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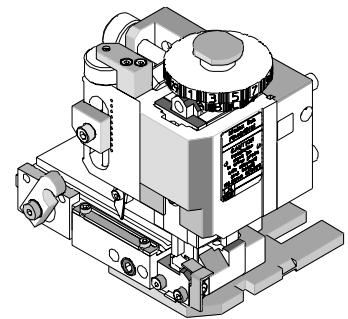
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sales@integrated-circuit.com

63865-6200 Fine Adjust Applicator



**FineAdjust Applicator
Specification Sheet
Part No. 63865-6200**



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 0.15mm (.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

MX150L™ Female Terminal for 18-24 AWG Wire, Metal Strip Carrier.

| Terminal Order No. | | Wire Size | | Insulation Diameter | | Strip Length | |
|--------------------|---------------|-----------|-----------------|---------------------|-----------|--------------|-----------|
| | | AWG | mm ² | mm | In. | mm | In. |
| 19420-0002 | Female (Tin) | 18-22 | 0.83-0.36 | 2.36-2.74 | .093-.108 | 4.20-5.00 | .165-.197 |
| 19420-0004 | Female (Gold) | 18-22 | 0.83-0.36 | 2.36-2.74 | .093-.108 | 4.20-5.00 | .165-.197 |
| 19420-0002 | Female (Tin) | 24 | 0.20 | 1.00 Nom. | .039 Nom. | 4.20-5.00 | .165-.197 |
| 19420-0004 | Female (Gold) | 24 | 0.20 | 1.00 Nom. | .039 Nom. | 4.20-5.00 | .165-.197 |

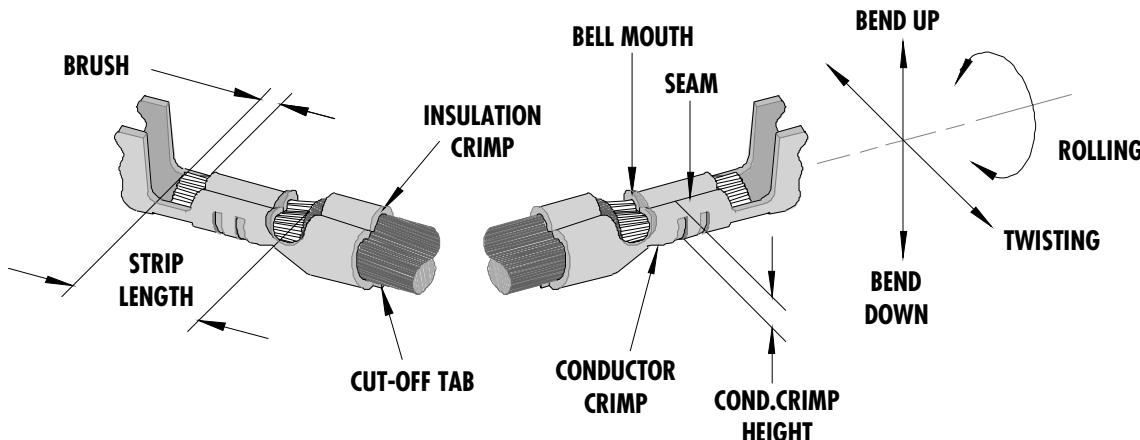
Note: Terminals will accommodate the following wire specification:

1. (18-22 AWG) UL1015 wires.

2. (24 AWG) UL20251 wire.

For 24 AWG wire, see Tool Qualification Notes, Item 2 on page 2.

DEFINITION OF TERMS



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

63865-6200 Fine Adjust Applicator

CRIMP SPECIFICATION

| Terminal Series No. | Bell mouth | | Cut-off Tab Max. | | Conductor Brush | |
|---------------------|------------|-----------|------------------|------|-----------------|-----------|
| | mm | In. | mm | In. | mm | In. |
| 19420 | 0.25-1.25 | .010-.049 | 0.50 | .020 | 0.15-0.65 | .006-.026 |

| 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 |
|---------------------|---------|-----------|-------|------|----------------------|------------|---|
| | | | | | Conductor | Insulation | |
| | Degree | Degree | mm | In. | mm | In. | |
| 19420 | 5 | 5 | 4 | 8 | 2.00 | .079 | 3.40 .133 |

After crimping, the conductor profile should measure the following.

