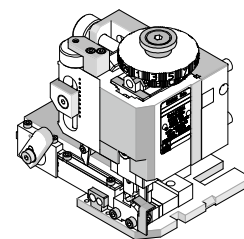


**FineAdjust  
Applicator**



**Application Tooling  
Specification Sheet**



**Order No. 63903-7400**

**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
- **Improved terminal track adjustment – see new track adjustment procedure on page 3.**

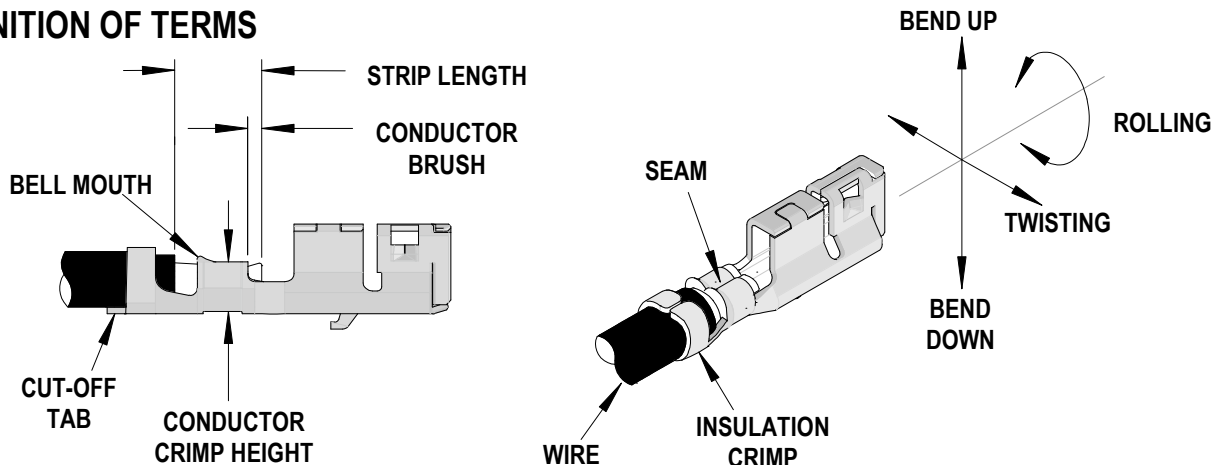
**SCOPE**

Products: 2.00mm W/B DuraClik ISL Series Receptacle Terminals.

Terminal Series No.	Terminal Order No.	Wire			Insulation Diameter				Strip Length	
					IPC/WHMA-A620 (1)		Terminal (2)			
		Wire Type (3)	AWG	mm <sup>2</sup>	mm	In.	mm	In.	mm	In.
560124	560124-0101	AVSS	NA	0.30	1.15-1.40	.045-.055	1.40-1.50	.055-.059	1.30-1.80	.051-.071
	560124-0131	FLR-A	NA	0.35	NA	NA	1.30 Max	.051 Max	2.00	.079
560236	560236-0101	AVSS	NA	0.30	1.15-1.40	.045-.055	1.40-1.50	.055-.059	1.30-1.80	.051-.071
	560236-0131	FLR-A	NA	0.35	NA	NA	1.30 Max	.051 Max	2.00	.079

- (1) To achieve optimum IPC-A620 insulation crimps, use this insulation OD range.  
 (2) Overall insulation OD specification for terminal.  
 (3) See Tool Qualification Notes on page 2.

**DEFINITION OF TERMS**



### CRIMP SPECIFICATION

Terminal Series No.	Bell mouth		Cut-off Tab Maximum		Conductor Brush	
	mm	In.	mm	In.	mm	In.
560124	0.05-0.35	.002-.014	0.15	.006	0.00-0.50	.000-.020
560236						

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
					Conductor		Insulation		
	Degree Max.	Degree Max.	mm	In	mm	In			
560124	4	3	3	4	1.20	.047	1.45	.057	
560236									

After crimping, the crimp profiles should measure the following:

