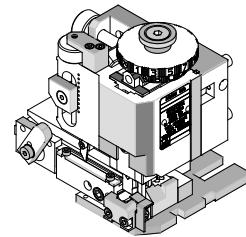


FineAdjust  
ApplicatorApplication Tooling  
Specification Sheet

Order No. 63903-9500

**FEATURES**

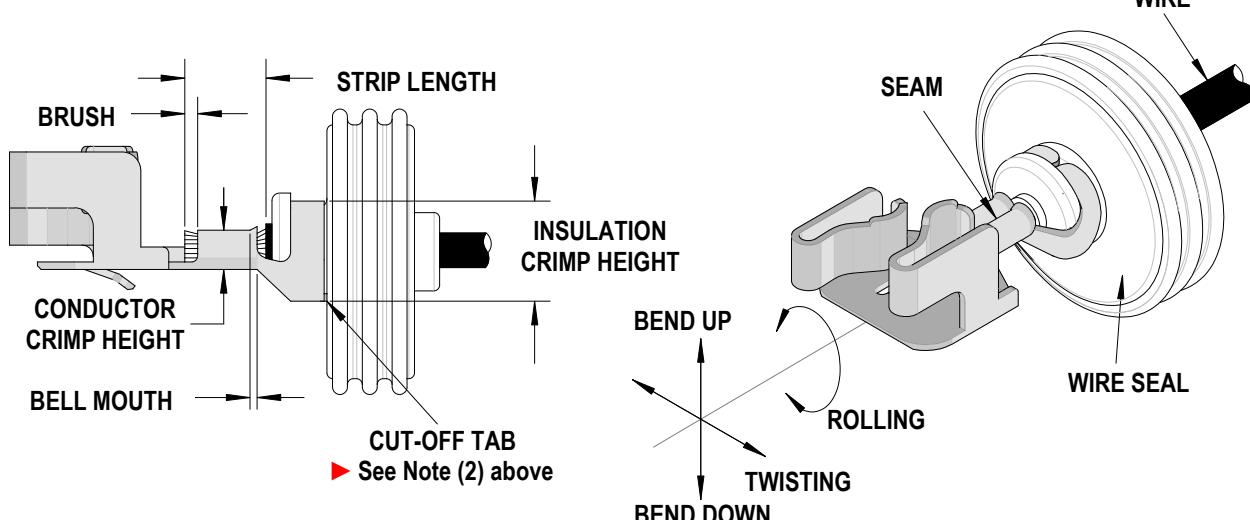
- Quick punch removal with the push of a button for fast and easy tooling change
- Applicator designed to industry standard mounting and shut height 135.80mm (5.346")
- Quick set-up time; plus the crimp height, track and feed adjustments can be set without removing the applicator from the press
- Fine 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
- Safety Guard Panel mounts directly to the Molex TM3000 style press.

**SCOPE**

Products: S8 Double Crimp Terminals.

Terminal Series No	Terminal Order No.	Wire Size		Insulation Diameter Terminal (1)		Strip Length	
		Wire Type	mm <sup>2</sup>	mm	In.	mm	In.
49868	49868-9702	AVS 0.5SQ	0.50	2.0-2.1	.079-.083	5.0- 5.5 mm	.197-.217
		FLRY-A 0.75SQ	0.75	1.7-1.9	.067-.075		
		AVS 0.85SQ	0.85	2.2-2.3	.087-.090		

(1) Overall insulation OD specification for terminal.  
 (2) ► Cut-off tab should be flush with insulation grip so seal does not get damaged when terminal is crimped

**DEFINITION OF TERMS**

**CRIMP SPECIFICATION**

Terminal Series No.	Bell mouth		Cut-off Tab Maximum See Note ► (2)		Conductor Brush	
	mm	In.	mm	In.	mm	In.
49868	0.30-0.60	.012-.024			0.30-0.80	.012-.031

