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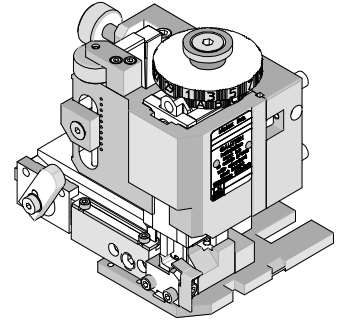
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Fine Adjust Applicator for SL™ Crimp Terminal



**FineAdjust Applicator  
Specification Sheet  
Part No. 63900-3400**



**FEATURES**

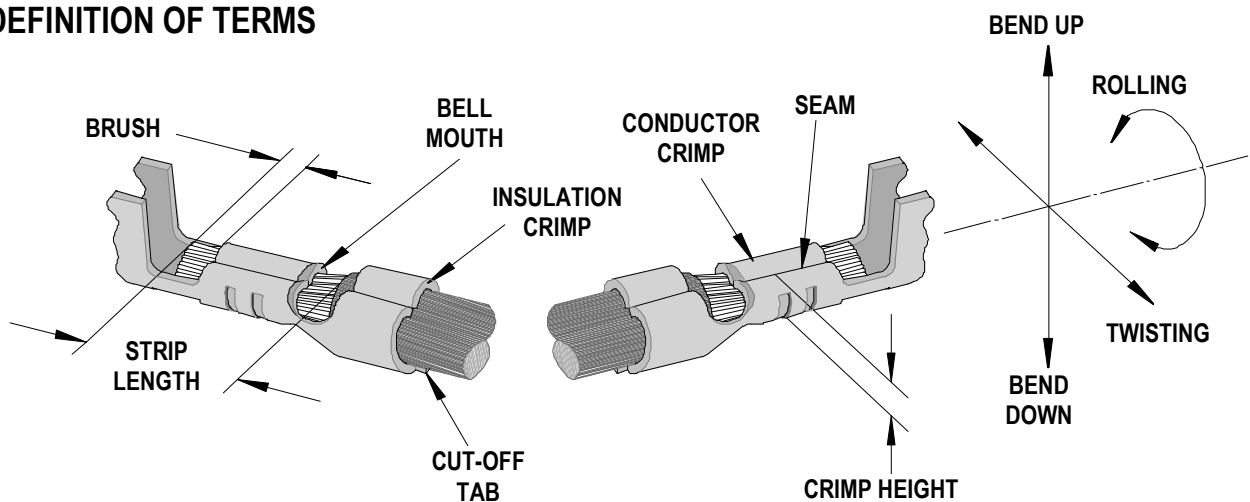
- Quick punch removal with the push of a button for fast and easy tooling change
- Applicator designed to industry standard mounting and shut height 135.80mm (5.346")
- Quick set-up time; plus the crimp height, track and feed adjustments can be set without removing the applicator from the press
- Fine 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: SL™ Crimp Terminal, Male, 24-30 AWG.

Terminal Series No.	Terminal Order No.		Wire Size		Insulation Diameter		Strip Length	
			AWG	mm <sup>2</sup>	mm	In.	mm	In.
50087	50087-8000	50087-8060	24-30	0.20-0.05	0.80-1.60	.031-.063	3.00-3.50	.118-.138
	50087-8014	50087-8099						
	50087-8030							
50294	50294-8089	50294-8099	24-28	0.20-0.08	0.85-1.60	.034-.063	3.00-3.50	.118-.138
70021	16-02-0077	40-08-0871	24-30	0.20-0.05	1.01-1.52	.040-.060	3.17-3.56	.125-.140
	16-02-0078	70021-0001						
	16-02-0091	70021-0004						
	16-02-0105	70021-0006						

**DEFINITION OF TERMS**



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

Fine Adjust Applicator for SL™ Crimp Terminal

### CRIMP SPECIFICATION

Terminal Series No.	Bell mouth		Cut-off Tab Maximum				Conductor Brush	
			Front		Rear			
	mm	In.	mm	In.	mm	In.	mm	In.
50087	0.20-0.50	.008-.020	0.15	.006	0.30	.012	0.00-1.00	.000-.039
50294	0.20-0.50	.008-.020	0.13	.005	0.13	.005	0.00-1.00	.000-.039
70021	0.20-0.50	.008-.020	0.13	.005	0.13	.005	0.00-1.00	.000-.039

