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FineAdjust for XRC™ Sealed Pin and Socket Crimp Terminals

<b>FineAdjust Applicator</b>	 <b>Application Tooling Specification Sheet</b>	 <b>Order No. 63867-9200</b>
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**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

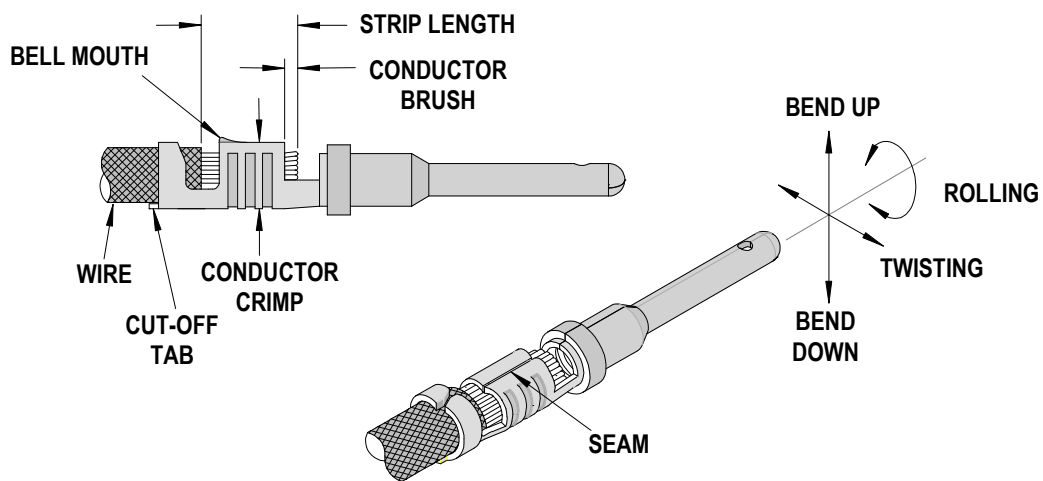
**SCOPE**

Products: XRC™ Sealed Pin and Socket Crimp Terminals, 14-18 AWG.

Terminal Series No.	Terminal Order No.		Wire Size		Insulation Diameter				Strip Length	
					IPC/WHMA-A620 (1)		Terminal (2)			
					AWG	mm <sup>2</sup>	mm	In.		
84524	84524-0008	84524-0016	14-18	2.08-0.82	2.41-3.30	.095-.130	1.90-3.30	.075-.130	3.81-5.08	.175-.225
84524	84524-0012	84524-0018	14-18	2.08-0.82	2.41-3.80	.095-.150	2.41-3.80	.095-.150	3.81-5.08	.175-.225
84525	84525-0017	84525-0039	14-18	2.08-0.82	2.41-3.30	.095-.130	1.90-3.30	.075-.130	3.81-5.08	.175-.225
84525	84525-0025	84525-0046	14-18	2.08-0.82	2.41-3.80	.095-.150	2.41-3.80	.095-.150	3.81-5.08	.175-.225

(1) To achieve optimum IPC-A620 Class 2 insulation crimps, use this insulation OD range  
 (2) Overall insulation OD specification for terminal.  
 Applicator 63867-9000 should be used for insulation OD 1.91-2.41mm for terminals 84524-0008, 84524-0016, 84525-0017, and 84525-0039.

**DEFINITION OF TERMS**



FineAdjust for XRC™ Sealed Pin and Socket Crimp Terminals

### CRIMP SPECIFICATION

Terminal Series No.	Bell mouth		Cut-off Tab Maximum		Conductor Brush	
	mm	In.	mm	In.	mm	In.
84524	0.20-0.80	.008-.032	0.50	.020	0.30-1.00	.012-.039
84525	0.20-0.80	.008-.032	0.50	.020	0.30-1.00	.012-.039

Terminal Series No.	Bend up	Bend down	Twist	Roll	Punch Width (Ref)				Seam
					Conductor		Insulation		
	Degree		Degree		mm	In.	mm	In.	
84524	3	3	4	8	2.60	.102	4.00	.158	Seam shall not be open And no wire allowed out of the crimping area
84525	3	3	4	8	2.60	.102	4.00	.158	

After crimping, the crimp profiles should measure the following:

