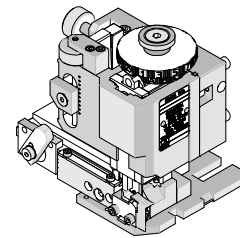




**FineAdjust  
Applicator**

**Application Tooling  
Specification Sheet**



**Order No. 63902-8500**

**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

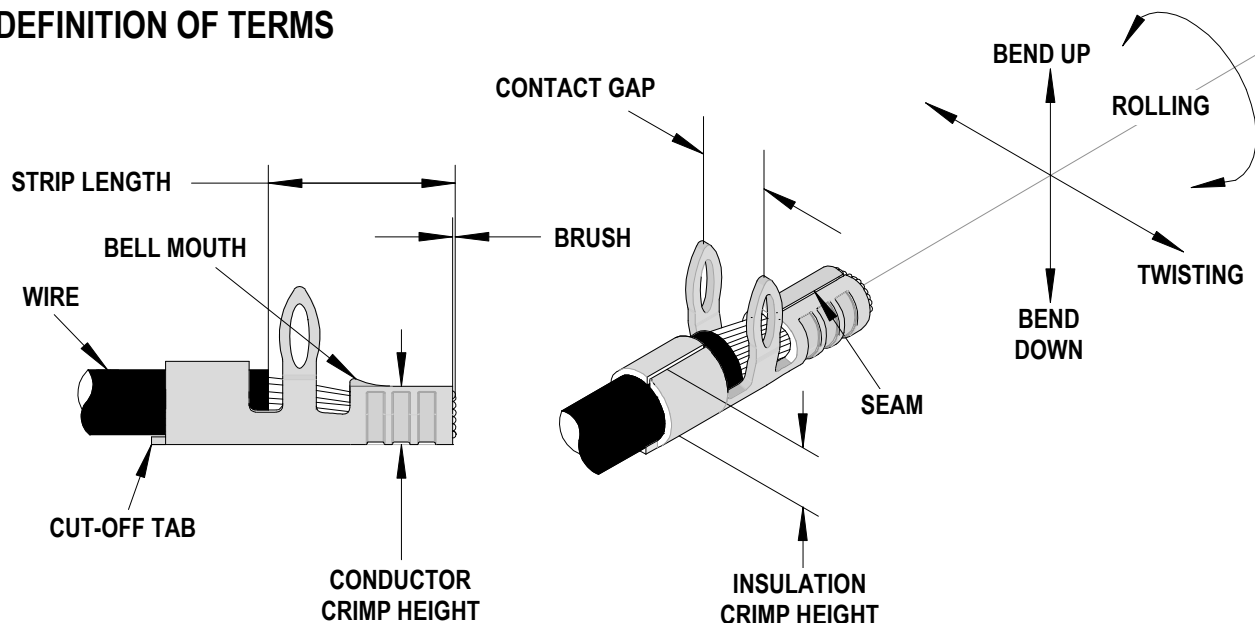
**SCOPE**

Products: Right Angle Board-In Terminal, 16AWG.

Terminal Series No.	Terminal Order No.	Wire Size		Insulation Diameter				Strip Length	
				IPC/WHMA-A620 (1)		Terminal Max. (2)			
		AWG	mm <sup>2</sup>	mm	In.	mm	In.	mm	In.
171892	171892-0100	16	1.30	1.80-2.00	.071-.079	2.39	.094	5.40-5.70	.212-.224

(1) To achieve optimum IPC-A620 insulation crimps, use this insulation OD range.  
 (2) Overall insulation OD specification for terminal.

**DEFINITION OF TERMS**



### CRIMP SPECIFICATION

Terminal Series No.	Bell mouth		Cut-off Tab Maximum		Conductor Brush Maximum	
	mm	In.	mm	In.	mm	In.
171892	0.20-0.50	.008-.020	0.30	.012	0.45	.018

Terminal Series No.	Bend up	Bend down	Twist	Roll	Punch Width (Ref)				Contact Gap (Center to Center)	
	Degree		Degree		Conductor		Insulation		mm	In.
	mm	In.	mm	In.	mm	In.	mm	In.	mm	In.
171892	5	5	5	10	2.30	.090	2.30	.090	2.30-2.80	.090-.110
<b>Seam</b>										
Seam shall not be open and no wire allowed out of the crimping area										