Terminal Series No.	Wire			Conductor				Insulation				Pull Force Minimum	
				Crimp Height		Crimp Width		Crimp Height		Crimp Width (Ref)			
	Wire Type	AWG	mm <sup>2</sup>	mm	In.	mm	In.	mm	In.	mm	In.	N	Lb.
560124	AVSS	NA	0.30	0.73-0.78	.029-.031	1.20-1.30	.047-.051	1.45-1.55	.057-.061	1.55	.061	58	13.0
	FLR-A	NA	0.35	0.68-0.73	.027-.029	1.20-1.30	.047-.051	1.28-1.38	.050-.054	1.55	.061	58	13.0
560236	AVSS	NA	0.30	0.73-0.78	.029-.031	1.20-1.30	.047-.051	1.45-1.55	.057-.061	1.55	.061	58	13.0
	FLR-A	NA	0.35	0.68-0.73	.027-.029	1.20-1.30	.047-.051	1.28-1.38	.050-.054	1.55	.061	58	13.0

#### 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.
3. Oiler (63801-7240) required to crimp all terminals to improve tooling life and minimize the crimp extrusion or flash. See 63800-4900 FineAdjust Manual.
4. FLR-A 0.35mm<sup>2</sup> and terminal 560124-0101 validated to USCAR21 (Rev3) Section 4.3, 4.4 and 4.5.2
5. FLR-A 0.35mm<sup>2</sup> wire and terminal 560124-0101 validated to VW 60330 (Rev. 2013-12) Section 4.3.4 and 5.5.1. Deviation on 4.3.4.8 (CFE Dimension)
6. FLR-A 0.35mm<sup>2</sup> wire and terminal 560124-0101 validated to LV214-2 (Rev 2008-01)

## TRACK ADJUSTMENT PROCEDURE

The terminal track should be adjusted only to correct the size of the bellmouth and cut-off tab. A 2.5mm hex wrench is used for the adjustment. See Figure 1 for part identification.

