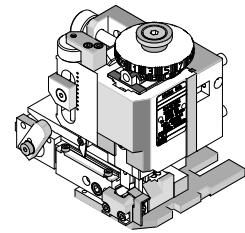


**FineAdjust  
Applicator**



**Application Tooling  
Specification Sheet**



**Order No. 63902-3100**

**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 .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

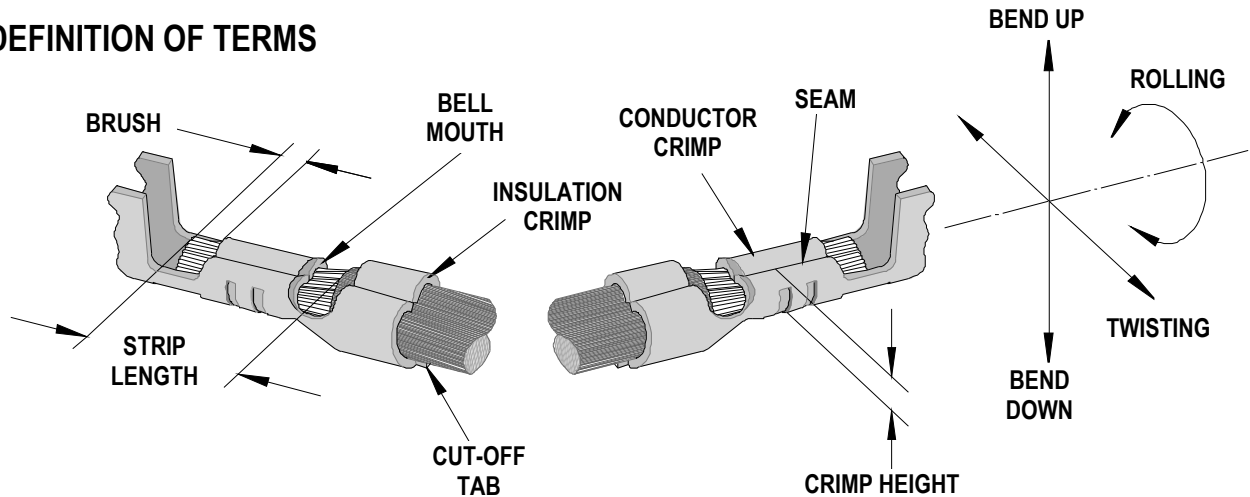
**SCOPE**

Products: 2.50mm (.098") Pitch SPOX™ Male Crimp Terminal, 22 - 24 AWG.

Terminal Series No.	Terminal Order No.		Wire Size		Insulation Diameter				Strip Length	
					IPC/WHMA-A620 (1)		Terminal (2)			
					AWG	mm <sup>2</sup>	mm	In.		
5263	08-70-1039	39-00-0042	22 - 28	0.35-0.08	1.40-1.60	.055-.063	1.15-1.90	.045-.075	2.40-2.90	.094-.114
	08-70-1045	39-00-0151								
	08-70-1047	39-00-0160								
	08-70-1048	98-00-0242								
45627	45627-0001	45627-1001	22 - 24	0.35-0.20	1.40-1.60	.055-.063	1.15-1.90	.045-.075	2.40-2.90	.094-.114
	45627-0002	45627-1002								

(1) To achieve optimum IPC-A620 insulation crimps, use this insulation OD range  
 (2) Overall insulation OD specification for terminal.  
 Applicator 63902-6400 should be used for insulation OD 1.20-1.38mm

### DEFINITION OF TERMS



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

### CRIMP SPECIFICATION

Terminal Series No.	Bell mouth		Cut-off Tab Maximum		Conductor Brush	
	mm	In.	mm	In.	mm	In.
5263	0.20-0.50	.008-.020	0.30	.012	0.00-1.00	.000-.039
45627	0.20-0.50	.008-.020	0.30	.012	0.00-1.00	.000-.039

Terminal Series 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		
	mm	In	mm	In	mm	In	mm	In	
5263	4	2	8	8	1.40	.055	1.90	.075	
45627	4	2	8	8	1.40	.055	1.90	.075	

After crimping, the conductor profile should measure the following.

Terminal Series No.	Wire Size		Crimp Height		Pull Force Minimum	
	AWG	mm <sup>2</sup>	mm	In.	N	Lb.
5263	22	0.35	0.69-0.76	.027-.030	39.1	8.8
	24	0.20	0.63-0.70	.025-.028	29.4	6.6
	26	0.12	0.59-0.65	.023-.026	19.6	4.4
	28	0.08	0.57-0.63	.022-.025	9.8	2.2
45627	22	0.35	0.69-0.76	.027-.030	39.1	8.8
	24	0.20	0.63-0.70	.025-.028	29.4	6.6