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	mm	In	
50087	3	3	3	8	1.00	.039	1.60	.063	
50294	3	0	3	8	1.00	.039	1.60	.063	
70021	3	3	3	8	1.00	.039	1.60	.063	

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.
50087	24	0.20	0.79-0.87	.031-.034	29.3	6.6
	26	0.12	0.74-0.81	.029-.032	19.5	4.4
	28	0.08	0.71-0.78	.028-.031	9.7	2.2
	30	0.05	0.67-0.74	.026-.029	4.9	1.1
50294	24	0.20	0.79-0.87	.031-.034	31.1	7.0
	26	0.12	0.74-0.81	.029-.032	17.8	4.0
	28	0.08	0.71-0.78	.028-.031	8.9	2.0
70021	24	0.20	0.79-0.84	.031-.033	22.2	5.0
	26	0.12	0.74-0.79	.029-.031	13.3	3.0
	28	0.08	0.71-0.76	.028-.030	8.9	2.0
	30	0.05	0.66-0.71	.026-.028	6.7	1.5

Pull Force should be measured with no influence from the insulation crimp.  
 The above specifications are guidelines to an optimum crimp.

Fine Adjust Applicator for SL™ Crimp Terminal

**PARTS LIST**

FineAdjust Applicator 63900-3400				
Item	Order No	Engineering No.	Description	Quantity
<b>Perishable Tooling</b>				
	63900-3470	63900-3470	Tool Kit (All "Y" Items)	REF
1	63444-1018	63444-1018	Conductor Punch	1 Y
2	63445-1031	63445-1031	Conductor Anvil	1 Y
3	63446-1626	63446-1626	Insulation Punch	1 Y
4	63445-1630	63445-1630	Insulation Anvil	1 Y
5	63443-0003	63443-0003	Cut-Off Plunger	2 Y
6	63443-0012	63443-0012	Front Plunger Retainer	1 Y
7	63443-1402	63443-1402	Cut-off Die Blade	1 Y
8	63443-1002	63443-1002	Rear Plunger Retainer	1 Y
<b>Other Components (REF 003450)</b>				
9	11-17-0022	1739-21	Hold Down Spring	1
10	11-18-4083	60707-8	Feed Guide	1
11	11-24-1067	4996-4	Cut-Off Plunger Spring	2
12	11-40-4039	8302-5	Plunger Striker	1
13	11-40-4382	8341-8	Shank	1
14	63443-0025	63443-0025	Dual Carrier Key	1
15	63443-0090	63443-0090	Wire Stop	1
16	63443-1718	63443-1718	18.80mm Height Spacer	1
17	63443-2204	63443-2204	4.00mm Coarse Spacer	1
18	63443-2310	63443-2310	3.50mm Fine Spacer	1
19	63443-3060	63443-3060	Rear Plunger Striker	1
20	63443-6111	63443-6111	Rear Cover	1
<b>Frame</b>				
21	63800-4901	63800-4901	Top	1
22	63801-3281	63801-3281	Base	1
23	63801-4650	63801-4650	Track	1
<b>Hardware</b>				
24	N/A	N/A	M3 by 6 Long SHCS	2**
25	N/A	N/A	M3 by 6 Long FHCS	1**
26	N/A	N/A	M4 by 6 Long SHCS	1**
27	N/A	N/A	M4 by 10 Long SHCS	2**
28	N/A	N/A	M4 by 12 Long BHCS	2**
29	N/A	N/A	M4 by 35 Long SHCS	1**
30	N/A	N/A	M4 by 50 Long SHCS	1**
31	N/A	N/A	M5 by 12 Long SHCS	1**
32	N/A	N/A	#10-32 by 3/8" Long Flat Point SSS	1**
33	N/A	N/A	#10-32 Hex Jam Nut	1**