Terminal Series No.	Bend up	Bend down	Twist	Roll	Punch Width mm (Ref)		Seam Seam shall not be open and no wire allowed out of the crimping area
	Degree		Degree		Conductor	Insulation	
	mm	In.	mm	In.	mm	In.	
49868	3	3	3	5	2.20	.087	5.30 .209

After crimping, the crimp profiles should measure the following:

Terminal Series No.	Wire Size		Conductor				Pull Force Minimum	
			Crimp Height		Crimp Width (Ref)			
	Wire Type	mm <sup>2</sup>	mm	In.	mm	In.	N	Lb.
49868	AVS 0.5 SQ	0.50	1.32-1.42	.051-.056	2.1-2.3	.083-.090	88.5	19.89
	FLRY-A 0.75 SQ	0.75	1.40-1.50	.055-.059	2.1-2.3	.083-.090	105.0	23.60
	AVS 0.85 SQ	0.85	1.45-1.55	.057-.061	2.1-2.3	.083-.090	127.5	28.55

Terminal Series No.	Wire Type	mm <sup>2</sup>	Wire Rear Seal		Insulation			
					Crimp Height Maximum		Crimp Width (Ref.)	
	Order No.	Color	mm	In.	mm	In.	mm	In.
49868	AVS 0.5 SQ	0.50	49454-9003	Red	4.82	.190	5.20-5.40	.205-.213
	FLRY-A 0.75 SQ	0.75			4.82	.190	5.20-5.40	.205-.213
	AVS 0.85 SQ	0.85			4.82	.190	5.20-5.40	.205-.213

**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.

**CAUTION:** Install only Molex terminals listed above with this tool. Do not crimp hardened objects as damage can occur to the tool or die.

**PARTS LIST**

<b>FineAdjust Applicator 63903-9500</b>				
<b>Item</b>	<b>Order No</b>	<b>Engineering No.</b>	<b>Description</b>	<b>Quantity</b>
<b>Perishable Tooling</b>				
	63903-9570	63903-9570	Tool Kit (All "Y" Items)	REF
1	63457-2201	63457-2201	Conductor Punch	1 Y
2	63455-2195	63455-2195	Conductor Anvil	1 Y
3	63454-5201	63454-5201	Insulation Punch	1 Y
4	63456-5295	63456-5295	Insulation Anvil	1 Y
5	63443-1226	63443-1226	Cut-Off Plunger	1 Y
6	63443-1229	63443-1229	Front Plunger Retainer	1 Y
<b>Other Components</b>				
7	11-17-0022	1739-21	Hold Down Spring	1
8	63600-6637	63600-6637	Cut-Off Plunger Spring	1
9	63443-0091	63443-0091	Wire Stop	1
10	63443-0093	63443-0093	Shank – Terminal Hold Down	1
11	63443-3620	63443-3620	Front Plunger Striker	1
12	63443-7213	63443-7213	Terminal Hold Down	1
13	63903-9551	63903-9551	Anvil Mount	1
14	63903-9594	63903-9594	Feed Guide	1
15	64016-2530	64016-2530	Guard Assembly-Point of Operation	1
<b>Frame</b>				
16	63800-3901	63800-3901	Top	1
17	63801-3288	63801-3288	Base	1
18	63801-9650	63801-9650	Track	1
<b>Hardware</b>				
19	N/A	N/A	M3 by 6 Long SHCS	2**
20	N/A	N/A	M3 by 8 Long SHCS	1**
21	N/A	N/A	M4 by 6 Long SHCS	1**
22	N/A	N/A	M4 by 8 Long SHCS	2**
23	N/A	N/A	M4 by 50 Long SHCS	2**
24	N/A	N/A	M5 by 12 Long SHCS	1**

\*\* Available from an industrial supply company such as MSC (1-800-645-7270).

