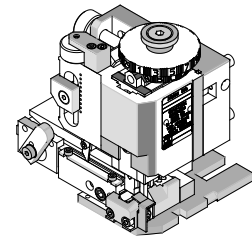


**FineAdjust  
Applicator**



**Application Tooling  
Specification Sheet**



**Order No. 63902-5800**

**FEATURES**

- Directly adapts to most automatic wire processing machines
- 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

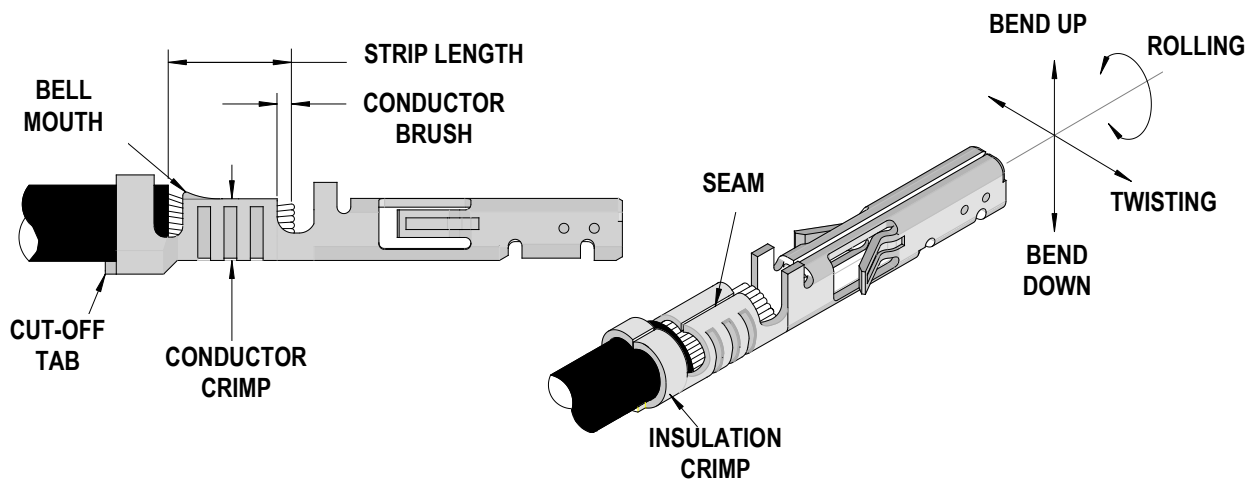
**SCOPE**

Products: Micro-Fit 3.0™ Crimp Terminal, Female, 18 AWG, UL1061 *ONLY*.

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.	mm	In.	mm	In.
45807	45807-0003	18	---	1.40-1.85	.055-.073	0.90-1.85	.035-.073	2.54-2.92	.100-.115
43030	43030-0038	18		1.40-1.85	.055-.073	0.90-1.85	.035-.073	2.54-2.92	.100-.115
	43030-0038	--	.75	1.40-1.85	.055-.073	0.90-1.85	.035-.073	2.54-2.92	.100-.115

(1) To achieve optimum IPC-A620 Class 2 insulation crimps, use this insulation OD range  
 (2) Overall insulation OD specification for terminal

**DEFINITION OF TERMS**



## CRIMP SPECIFICATION

Terminal Series No.	Bell mouth		Cut-off Tab Maximum		Conductor Brush	
	mm	In.	mm	In.	mm	In.
45807	0.05-0.40	.002-.016	0.30	.012	0.20-0.80	.008-.031
43030	0.05-0.40	.002-.016	0.30	.012	0.20-0.80	.008-.031

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	
45807	3	3	4	8	1.60	.063	1.80	.071	
43030	3	3	4	8	1.60	.063	1.80	.071	

After crimping, the conductor profile should measure the following.

Terminal Series No.	Wire Size		Conductor Crimp Height		Insulation Crimp Height		Pull Force Minimum	
	AWG	mm <sup>2</sup>	mm	In.	mm (Ref.)	In. (Ref.)	N	Lb.
45807	18	---	1.00-1.10	.039-.043	1.90	.075	89.0	20.0
43030	18	--	1.00-1.10	.039-.043	1.90	.075	89.0	20.0
	--	.75	.85-.95	.034-.038	1.95	.077	89.0	20.0

