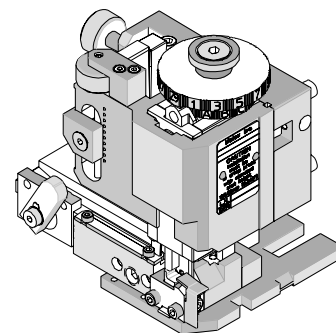




FineAdjust Applicator Specification Sheet Part No. 63900-2900



FEATURES

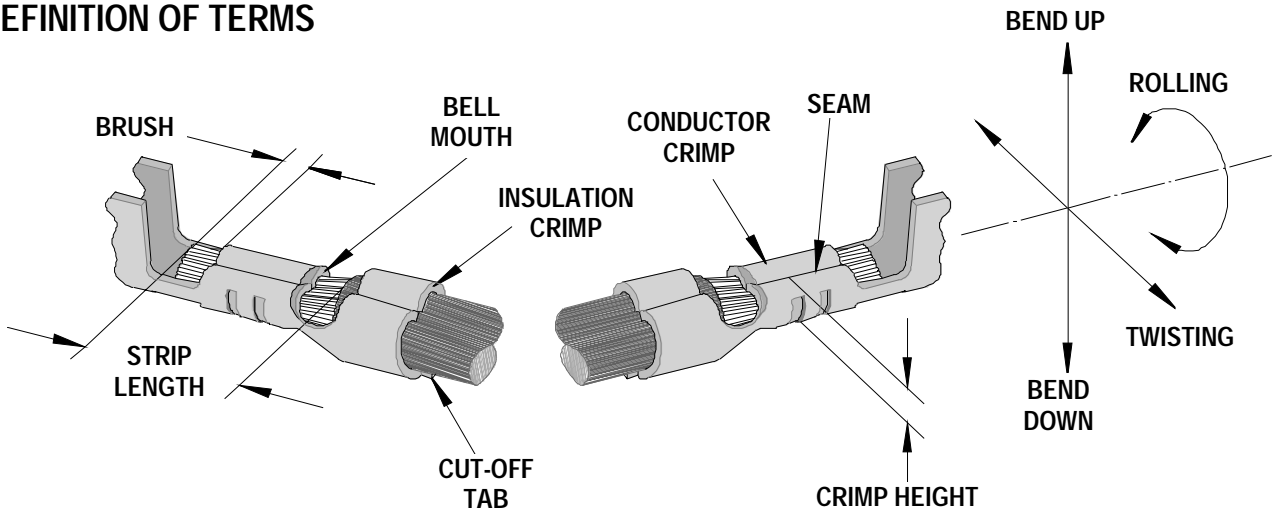
- Quick punch removal with the push of a button for fast and easy tooling change
- Applicator designed to industry standard mounting and shut height 135.80mm (5.346")
- Quick set-up time; plus the crimp height, track and feed adjustments can be set without removing the applicator from the press
- Fine 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: Mini-Fit Jr.™, Mini-Fit HCS™, and Mini-Fit Plus HCS™ Crimp Terminal 18-24 AWG with smaller insulation OD's.