After crimping, the crimp profiles should measure the following:

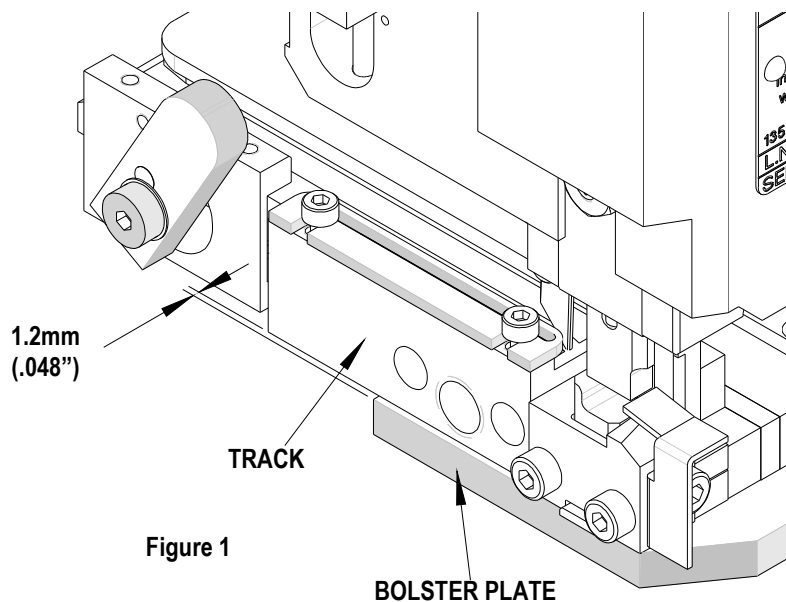
Terminal Series No.	Wire Size		Conductor				Insulation		Pull Force Minimum	
			Crimp Height		Crimp Width (Ref)		Crimp Height			
	AWG	mm <sup>2</sup>	mm	In.	mm	In.	mm	In.	N	Lb.
171892	16	1.30	1.48-1.52	.058-.060	2.45	.096	2.45	.096	133.5	30.0

**\* 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.

### Track Adjustment

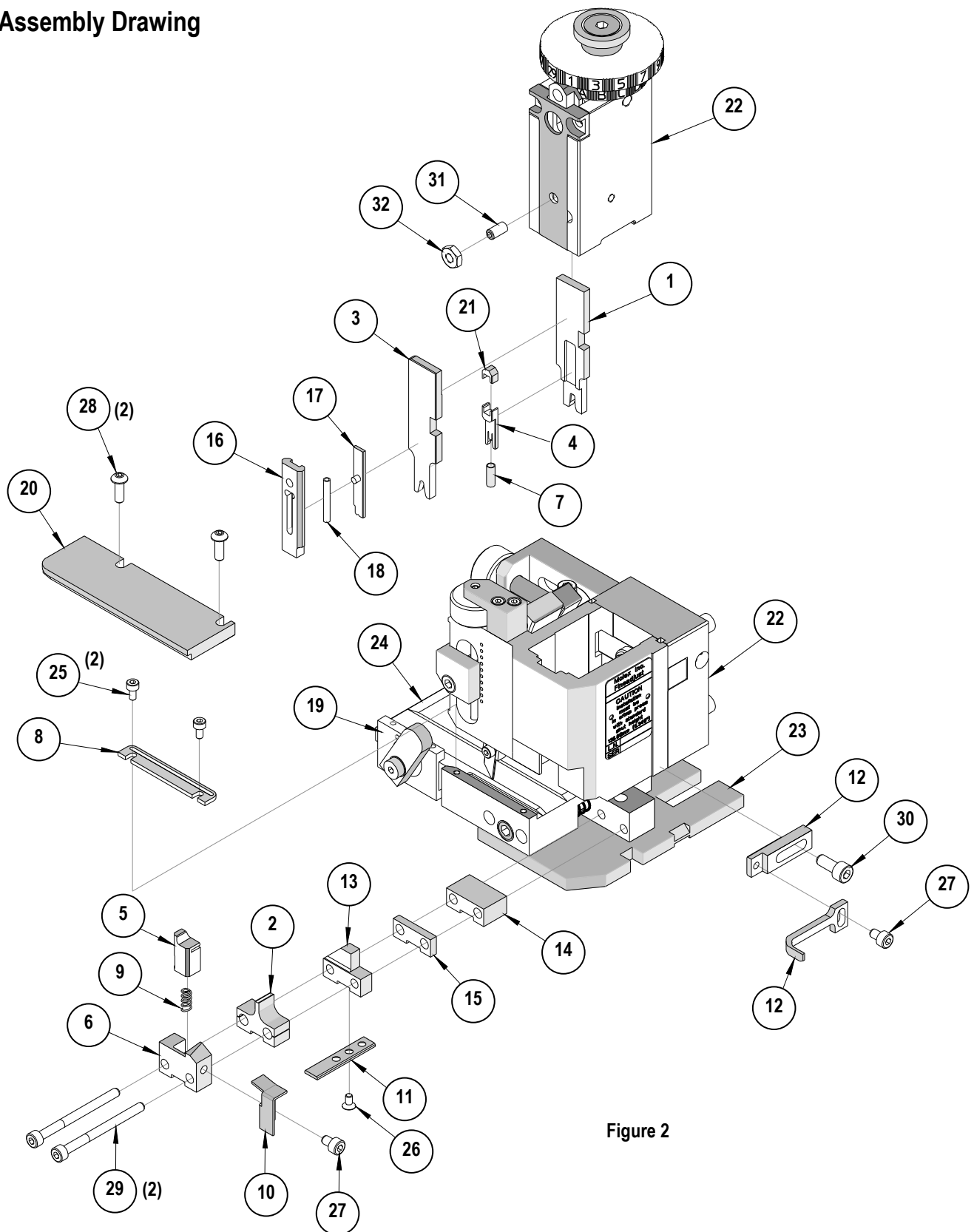
The correct track set-up for this applicator is shown in Figure 1.