Terminal Order No.	Wire Size		Conductor				Insulation				Pull Force Minimum	
			Crimp Height		Crimp Width (Ref)		Crimp Height (Ref)		Crimp Width (Ref)			
	AWG	mm <sup>2</sup>	mm	In.	mm	In.	mm	In.	mm	In.	N	Lb.
84524-0008 84524-0016	14	2.08	1.57-1.67	.062-.066	2.50-2.70	.098-.106	2.40-3.75	.095-.148	3.40-4.10	.134-.161	222.6	50.04
	16	1.31	1.32-1.42	.052-.056	2.50-2.70	.098-.106	2.40-3.75	.095-.148	3.40-4.10	.134-.161	133.5	30.01
	18	0.82	1.16-1.26	.046-.050	2.50-2.70	.098-.106	2.40-3.75	.095-.148	3.40-4.10	.134-.161	89.0	20.00
84524-0012 84524-0018	14	2.08	1.60-1.70	.063-.067	2.50-2.70	.098-.106	2.40-4.30	.095-.169	3.60-4.20	.142-.165	222.6	50.04
	16	1.31	1.35-1.45	.053-.057	2.50-2.70	.098-.106	2.40-4.30	.095-.169	3.60-4.20	.142-.165	133.5	30.01
	18	0.82	1.20-1.30	.047-.051	2.50-2.70	.098-.106	2.40-4.30	.095-.169	3.60-4.20	.142-.165	89.0	20.00
84525-0017 84525-0039	14	2.08	1.57-1.67	.062-.066	2.50-2.70	.098-.106	2.40-3.75	.095-.148	3.40-4.10	.134-.161	222.6	50.04
	16	1.31	1.32-1.42	.052-.056	2.50-2.70	.098-.106	2.40-3.75	.095-.148	3.40-4.10	.134-.161	133.5	30.01
	18	0.82	1.16-1.26	.046-.050	2.50-2.70	.098-.106	2.40-3.75	.095-.148	3.40-4.10	.134-.161	89.0	20.00
84525-0025 84525-0046	14	2.08	1.60-1.70	.063-.067	2.50-2.70	.098-.106	2.40-4.30	.095-.169	3.60-4.20	.142-.165	222.6	50.04
	16	1.31	1.35-1.45	.053-.057	2.50-2.70	.098-.106	2.40-4.30	.095-.169	3.60-4.20	.142-.165	133.5	30.01
	18	0.82	1.20-1.30	.047-.051	2.50-2.70	.098-.106	2.40-4.30	.095-.169	3.60-4.20	.142-.165	89.0	20.00

\* 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.

FineAdjust for XRC™ Sealed Pin and Socket Crimp Terminals

**PARTS LIST**

FineAdjust Applicator 63867-9200				
Item	Order No	Engineering No.	Description	Quantity
<b>Perishable Tooling</b>				
	63867-9270	63867-9270	Tool Kit (All "Y" Items)	REF
1	63457-0079	63457-0079	Conductor Punch	1 Y
2	63445-2653	63445-2653	Conductor Anvil	1 Y
3	63454-0046	63454-0046	Insulation Punch	1 Y
4	63456-0092	63456-0092	Insulation Anvil	1 Y
5	63443-0037	63443-0037	Cut-Off Plunger	1 Y
6	63443-0038	63443-0038	Front Plunger Retainer	1 Y
<b>Other Components</b>				
7	11-17-0022	1739-21	Hold Down Spring	1
8	11-18-4083	60707-8	Feed Guide	1
9	11-18-4456	60739A109	Wire Hold Down Spring	1
10	11-24-1149	4996-37	Shank	1
11	63443-0009	63443-0009	Front Scrap Chute	1
12	63443-0024	63443-0024	Key	1
13	63443-0061	63443-0061	Wire Stop	1
14	63443-0068	63443-0068	Blade-Wire Hold Down	1
15	63443-1169	63443-1169	Terminal Hold Down	1
16	63443-1715	63443-1715	Height Spacer (18.50mm)	1
17	63443-2215	63443-2215	Coarse Spacer (15.00mm)	1
18	63443-2305	63443-2305	Fine Spacer (3.25mm)	1
19	63443-2801	63443-2801	Front Plunger Striker	1
20	63443-2912	63443-2912	Wire Hold Down Plunger	1
21	63443-6122	63443-6122	Rear Cover	1
22	63600-1057	63600-1057	Compression Spring	1
23	63600-2673	63600-2673	Mini Rod	1
24	63700-0539	63700-0539	Cut-Off Plunger Spring	1
<b>Frame</b>				
25	63800-4901	63800-4901	Top	1
26	63801-3281	63801-3281	Base	1
27	63801-4950	63801-4950	Track	1
<b>Hardware</b>				
28	N/A	N/A	M3 by 6 Long SHCS	2**
29	N/A	N/A	M3 by 6 Long FHCS	1**
30	N/A	N/A	M4 by 6 Long SHCS	1**
31	N/A	N/A	M4 by 12 Long BHCS	2**
32	N/A	N/A	M4 by 50 Long SHCS	2**
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).