#### 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**

<b>FineAdjust Applicator 63902-3100</b>				
<b>Item</b>	<b>Order No</b>	<b>Engineering No.</b>	<b>Description</b>	<b>Quantity</b>
<b>Perishable Tooling</b>				
	63902-3170	63902-3170	Tool Kit (All "Y" Items)	REF
1	63444-1413	63444-1413	Conductor Punch	1 Y
2	63445-1435	63445-1435	Conductor Anvil	1 Y
3	63446-1906	63446-1906	Insulation Punch	1 Y
4	63445-1906	63445-1906	Insulation Anvil	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	11-18-4083	60707-8	Feed Guide	1
8	11-24-1067	4996-4	Cut-Off Plunger Spring	1
9	11-40-4039	8302-5	Plunger Striker	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	63443-1718	63443-1718	Height Spacer	1
14	63443-2201	63443-2201	Coarse Spacer (1.00mm)	1
15	63443-2215	63443-2215	Coarse Spacer (15.00mm)	1
16	63443-2313	63443-2313	Fine Spacer (3.65mm)	1
17	63443-6113	63443-6113	Rear Cover	1
<b>Frame</b>				
18	63800-4901	63800-4901	Top	1
19	63801-3281	63801-3281	Base	1
20	63801-4650	63801-4650	Track	1
<b>Hardware</b>				
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 50 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).				

### Assembly Drawing

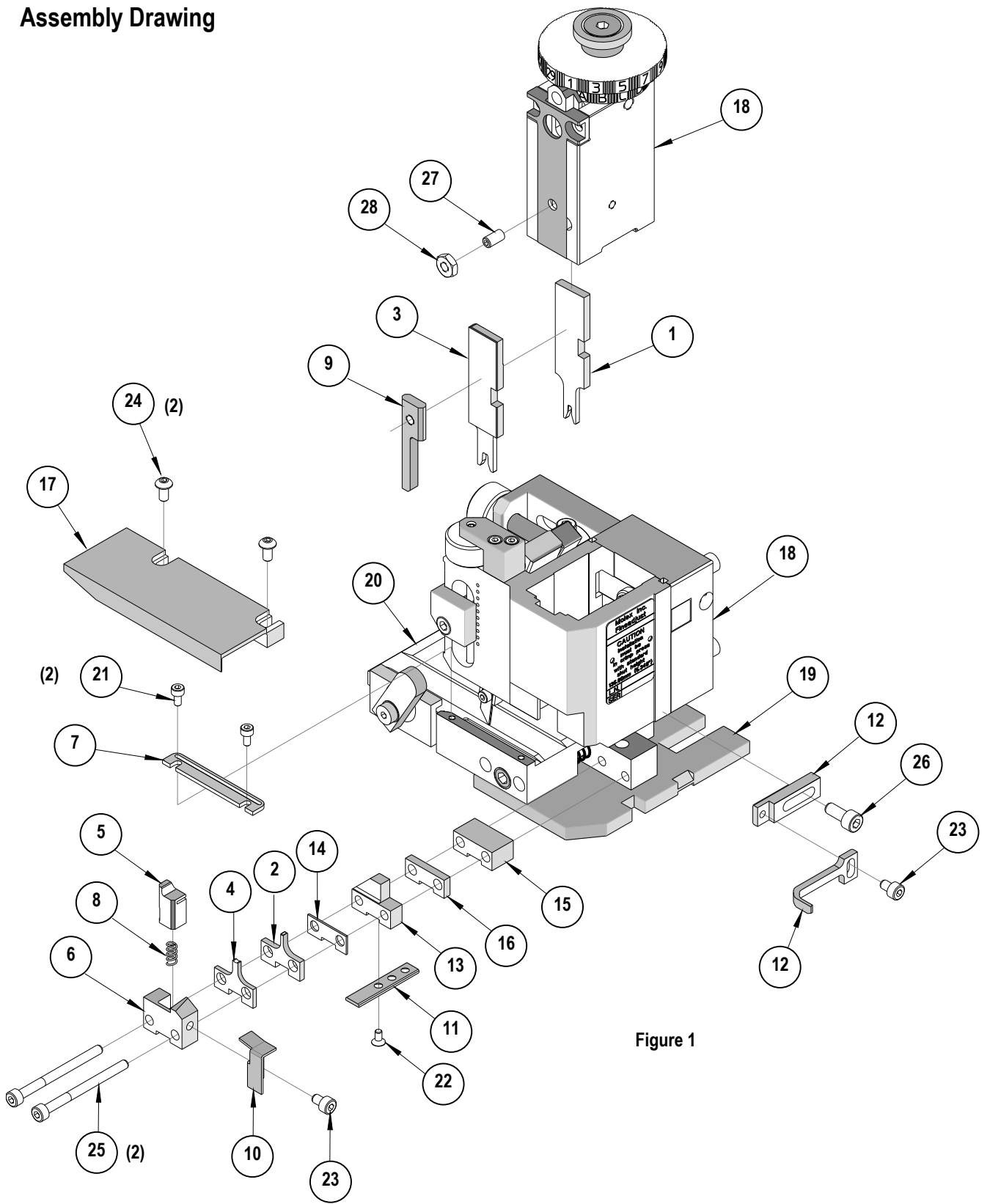


Figure 1

## 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 135.8 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.

<http://www.molex.com>