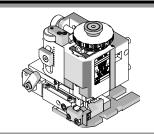


FineAdjust Applicator

Application Tooling Specification Sheet



Order No. 63903-1800

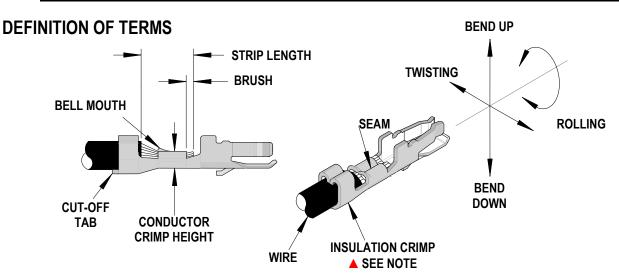
FEATURES

- 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: 1.25mm (.049") Wire to Wire Crimp Terminal, 26-30 AWG.

Terminal Series No.	Terminal	Wire Size			Insulation	Strip Langth			
	Order No.			IPC/WHMA-A620◆		Terminal → →		Strip Length	
Series No.	Order No.	AWG	mm²	mm	ln.	mm	ln.	mm	ln.
504185	504185-1000	26-30	0.12-0.05	0.78-0.90	.031035	0.78-1.02	.031040	1.40-1.60	.055063
505263	505263-1000	26-30	0.12-0.05	0.78-0.90	.031035	0.78-1.02	.031040	1.40-1.60	.055063
To achieve optimum IPC-A620 insulation crimps, use this insulation OD range. ◆◆Overall insulation OD specification for terminal									



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

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INSULATION CRIMP FORM

This crimp terminal is designed for miniaturization; therefore, each dimension of insulation crimp portion appears small as compared to the terminal material



thickness. In order to avoid insulation piercing the crimp forms by the insulation barrel, coining is provided inside of the insulation barrel. For this reason, various crimp forms will occur at the tip of the insulation crimp barrel shown in the figure below.

These crimp forms maybe changed completely by a small change in the wire, insulation punch, or terminal.

These crimp forms are satisfactory for original function of the insulation crimp portion and it is confirmed that all of these forms below are acceptable insulation crimps.

CRIMP SPECIFICATION

Terminal Series No.	Bell n	nouth	Cut-off Tak	Maximum	Conductor Brush	
Terrifical Series No.	mm	ln.	mm	ln.	mm	ln.
504185	0.10-0.30	.004012	0.10	.004	0.10-0.30	.004012
505263	0.10-0.50	.004020	0.10	.004	0.10-0.50	.004020

	Bend up E	Twist Roll		Punch Width mm (Ref)				Seam	
Terminal Series No.	Bella up			Conductor		Insulation			
	Degree		Degree		mm	In	mm	ln	Seam shall not be open
504185	2	3	4	6	0.85	.034	0.90	.035	and no wire allowed out of
505263	3	3	4	8	0.85	.034	0.90	.035	the crimping area

After crimping, the conductor profile should measure the following.

Terminal Series No.		Wire	Size	Conductor C	rimp Height	Pull Force Minimum	
		AWG	mm ²	mm	ln.	N	Lb.
504185	505263	26	0.12	0.54-0.59	.021023	9.8	2.20
		28	0.08	0.49-0.54	.019021	9.8	2.20
		30	0.05	0.46-0.51	.018020	4.9	1.10

Terminal Series No.		Wire	Size		Insulation			
		AWG	mm²	Crimp Hei	ight (Ref.)	Crimp Width (Ref.)		
				mm	ln.	mm	ln.	
	505263	26	0.12	1.19-1.29	.047051	0.97	.038	
504185		28	0.08	1.18-1.28	.046050	0.97	.038	
		30	0.05	1.08-1.18	.042046	0.97	.038	

Tool Qualification Notes:

