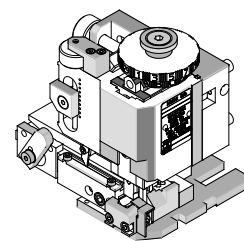




**FineAdjust  
Applicator**

**Application Tooling  
Specification Sheet**



**Order No. 63900-6100**

**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

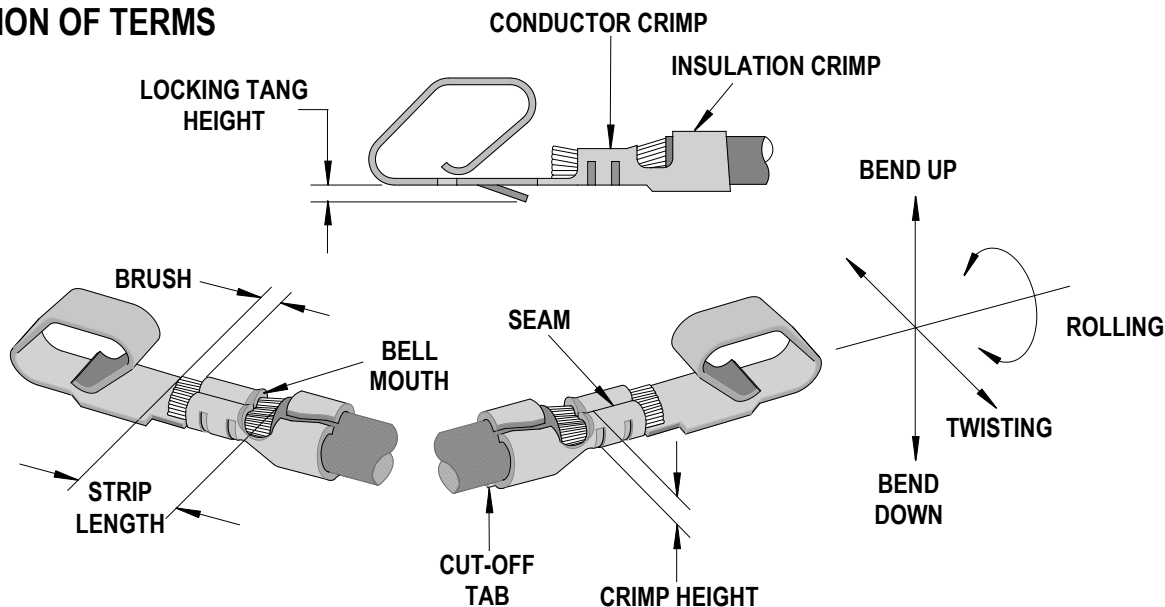
**SCOPE**

Products: KK .156 Crimp Terminal-Humpback with Anti-Fish hook-18 AWG.

Terminal Series No.	Terminal Order No.	Wire Size		◆Insulation Diameter Maximum		Strip Length	
		AWG	mm <sup>2</sup>	mm	In.	mm	In.
45606	45606-0004	18	0.80	2.79	.110	2.90-3.70	.114-.146

Note: Terminal will accommodate the UL1015 and UL1120 wires.  
◆Insulation crimp to meet IPC/WHMA-A-620 Class 2 compliance.

**DEFINITION OF TERMS**



## CRIMP SPECIFICATION

Terminal Series No.	Bell mouth		Cut-off Tab Maximum		Conductor Brush	
	mm	In.	mm	In.	mm	In.
45606	0.20-0.50	.008-.020	0.50	.020	0.10-0.60	.004-.024

Terminal Series No.	Bend up	Bend down	Twist	Roll	Punch Width (Ref)				Seam
					Conductor		Insulation		
	Degree (Max)		Degree (Max)		mm	In	mm	In	
45606	3	3	4	8	1.90	.075	3.00	.118	Seam shall not be open and no wire allowed out of the crimping area

After crimping, the conductor profile should measure the following.

Terminal Series No.	Wire Size		Conductor Crimp Height		Insulation Crimp Height (Ref.)		Pull Force Minimum	
	AWG	mm <sup>2</sup>	mm	In.	mm	In.	N	Lb.
45606	18	0.80	1.07-1.12	.042-.044	3.00	.118	89.0	20.00