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**Assembly Drawing**

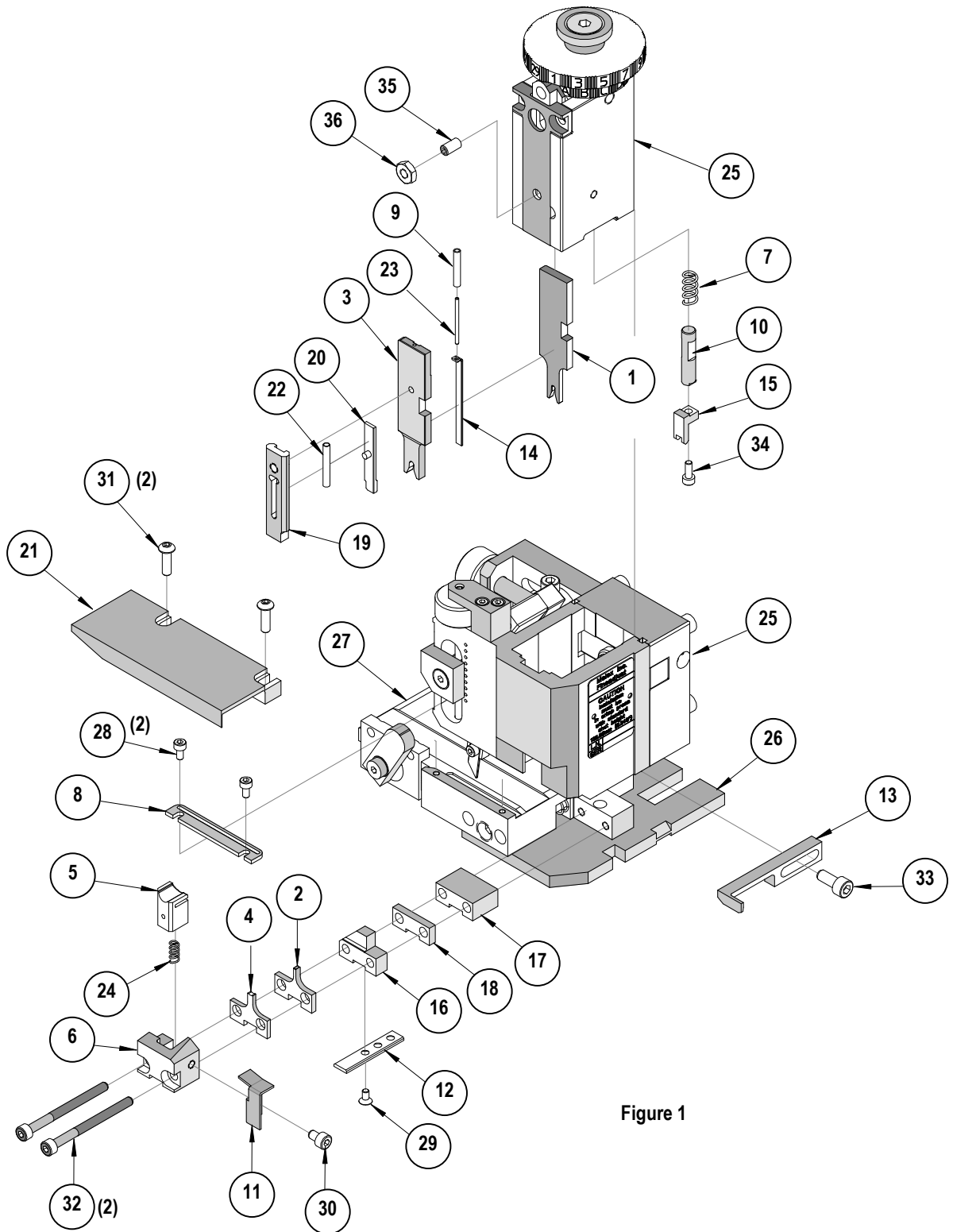


Figure 1

FineAdjust for XRC™ Sealed Pin and Socket 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 135.80 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.

<http://www.molex.com>