Terminal Series No.	Terminal Order No.				Wire Size		Ⓢ Insulation Diameter		Strip Length	
					AWG	mm ²	mm	In.	mm	In.
5556	39-00-0038	39-00-0153	39-00-0200	39-00-0419	18-24	0.80-0.20	1.30-2.15	.051-.085	3.00-3.50	.118-.138
	39-00-0055	39-00-0163	39-00-0207	39-00-0425						
	39-00-0059	39-00-0169	39-00-0213	39-00-0428						
	39-00-0073	39-00-0175	39-00-0405	39-00-0436						
	39-00-0108	39-00-0181	39-00-0407	39-00-0440						
	39-00-0114	39-00-0194	39-00-0410	40-13-0851						
5558	39-00-0040	39-00-0120	39-00-0420	39-00-0437	18-24	0.80-0.20	1.30-2.15	.051-.085	3.00-3.50	.118-.138
	39-00-0053	39-00-0126	39-00-0426	40-01-0853						
	39-00-0061	39-00-0219	39-00-0427	40-13-0853						
	39-00-0075	39-00-0411	39-00-0430	98-00-0174						
30490	30490-0002	30490-1002	30490-2002		18-24	0.80-0.20	1.30-2.15	.051-.085	3.00-3.50	.118-.138
44476	44476-1111	44476-1211			18-20	0.80-0.50	1.30-2.15	.051-.085	3.00-3.50	.118-.138
44478	44478-1111	44478-1211			18-20	0.80-0.50	1.30-2.15	.051-.085	3.00-3.50	.118-.138
44485	44485-1211	44485-1311	44485-1411		18-24	0.80-0.20	1.30-2.15	.051-.085	3.00-3.50	.118-.138
45750	45750-1111	45750-1211			18-20	0.80-0.50	1.65-2.05	.065-.081	3.00-3.50	.118-.138
46012	46012-1111	46012-1211	46012-1141	46012-1241	18-20	0.80-0.50	1.65-2.05	.065-.081	3.00-3.50	.118-.138
46018	46018-1541				18-20	0.80-0.50	1.65-2.05	.065-.081	3.00-3.50	.118-.138
46083	46083-1111	46083-1121	46083-1211	46083-1221	18-20	0.80-0.50	1.65-2.05	.065-.081	3.00-3.50	.118-.138
46098	46098-1541				18-20	0.80-0.50	1.65-2.05	.065-.081	3.00-3.50	.118-.138
Ⓢ This Applicator will crimp the above terminals and wires. However it provides optimum A-620 Class 2 crimps for 18-20 AWG wire with insulation OD 1.65-2.05mm (example UL1007). Applicator 63900-2600 should be used for insulation OD 2.05-2.95mm (example UL1015).										

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.
5556	0.20-0.50	.008-.020	0.30	.012	0.00-1.00	.000-.039
5558	0.20-0.50	.008-.020	0.30	.012	0.00-1.00	.000-.039
30490	0.20-0.50	.008-.020	0.30	.012	0.00-1.00	.000-.039
44476	0.20-0.50	.008-.020	0.30	.012	0.00-1.00	.000-.039
44478	0.20-0.50	.008-.020	0.30	.012	0.00-1.00	.000-.039
44485	0.20-0.50	.008-.020	0.30	.012	0.00-1.00	.000-.039
45750	0.20-0.50	.008-.020	0.30	.012	0.00-1.00	.000-.039
46012	0.20-0.50	.008-.020	0.30	.012	0.00-1.00	.000-.039
46018	0.20-0.50	.008-.020	0.30	.012	0.00-1.00	.000-.039
46083	0.20-0.50	.008-.020	0.30	.012	0.00-1.00	.000-.039
46098	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)			
					Conductor		Insulation	
	Degree		Degree		mm	In.	mm	In.
5556	5	2	5	15	1.60	.063	2.00	.079
5558	5	2	5	15	1.60	.063	2.00	.079
30490	5	2	5	15	1.60	.063	2.00	.079
44476	5	2	5	15	1.60	.063	2.00	.079
44478	5	2	5	15	1.60	.063	2.00	.079
44485	5	2	5	15	1.60	.063	2.00	.079
45750	5	2	5	15	1.60	.063	2.00	.079
46012	5	2	5	15	1.60	.063	2.00	.079
46018	5	2	5	15	1.60	.063	2.00	.079
46083	5	2	5	15	1.60	.063	2.00	.079
46098	5	2	5	15	1.60	.063	2.00	.079