**PARTS LIST**

<b>FineAdjust Applicator 63902-8500</b>				
<b>Item</b>	<b>Order No</b>	<b>Engineering No.</b>	<b>Description</b>	<b>Quantity</b>
<b>Perishable Tooling</b>				
	63902-8570	63902-8570	Tool Kit (All "Y" Items)	REF
1	63457-2303	63457-2303	Conductor Punch	1 Y
2	63456-2301	63456-2301	Combination Anvil	1 Y
3	63454-2403	63454-2403	Insulation Punch	1 Y
4	63902-8511	63902-8511	Terminal Retainer	1 Y
5	63443-0002	63443-0002	Front Cut-Off Plunger	1 Y
6	63443-0012	63443-0012	Front Plunger Retainer	1 Y
<b>Other Components</b>				
7	11-17-0094	1739-37	Pawl 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	63443-0024	63443-0024	Key	1
12	63443-0090	63443-0090	Wire Stop	1
13	63443-1720	63443-1720	Height Spacer	1
14	63443-2212	63443-2212	Coarse Spacer (12.00mm)	1
15	63443-2319	63443-2319	Fine Spacer (3.95mm)	1
16	63443-2801	63443-2801	Plunger Striker	1
17	63443-2917	63443-2917	Wire Hold Down Plunger	1
18	63600-1057	63600-1057	Compression Spring	1
19	63860-2015	63860-2015	Drag Frame Modified	1
20	63902-8510	63902-8510	Rear Cover	1
21	63902-8512	63902-8512	Retainer Spring	1
<b>Frame</b>				
22	63800-4901	63800-4901	Top	1
23	63801-3281	63801-3281	Base	1
24	63801-4650	63801-4650	Track	1
<b>Hardware</b>				
25	N/A	N/A	M3 by 6 Long SHCS	2**
26	N/A	N/A	M3 by 6 Long FHCS	1**
27	N/A	N/A	M4 by 6 Long SHCS	2**
28	N/A	N/A	M4 by 12 Long BHCS	2**
29	N/A	N/A	M4 by 50 Long SHCS	2**
30	N/A	N/A	M5 by 12 Long SHCS	1**
31	N/A	N/A	#10-32 by 3/8" Long Flat Point SSS	1**
32	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



## 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.

### Contact Information

For more information on Molex application tooling please contact Molex at 1-800-786-6539.

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