvil Mount	1
13	63443-4006	63443-4006	Wire Stop	1
14	63443-0009	63443-0009	Scrape Chute	1
15	63800-4900	63800-4900	Fine Adjust Applicator Frame	1
16	63860-2015	63860-2015	* Drag Frame (Modified)	1
17	N/A	N/A	M3 by 6Lg. SHCS	2**
18	N/A	N/A	M4 by 6Lg. SHCS	1**
19	N/A	N/A	M4 by 12Lg. BHCS	2**
20	N/A	N/A	M4 by 16Lg SHCS	1**
21	N/A	N/A	M4 by 20Lg. SHCS	1**
22	N/A	N/A	M4 by 50Lg. SHCS	1**
23	N/A	N/A	3MM by 6Lg. Roll Pin	1**
24	N/A	N/A	#10-32 by 1/4"Lg. BHCS	1**
	63866-3170	63866-3170	Tool Kit (All Y Items)	REF

Doc No: ATS-638663100 Revision: C

Release Date: 09-30-04 Revision Date: 04-16-08

^{*} Frame part - To be modified.

** The following purchased parts are available from an Industrial supply company such as MSC (1-800-645-7270).



Doc No: ATS-638663100 Revision: C

Release Date: 09-30-04 Revision Date: 04-16-08

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 135.8 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.

Molex Application Tooling Group

1150 E. Diehl Road Naperville, IL 60563 Tel: (630) 969-4550 Fax: (630) 505-0049

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

UNCONTROLLED COPY Doc No: ATS-638663100 Release Date: 09-30-04 Page 5 of 5 Revision: C