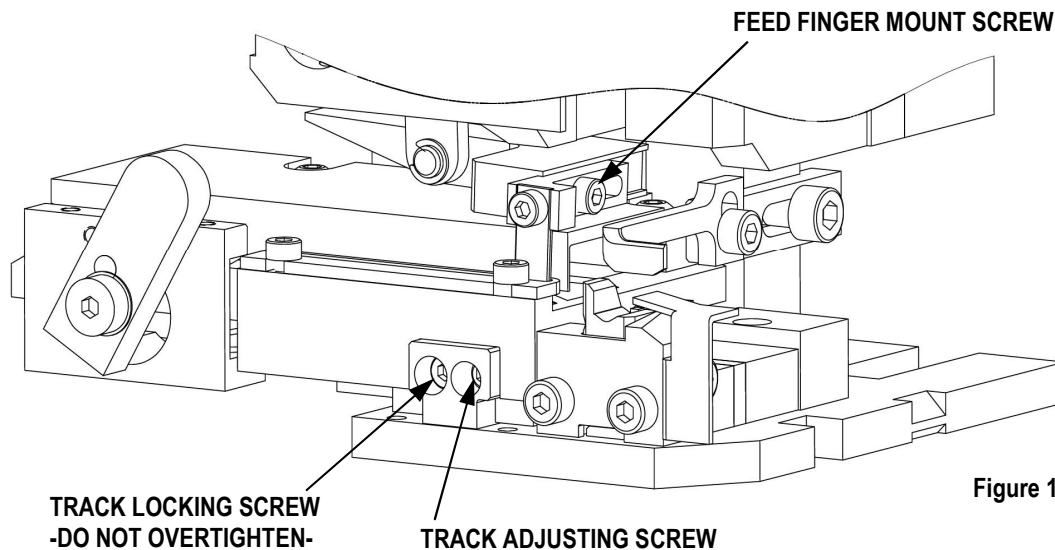


Figure 1

1. Disconnect power from the press.
2. Loosen the feed finger mount screw 1 turn. This allows the feed finger to follow the track adjustment.
3. Loosen the track locking screw 2 turns.
4. Turn the track adjusting screw in the direction needed (one turn of the screw moves the track 0.8mm/0.031in):
  - a. Turn clockwise to move the track in (away from the operator). This adjustment increases the cut-off tab length and decreases the bellmouth size.
  - b. Turn counterclockwise to move the track out (toward the operator). This adjustment decreases the cut-off tab length and increases the bellmouth size. See Notes below.
  - c. Make adjustments in small increments (  $\frac{1}{4}$  to  $\frac{1}{2}$  turn)
5. Tighten the track locking screw until snug. Do not overtighten the screw – about 0.5N-m (5in-lb) is enough to lock the track.
6. Tighten the feed finger mount screw.
7. Make several crimps with wire. Inspect the cut-off tab length and bellmouth size.

### NOTES

- If the track adjusting screw becomes difficult to turn counterclockwise, this means the adjustment has run into the track locking screw. Loosen the track locking screw to gain more outward adjustment.
- If the track is being adjusted outward to reduce cut-off tab, be aware that excessive adjustment will cause the terminal's insulation grips to drag on the cut-off plunger and cause terminal feed problems.

**PARTS LIST**

<b>FineAdjust Applicator 63903-7400</b>				
<b>Item</b>	<b>Order No</b>	<b>Engineering No.</b>	<b>Description</b>	<b>Quantity</b>
<b>Perishable Tooling</b>				
	63903-7470	63903-7470	Tool Kit (All "Y" Items)	REF
1	63457-1212	63457-1212	Conductor Punch	1 Y
2	63455-0140	63455-0140	Conductor Anvil	1 Y
3	63454-0163	63454-0163	Insulation Punch	1 Y
4	63456-0111	63456-0111	Insulation Anvil	1 Y
5	63443-0005	63443-0005	Cut-Off Plunger	1 Y
6	63443-0012	63443-0012	Front Plunger Retainer	1 Y
<b>Other Components</b>				
7	11-17-0022	1739-21	Hold Down 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	Scrap Chute	1
11	63443-0024	63443-0024	Key	1
12	63443-0090	63443-0090	Wire Stop	1
13	63443-0093	63443-0093	Shank	1
14	63443-1720	63443-1720	Height Spacer (19.00mm)	1
15	63443-2215	63443-2215	Coarse Spacer (15.00mm)	1
16	63443-2307	63443-2307	Fine Spacer (3.35mm)	1
17	63443-2320	63443-2320	Fine Spacer (1.75mm)	1
18	63443-2806	63443-2806	Front Plunger Striker	1
19	63443-2904	63443-2904	Wire Hold-Down Plunger	1
20	63443-6109	63443-6109	Rear Cover	1
21	63600-1057	63600-1057	Striker Plunger Spring	1
22	63903-7407	63903-7407	Terminal Hold Down	1
<b>Frame</b>				
23	63800-4901	63800-4901	Top	1
24	63801-3289	63801-3289	Base	1
25	63801-4652	63801-4652	Track	1
26	63800-4313	63800-4313	Rear Support Block	1
<b>Hardware</b>				
27	N/A	N/A	M3 by 6 Long SHCS	2**
28	N/A	N/A	M3 by 6 Long FHCS	1**
29	N/A	N/A	M3 by 8 Long SHCS	1**
30	N/A	N/A	M4 by 6 Long SHCS	2**
31	N/A	N/A	M4 by 12 Long BHCS	2**
32	N/A	N/A	M4 by 50 Long SHCS	2**
33	N/A	N/A	M5 by 6 Long BHCS	1**
34	N/A	N/A	M5 by 12 Long SHCS	1**
35	N/A	N/A	#10-32 by 3/8" Long Flat Point SSS	1**
36	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

