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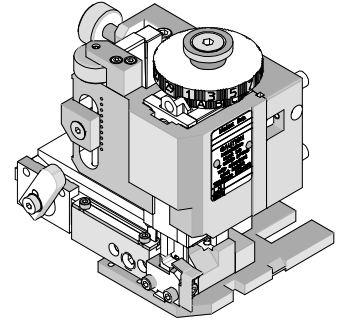
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Fine Adjust Applicator for SL™ Crimp Terminals



**FineAdjust Applicator
Specification Sheet
Order No. 63900-3300**



FEATURES

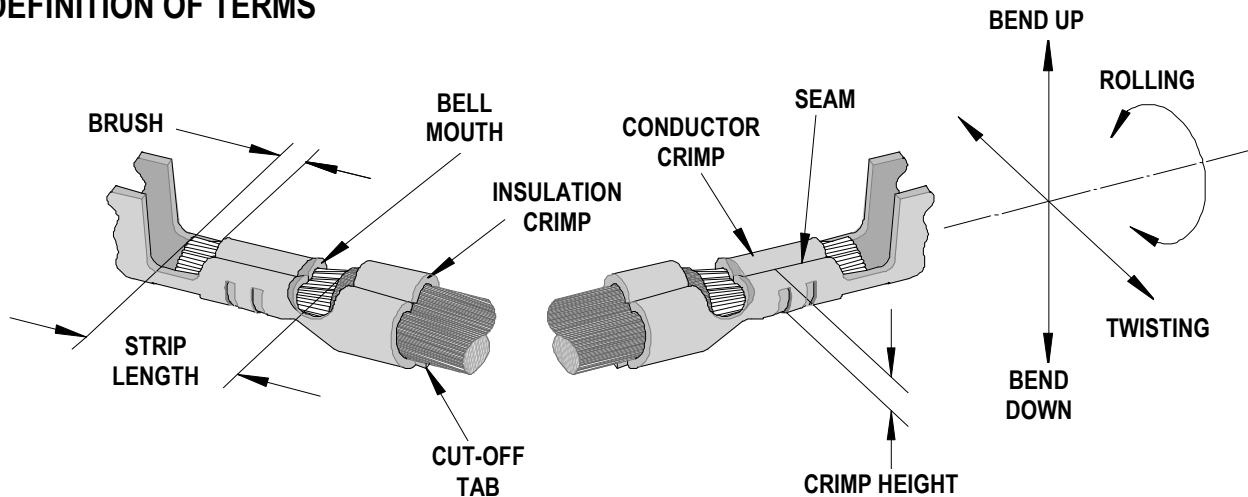
- Quick punch removal with the push of a button for fast and easy tooling change
- Applicator designed to industry standard mounting and shut height 135.80mm (5.346")
- Quick set-up time; plus the crimp height, track and feed adjustments can be set without removing the applicator from the press
- Fine 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™ Female Crimp Terminal, 32-36 AWG.

Terminal Series No	Terminal Order No.			Wire Size		Insulation Diameter		Strip Length	
				AWG	mm ²	mm	In.	mm	In.
70058	016-02-0074	016-02-0085	70058-0084	32-36	0.03-0.01	0.43-0.64	.017-.025	3.17-3.56	.125-.140
	016-02-0084	016-02-0143	70058-4084						
71851	016-02-1118	016-02-1120	016-02-1122	32-36	0.03-0.01	0.43-0.64	.017-.025	3.17-3.56	.125-.140

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 Terminals

CRIMP SPECIFICATION

Terminal Series No.	Bell mouth		Cut-off Tab Maximum				Conductor Brush	
			Front		Rear			
	mm	In.	mm	In.	mm	In.	mm	In.
70058	0.20-0.50	.008-.020	0.13	.005	0.08	.003	0.00-1.00	.000-.039
71851	0.20-0.50	.008-.020	0.13	.005	0.08	.003	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	
70058	3	3	3	8	0.90	.035	1.40	.055	
71851	3	3	3	8	0.90	.035	1.40	.055	

After crimping, the conductor profile should measure the following.

Terminal Series No.	Wire Size		Crimp Height		Pull Force Minimum	
	AWG	mm ²	mm	In.	N	Lb.
70058	32	0.03	0.64-0.66	.025-.026	4.4	1.0
	34	0.02	0.61-0.64	.024-.025	2.7	0.6
	36	0.01	0.61-0.64	.024-.025	1.8	0.4
71851	32	0.03	0.64-0.66	.025-.026	4.4	1.0
	34	0.02	0.61-0.64	.024-.025	2.7	0.6
	36	0.01	0.61-0.64	.024-.025	1.8	0.4