Seam

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				Pull Force Minimum	
			Crimp Height		Crimp Width (Ref)			
	AWG	mm ²	mm	In.	mm	In.	N	Lb.
5556	18	0.80	0.97-1.07	.038-.042	1.68	.066	88.0	19.8
	20	0.50	0.95-1.04	.037-.041	1.66	.065	58.7	13.2
	22	0.35	0.85-0.94	.033-.037	1.65	.065	39.1	8.8
	24	0.20	0.79-0.87	.031-.034	1.63	.064	29.3	6.6
5558	18	0.80	0.97-1.07	.038-.042	1.68	.066	88.0	19.8
	20	0.50	0.95-1.04	.037-.041	1.66	.065	58.7	13.2
	22	0.35	0.85-0.94	.033-.037	1.65	.065	39.1	8.8
	24	0.20	0.79-0.87	.031-.034	1.63	.064	29.3	6.6
30490	18	0.80	0.97-1.07	.038-.042	1.68	.066	88.0	19.8
	20	0.50	0.95-1.04	.037-.041	1.66	.065	58.7	13.2
	22	0.35	0.85-0.94	.033-.037	1.65	.065	39.1	8.8
	24	0.20	0.79-0.87	.031-.034	1.63	.064	29.3	6.6
44476	18	0.80	0.97-1.07	.038-.042	1.68	.066	68.4	15.4
	20	0.50	0.95-1.04	.037-.041	1.66	.065	58.7	13.2
44478	18	0.80	0.97-1.07	.038-.042	1.68	.066	68.4	15.4
	20	0.50	0.95-1.04	.037-.041	1.66	.065	58.7	13.2
44485	18	0.80	0.97-1.07	.038-.042	1.68	.066	88.0	19.8
	20	0.50	0.95-1.04	.037-.041	1.66	.065	58.7	13.2
	22	0.35	0.85-0.94	.033-.037	1.65	.065	39.1	8.8
	24	0.20	0.79-0.87	.031-.034	1.63	.064	29.3	6.6
45750	18	0.80	0.97-1.07	.038-.042	1.68	.066	68.4	15.4
	20	0.50	0.84-0.94	.033-.037	1.66	.065	58.7	13.2
46012	18	0.80	0.97-1.07	.038-.042	1.68	.066	68.4	15.4
	20	0.50	0.84-0.94	.033-.037	1.66	.065	58.7	13.2
46018	18	0.80	0.97-1.07	.038-.042	1.68	.066	68.4	15.4
	20	0.50	0.84-0.94	.033-.037	1.66	.065	58.7	13.2
46083	18	0.80	0.97-1.07	.038-.042	1.68	.066	68.4	15.4
	20	0.50	0.84-0.94	.033-.037	1.66	.065	58.7	13.2
46098	18	0.80	0.97-1.07	.038-.042	1.68	.066	68.4	15.4
	20	0.50	0.84-0.94	.033-.037	1.66	.065	58.7	13.2

⚠ 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 63900-2900				
Item	Order No	Engineering No.	Description	Quantity
Perishable Tooling				
	63900-2970	63900-2970	Tool Kit (All "Y" Items)	REF
1	63444-1609	63444-1609	Conductor Punch	1 Y
2	63445-1646	63445-1646	Conductor Anvil	1 Y
3	63446-2001	63446-2001	Insulation Punch	1 Y
4	63445-2005	63445-2005	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
Other Components (REF 002650)				
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	63443-1717	63443-1717	18.70mm Height Spacer	1
14	63443-2216	63443-2216	16.00mm Coarse Spacer	1
15	63443-2302	63443-2302	3.10mm Fine Spacer	1
16	63443-6111	63443-6111	Rear Cover	1
Frame				
17	63800-4901	63800-4901	Top	1
18	63801-3281	63801-3281	Base	1
19	63801-4650	63801-4650	Track	1
Hardware				
20	N/A	N/A	M3 by 6 Long SHCS	2**
21	N/A	N/A	M3 by 6 Long FHCS	1**
22	N/A	N/A	M4 by 6 Long SHCS	2**
23	N/A	N/A	M4 by 12 Long BHCS	2**
24	N/A	N/A	M4 by 50 Long SHCS	2**
25	N/A	N/A	M5 by 12 Lg SHCS	1**
26	N/A	N/A	#10-32 by 3/8" Long Flat Point SSS	1**
27	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