## Assembly Drawing

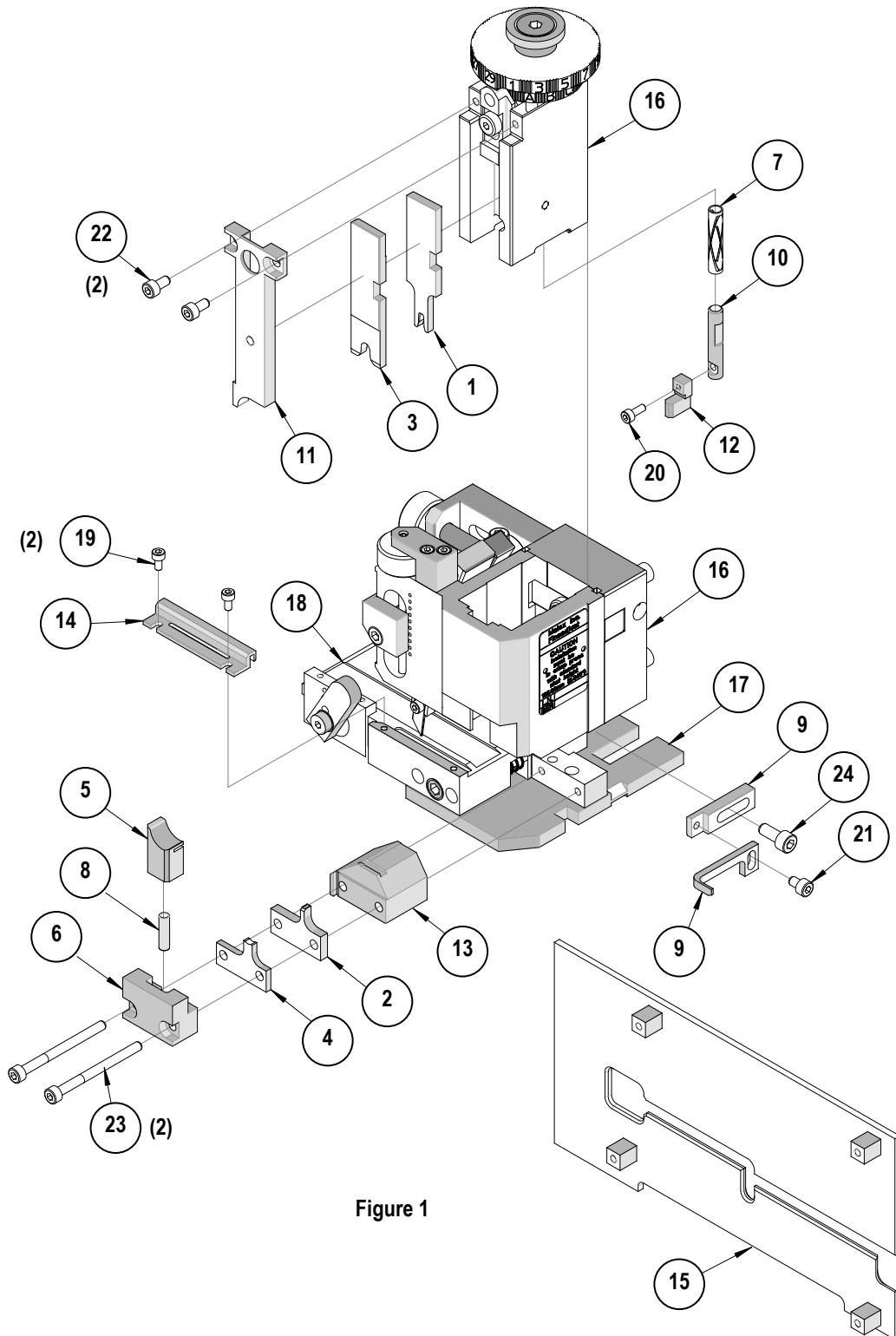


Figure 1

## 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 135.80 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>