| Terminal Order No. | Wire Size | | Conductor Crimp Height | | Insulation Crimp Height | | Pull Force Min. | |
|--------------------|-----------|-----------------|------------------------|-----------|-------------------------|-----------|-----------------|-------|
| | AWG | mm ² | mm | In. | Mm (Ref) | In. (Ref) | N | Lb. |
| 19420-0002 | 18 | 0.83 | 1.15-1.25 | .045-.049 | 3.00 max. | .118 max. | 89.0 | 20.00 |
| 19420-0002 | 20 | 0.58 | 1.10-1.20 | .043-.047 | 3.00 max. | .118 max. | 57.9 | 13.00 |
| 19420-0002 | 22 | 0.36 | 1.05-1.15 | .041-.045 | 3.00 max. | .118 max. | 35.6 | 8.00 |
| 19420-0002 | 24 | 0.20 | 1.00-1.10 | .039-.043 | 3.00 max. | .118 max. | 22.2 | 5.00 |
| | | | | | | | | |
| 19420-0004 | 18 | 0.83 | 1.15-1.25 | .045-.049 | 3.00 max. | .118 max. | 89.0 | 20.00 |
| 19420-0004 | 20 | 0.58 | 1.10-1.20 | .043-.047 | 3.00 max. | .118 max. | 57.9 | 13.00 |
| 19420-0004 | 22 | 0.36 | 1.05-1.15 | .041-.045 | 3.00 max. | .118 max. | 35.6 | 8.00 |
| 19420-0004 | 24 | 0.20 | 1.00-1.10 | .039-.043 | 3.00 max. | .118 max. | 22.2 | 5.00 |

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

👉 Tool Qualification Notes:

1. This Applicator was qualified to the above specifications with UL1015 wires for 18-22 AWG and UL20251 wire for 24 AWG.
2. For the 24 AWG wire, the insulation crimp has clearance around the wire and does not provide strain relief, even at the nominal reference crimp height of 2.11mm (.083").

63865-6200 Fine Adjust Applicator

PARTS LIST

| FineAdjust Applicator 63865-6200 | | | | |
|---|-------------------|------------------------|--------------------------|-----------------|
| Item | Order No | Engineering No. | Description | Quantity |
| Perishable Tooling | | | | |
| | 63865-6270 | 63865-6270 | Tool Kit (All "Y" Items) | REF |
| 1 | 63444-2037 | 63444-2037 | Conductor Punch | 1 Y |
| 2 | 63445-2068 | 63445-2068 | Conductor Anvil | 1 Y |
| 3 | 63454-0022 | 63454-0022 | Insulation Punch | 1 Y |
| 4 | 63445-3440 | 63445-3440 | Insulation Anvil | 1 Y |
| 5 | 63443-0035 | 63443-0035 | Cut-Off Plunger | 1 Y |
| 6 | 63443-0036 | 63443-0036 | Front Plunger Retainer | 1 Y |
| Other Components | | | | |
| 7 | 11-18-4080 | 60707-5 | Wire Stop | 1 |
| 8 | 11-18-4083 | 60707-8 | Front Cover | 1 |
| 9 | 63443-0009 | 63443-0009 | Scrape Chute | 1 |
| 10 | 63443-0021 | 63443-0021 | Lower Tooling Key | 1 |
| 11 | 63443-2508 | 63443-2508 | Anvil Mount | 1 |
| 12 | 63443-3160 | 63443-3160 | Front Plunger Striker | 1 |
| 13 | 63443-6013 | 63443-6013 | Rear Cover | 1 |
| 14 | 63700-0539 | 63700-0539 | Cut-off Plunger Spring | 1 |
| Frame | | | | |
| 15 | 63800-4901 | 63800-4901 | Top | 1 |
| 16 | 63801-3281 | 63801-3281 | Base | 1 |
| 17 | 63801-4650 | 63801-4650 | Track | 1 |
| Hardware | | | | |
| 18 | N/A | N/A | M3 by 6Lg. SHCS | 2** |
| 19 | N/A | N/A | M4 by 6Lg. SHCS | 1** |
| 20 | N/A | N/A | M4 by 12Lg. BHCS | 2** |
| 21 | N/A | N/A | M4 by 50Lg. SHCS | 2** |
| 22 | N/A | N/A | M5 by 12Lg SHCS | 1** |
| 23 | N/A | N/A | 3MM by 6Lg. Roll Pin | 1** |
| 24 | N/A | N/A | #10-32 by 1/4" Lg. BHCS | 1** |