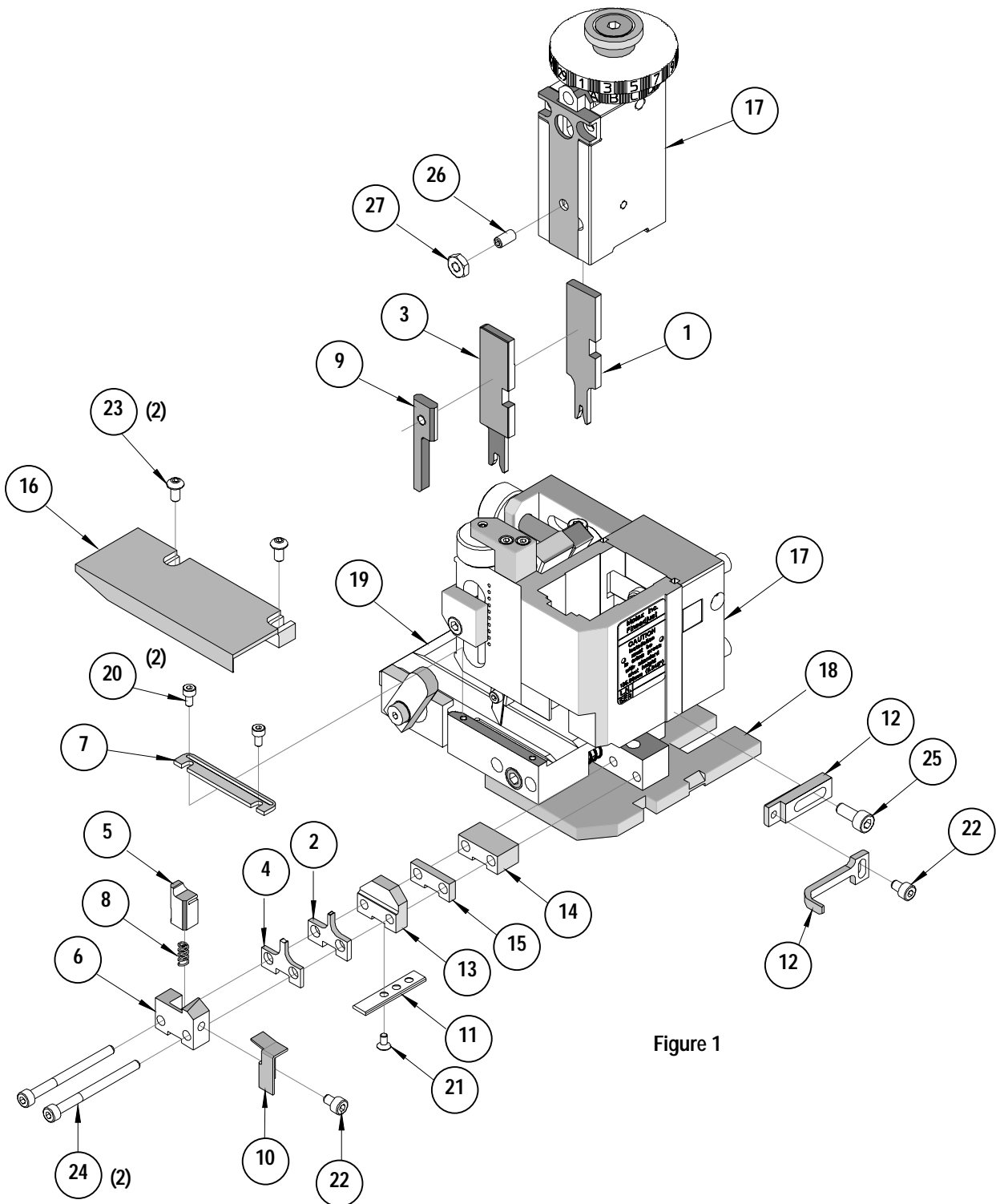


Figure 1

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 135.80 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.

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