### 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 63900-6100				
Item	Order No	Engineering No.	Description	Quantity
<b>Perishable Tooling</b>				
	63900-6170	63900-6170	Tool Kit (All "Y" Items)	REF
1	63444-1913	63444-1913	Conductor Punch	1 Y
2	63445-1949	63445-1949	Conductor Anvil	1 Y
3	63446-3026	63446-3026	Insulation Punch	1 Y
4	63445-3045	63445-3045	Insulation Anvil	1 Y
5	63443-0035	63443-0035	Cut-Off Plunger	1 Y
6	63443-0036	63443-0036	Front Plunger Retainer	1 Y
<b>Other Components (006150)</b>				
7	11-18-4083	60707-8	Feed Guide	1
8	63443-0009	63443-0009	Scrape Chute	1
9	63443-0024	63443-0024	Key	1
10	63443-0090	63443-0090	Wire Stop	1
11	63443-1717	63443-1717	Height Spacer (18.70mm)	1
12	63443-2202	63443-2202	Coarse Spacer (2.00mm)	1
13	63443-2213	63443-2213	Coarse Spacer (13.00mm)	1
14	63443-2317	63443-2317	Fine Spacer (3.85mm)	1
15	63443-3160	63443-3160	Front Plunger Striker	1
16	63443-6121	63443-6121	Rear Cover	1
17	63700-0539	63700-0539	Cut-off Plunger Spring	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

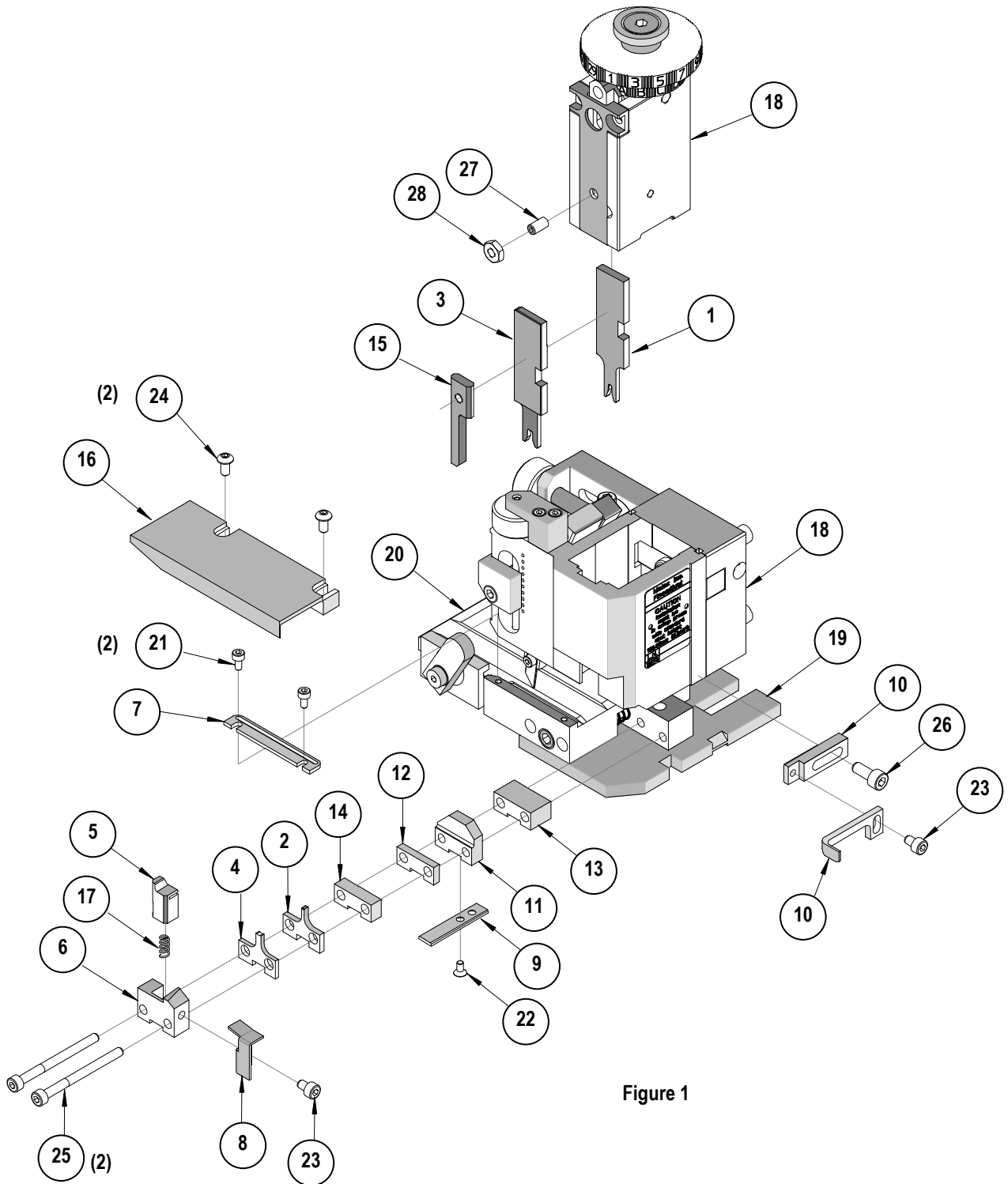


Figure 1

## 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 135.8mm (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>