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

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**Assembly Drawing**

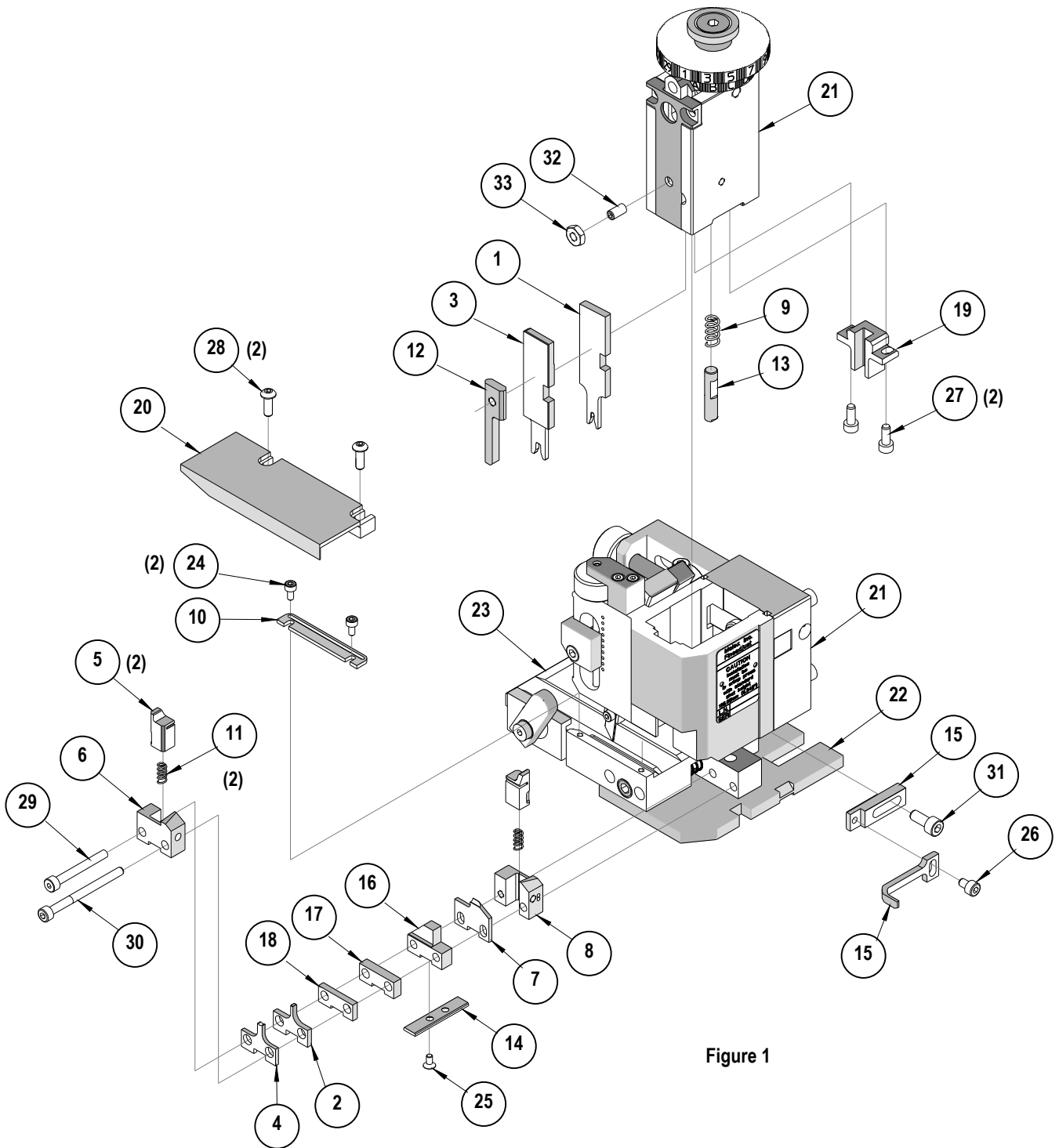


Figure 1

Fine Adjust Applicator for SL™ Crimp Terminal

## 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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