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

63865-6200 Fine Adjust Applicator

Assembly Drawing

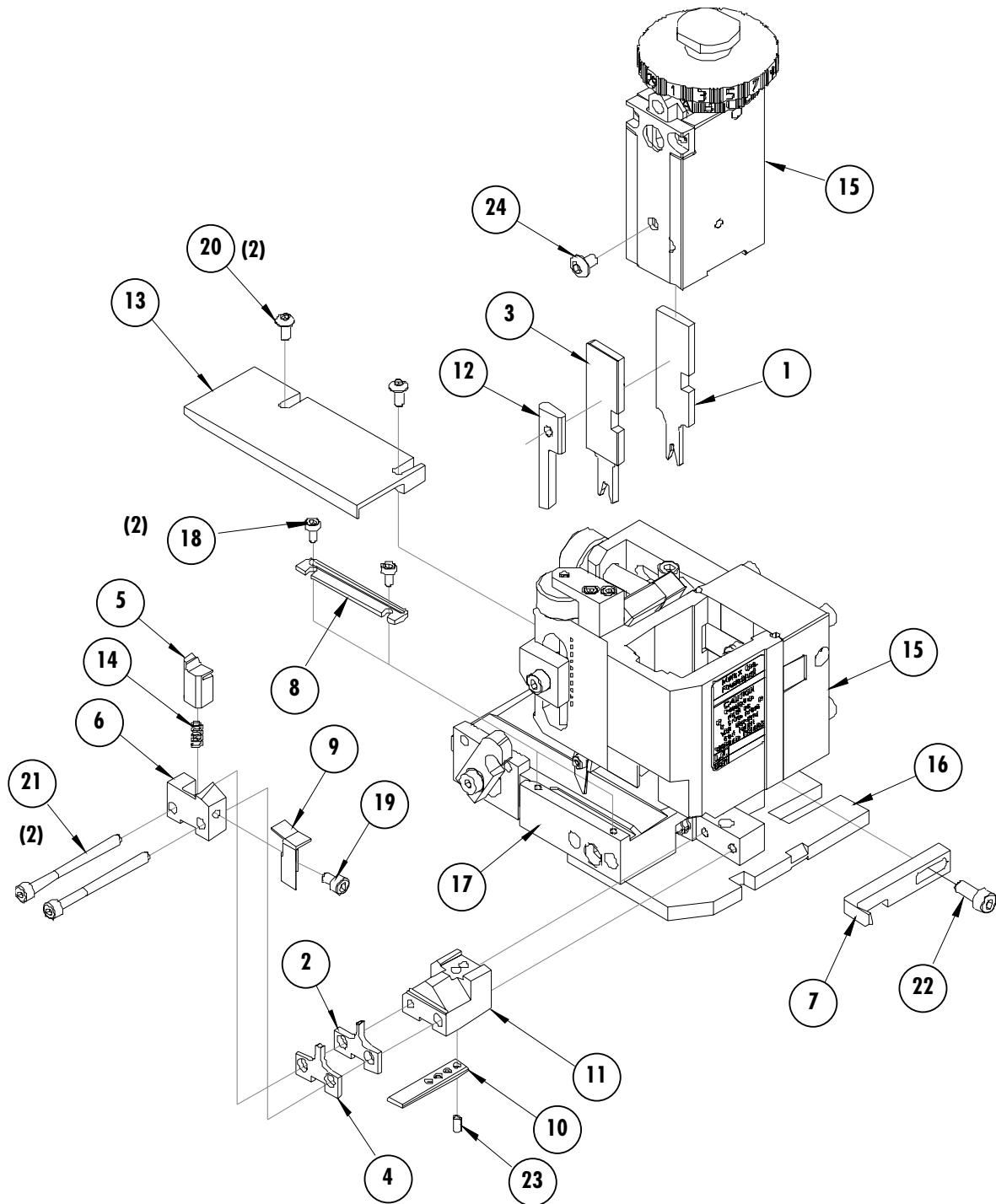


Figure 1

63865-6200 Fine Adjust Applicator

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 135.8 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.

Americas Headquarters
Lisle, Illinois 60532 U.S.A.
1-800-78MOLEX
amerinfo@molex.com

Far East North Headquarters
Yamato, Kanagawa, Japan
81-462-65-2324
feninfo@molex.com

Far East South Headquarters
Jurong, Singapore
65-6-268-6868
fesinfo@molex.com

European Headquarters
Munich, Germany
49-89-413092-0
eurinfo@molex.com

Corporate Headquarters
2222 Wellington Ct.
Lisle, IL 60532 U.S.A.
630-969-4550
Fax: 630-969-1352

Visit our Web site at <http://www.molex.com>