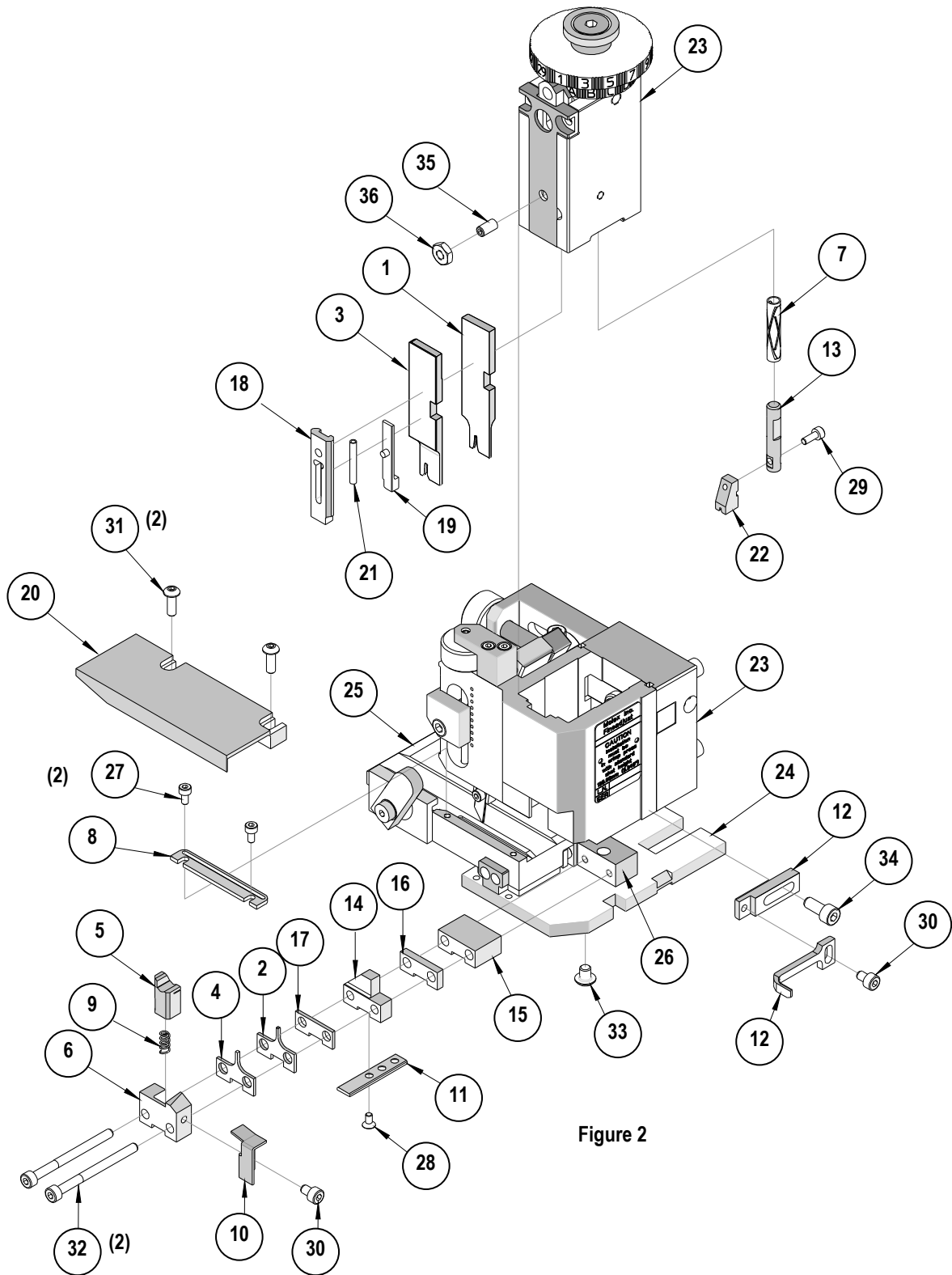


Figure 2


## 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.

 <b>CAUTION</b>	<p><b>CAUTION:</b> Molex tooling crimp specifications are valid only when used with Molex terminals and tooling manufactured by Molex and sold by Molex or authorized distributors ("Molex Tooling"). When using tooling other than Molex Tooling with Molex specific connector systems listed in our ATS documents, the Molex tooling qualification does not apply and the responsibility for full qualification of the connector system is that of the customer. Molex accepts no liability for connector performance or tooling support where tooling other than Molex Tooling is used or where Molex Tooling is modified.</p>
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