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

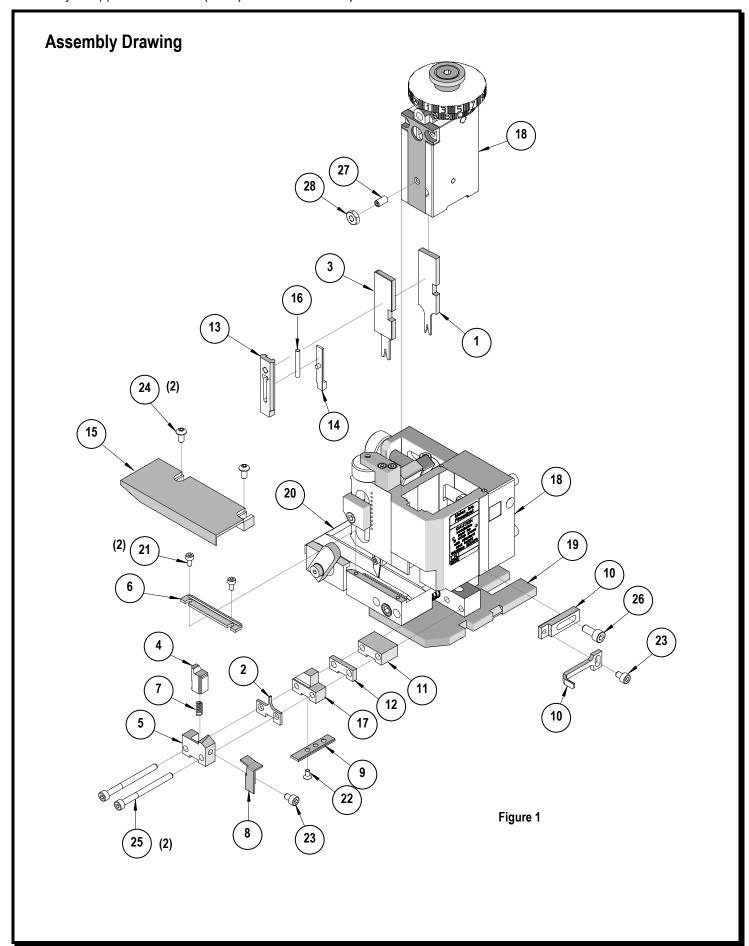
2. The above specifications are guidelines to an optimum crimp.

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PARTS LIST

FineAdjust Applicator 63903-1800										
Item	Order No	Engineering No.	Description	Quantity						
	Perishable Tooling									
	63903-1870	63903-1870	Tool Kit (All "Y" Items)	REF						
1	63457-0103	63457-0103	Conductor Punch	1 Y						
2	63455-0135	63455-0135	Conductor Anvil	1 Y						
3	63446-0905	63446-0905	Insulation Punch	1Y						
4	63443-0005	63443-0005	Cut-Off Plunger	1 Y						
5	63443-0012	63443-0012	Front Plunger Retainer	1 Y						
		Other	Components							
6	11-18-4083	60707-8	Feed Guide	1						
7	11-24-1067	4996-4	Cut-Off Plunger Spring	1						
8	63443-0009	63443-0009	Front Scrap Chute	1						
9	63443-0024	63443-0024	Key	1						
10	63443-0090	63443-0090	Wire Stop	1						
11	63443-2217	63443-2217	Coarse Spacer (17.00mm)	1						
12	63443-2310	63443-2310	Fine Spacer (3.50mm)	1						
13	63443-2806	63443-2806	Front Plunger Striker	1						
14	63443-2904	63443-2904	Wire Hold Down Plunger	1						
15	63443-6108	63443-6108	Rear Cover	1						
16	63600-0021	63600-0021	Compression Spring	1						
17	63903-1811	63903-1811	Height Spacer (19.00mm)	1						
			Frame							
18	63800-4901	63800-4901	Тор	1						
19	63801-3281	63801-3281	Base	1						
20	63801-4650	63801-4650	Track	1						
		Н	ardware							
21	N/A	N/A	M3 by 6 Long SHCS	2**						
22	N/A	N/A	M3 by 6 Long FHCS	1**						
23	N/A	N/A	M4 by 6 Long SHCS	2**						
24	N/A	N/A	M4 by 12 Long BHCS	2**						
25	N/A	N/A	M4 by 45 Long SHCS	2**						
26	N/A	N/A	M5 by 12 Long SHCS	1**						
27	N/A	N/A	#10-32 by 3/8"Long Flat Point SSS	1**						
28	N/A	N/A	#10-32 Hex Jam Nut	1**						
*	** Available from an industrial supply company such as MSC (1-800-645-7270).									

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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.

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

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