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 Terminals

PARTS LIST

FineAdjust Applicator 63900-3300				
Item	Order No	Engineering No.	Description	Quantity
Perishable Tooling				
	63900-3370	63900-3370	Tool Kit (All "Y" Items)	REF
1	63444-0914	63444-0914	Conductor Punch	1 Y
2	63445-0931	63445-0931	Conductor Anvil	1 Y
3	63446-1419	63446-1419	Insulation Punch	1 Y
4	63445-1425	63445-1425	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
Other Components (REF 003150)				
9	11-17-0022	1739-21	Hold Down Spring	1
10	11-18-4094	60709A111	Front Cover	1
11	11-24-1067	4996-4	Cut-Off Plunger Spring	2
12	11-24-1149	4996-37	Shank	1
13	11-40-4039	8302-5	Front Plunger Striker	1
14	11-40-4274	8331-8	Hold Down Blade	1
15	63443-0025	63443-0025	Dual Carrier Key	1
16	63443-0090	63443-0090	Wire Stop	1
17	63443-2600	63443-2600	Front Spacer	1
18	63443-2205	63443-2205	5.0mm Coarse Spacer	1
19	63443-2306	63443-2306	3.30mm Fine Spacer	1
20	63443-3060	63443-3060	Rear Plunger Striker	1
21	63443-6111	63443-6111	Rear Cover	1
Frame				
22	63800-4901	63800-4901	Top	1
23	63801-3281	63801-3281	Base	1
24	63801-4650	63801-4650	Track	1
25	63860-2015	63860-2015	Drag Frame	1
Hardware				
26	N/A	N/A	M3 by 6 Long SHCS	2**
27	N/A	N/A	M3 by 6 Long FHCS	1**
28	N/A	N/A	M4 by 6 Long SHCS	1**
29	N/A	N/A	M4 by 10 Long SHCS	2**
30	N/A	N/A	M4 by 12 Long BHCS	2**
31	N/A	N/A	M4 by 35 Long SHCS	1**
32	N/A	N/A	M4 by 50 Long SHCS	1**
33	N/A	N/A	M5 by 12 Long SHCS	1**
34	N/A	N/A	#5-40 by 3/8" 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).

Fine Adjust Applicator for SL™ Crimp Terminals

Assembly Drawing

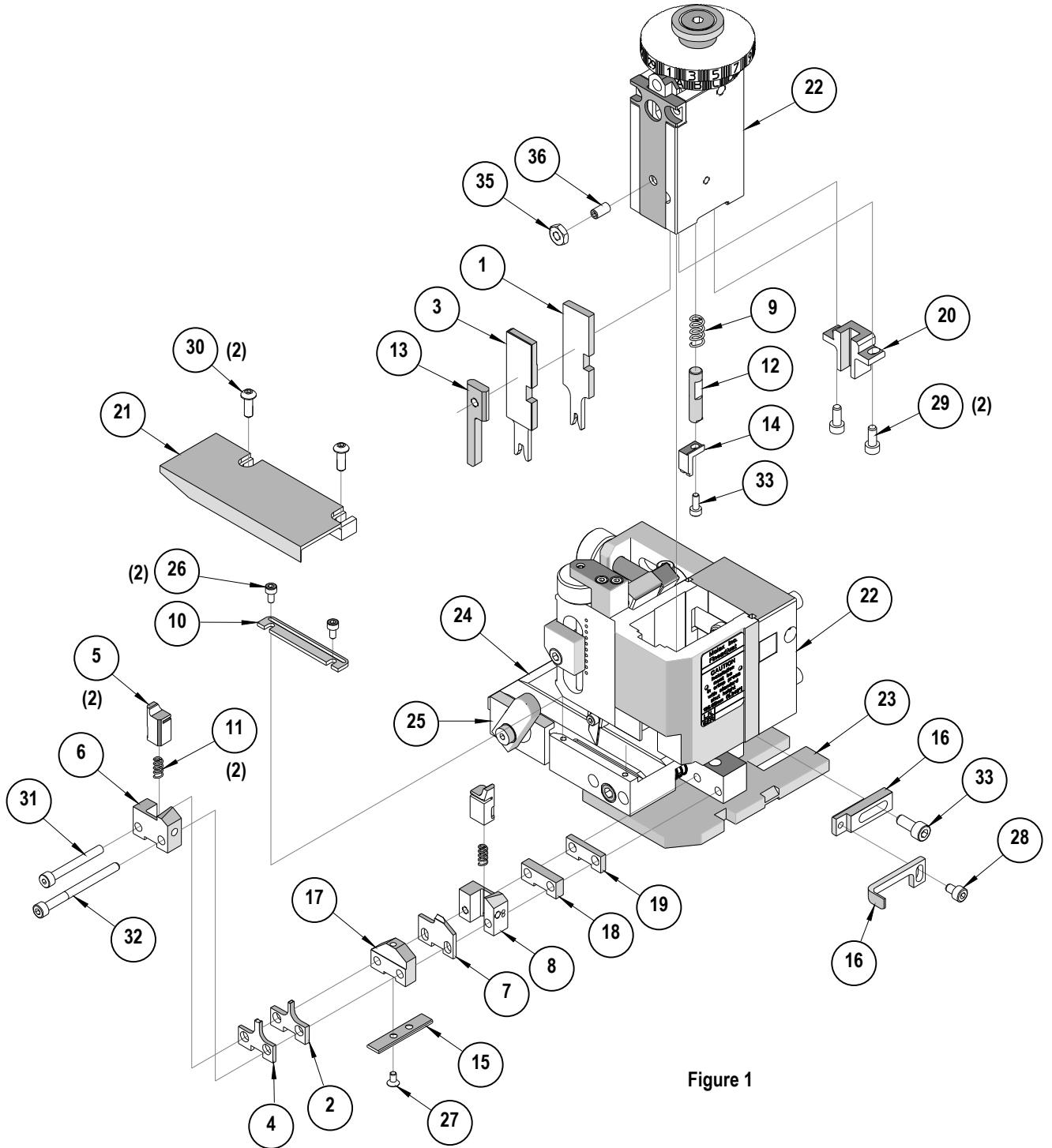


Figure 1

Fine Adjust Applicator for SL™ Crimp Terminals

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.

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