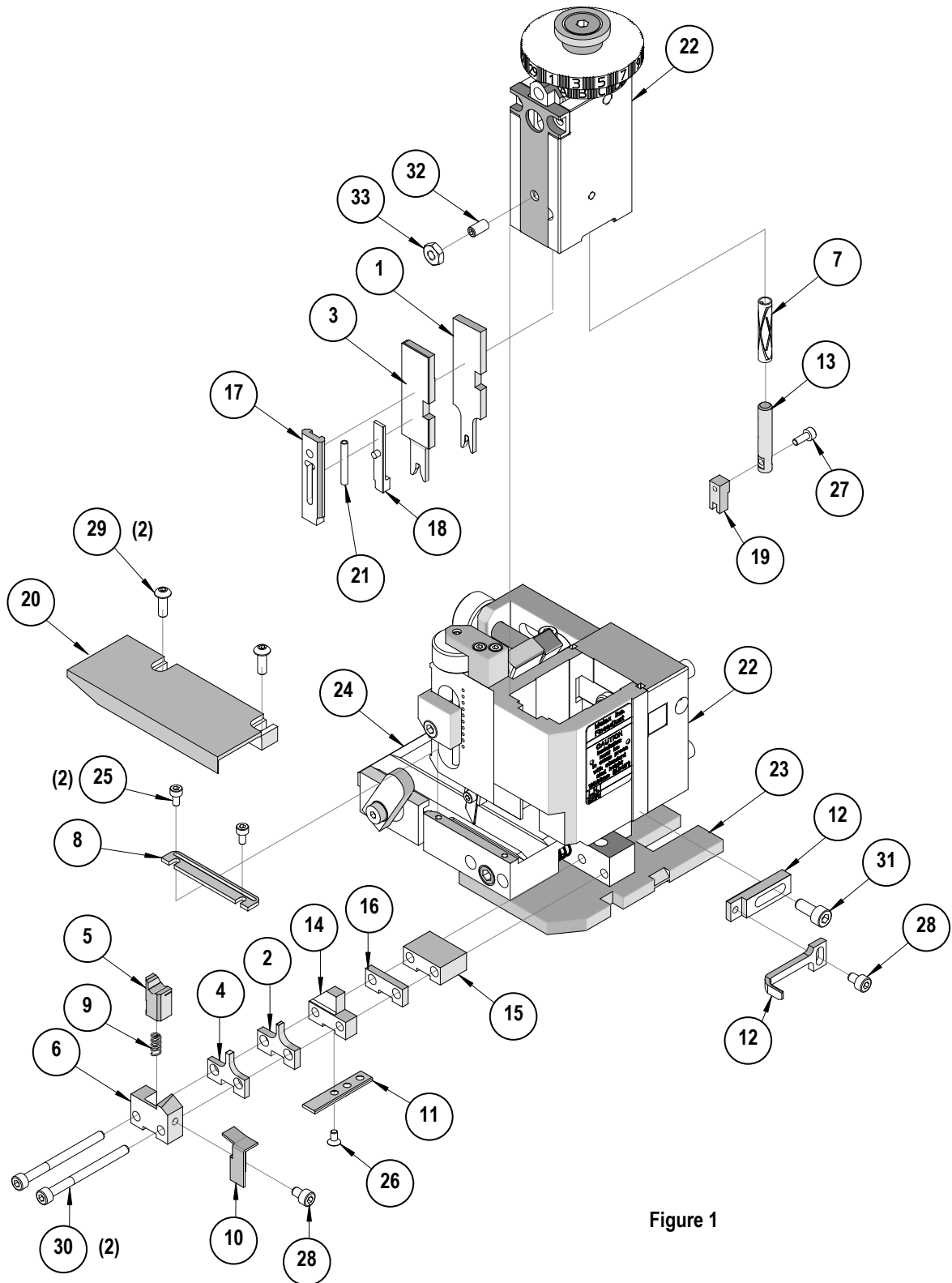
### Tool Qualification Notes:

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**

<b>FineAdjust Applicator 63902-5800</b>				
<b>Item</b>	<b>Order No</b>	<b>Engineering No.</b>	<b>Description</b>	<b>Quantity</b>
<b>Perishable Tooling</b>				
	63902-5870	63902-5870	Tool Kit (All "Y" Items)	REF
1	63444-1609	63444-1609	Conductor Punch	1 Y
2	63455-0128	63455-0128	Conductor Anvil	1 Y
3	63446-1802	63446-1802	Insulation Punch	1 Y
4	63445-1809	63445-1809	Insulation Anvil	1 Y
5	63443-0005	63443-0005	Cut-Off Plunger	1 Y
6	63443-0012	63443-0012	Front Plunger Retainer	1 Y
<b>Other Components</b>				
7	11-17-0022	1739-21	Compression Spring	1
8	11-18-4083	60707-8	Feed Guide	1
9	11-24-1067	4996-4	Cut-off Plunger Spring	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	63443-0093	63443-0093	Shank	1
14	63443-1720	63443-1720	Height Spacer	1
15	63443-2215	63443-2215	Coarse Spacer (15.00mm)	1
16	63443-2308	63443-2308	Fine Spacer (3.40mm)	1
17	63443-2802	63443-2802	Front Plunger Striker	1
18	63443-2903	63443-2903	Wire Hold Down Plunger	1
19	63443-7123	63443-7123	Terminal Hold down	1
20	63443-6111	63443-6111	Rear Cover	1
21	63600-1057	63600-1057	Compression Spring	1
<b>Frame</b>				
22	63800-4901	63800-4901	Top	1
23	63801-3281	63801-3281	Base	1
24	63801-4650	63801-4650	Track	1
<b>Hardware</b>				
25	N/A	N/A	M3 by 6 Long SHCS	2**
26	N/A	N/A	M3 by 6 Long FHCS	1**
27	N/A	N/A	M3 by 8 Long SHCS	1**
28	N/A	N/A	M4 by 6 Long SHCS	2**
29	N/A	N/A	M4 by 12 Long BHCS	2**
30	N/A	N/A	M4 by 50 Long SHCS	2**
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).				

### Assembly Drawing



## 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 135.8mm (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.

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