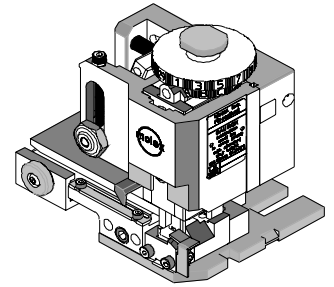




FineAdjust Applicator Specification Sheet Part No. 63866-5100



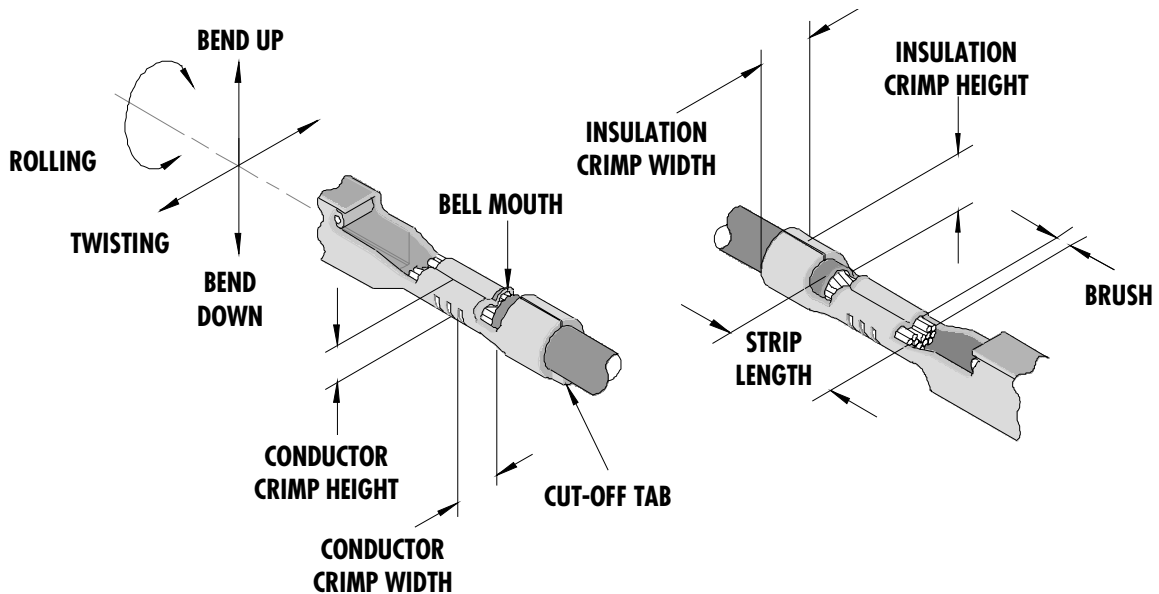
FEATURES

- 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

Terminal Series No.		Wire Size	Actual mm ²	Wire Specification		Insulation Diameter		Strip Length	
				Low Temp.	High Temp.	mm	In.	mm	In.
34230-0001	Female (Tin)	22 AWG	0.352	WSB-M1L134-A1	WSS-M1L135-A1	1.50-1.65	.059-.065	4.00-4.80	.157-.189
				ESB-M1L120-A	ESB-M1L123-A/A2				
34230-0001	Female (Tin)	0.35mm ²	0.340	WSK-M1L124-A	S97GG-14401-AA	1.20-1.40	.047-.055	4.00-4.80	.157-.189
34230-0001	Female (Tin)	0.22mm ²	0.214	WSK-M1L124-A	N/A	1.10-1.20	.043-.047	4.00-4.80	.157-.189

DEFINITION OF TERMS



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

CRIMP SPECIFICATION

Terminal Series No.	Bell mouth (Front Only)		Cut-off Tab Max.		Conductor Brush	
	mm	In.	mm	In.	mm	In.
34230-0001	0.20-0.50	.008-.020	0.50	.020	0.10-1.00	.004-.039

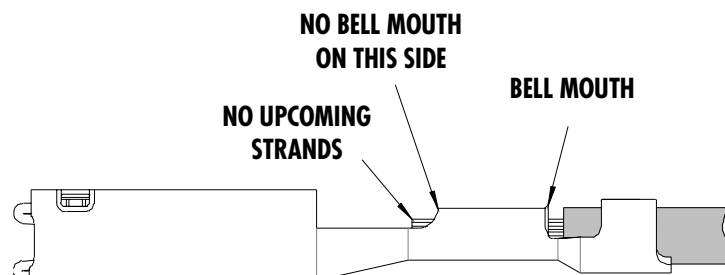
Terminal Part No.	Wire Size	Actual mm ²	Bend up	Bend down	Twist	Roll	Punch Width (Ref)				Seam Seam shall not be open and no wire allowed out of the crimping area
			Degree		Degree		Conductor		Insulation		
			mm	In	mm	In	mm	In			
34230-0001	22 AWG	0.352	3	3	2.5	N/A	1.35	.053	1.65	.065	
34230-0001	0.35mm ²	0.340	3	3	2.5	N/A	1.35	.053	1.65	.065	
34230-0001	0.22mm ²	0.214	3	3	2.5	N/A	1.35	.053	1.65	.065	

After crimping, the conductor profile should measure the following.

Terminal Series No.	Wire Size	Actual mm ²	Wire Specification		Conductor				Pull Force Min.	
			Low Temp.	High Temp.	Crimp Height		Crimp Width		N	Lb.
					mm	In.	mm	In.		
34230-0001	22 AWG	0.352	WSB-M1L134-A1	WSS-M1L135-A1	1.02-1.10	.040-.043	1.39-1.47	.055-.058	53.0	11.93
34230-0001	22 AWG	0.352	ESB-M1L120-A	ESB-M1L123-A/A2	1.02-1.10	.040-.043	1.39-1.47	.055-.058	53.0	11.93
34230-0001	0.35mm ²	0.340	WSK-M1L124-A	S97GG-14401-AA	1.02-1.10	.040-.043	1.39-1.47	.055-.058	53.0	11.93
34230-0001	0.22mm ²	0.214	WSK-M1L124-A	N/A	0.96-1.04	.038-.041	1.38-1.46	.054-.057	40.0	9.00

Terminal Series No.	Wire Size	Actual mm ²	Wire Specification		Insulation			
			Low Temp.	High Temp.	Crimp Height		Crimp Width	
					mm	In.	mm	In.
34230-0001	22 AWG	0.352	WSB-M1L134-A1	WSS-M1L135-A1	1.50-1.70	.059-.067	1.60-1.80	.063-.071
34230-0001	22 AWG	0.352	ESB-M1L120-A	ESB-M1L123-A/A2	1.50-1.70	.059-.067	1.60-1.80	.063-.071
34230-0001	0.35mm ²	0.340	WSK-M1L124-A	S97GG-14401-AA	1.50-1.70	.059-.067	1.60-1.80	.063-.071
34230-0001	0.22mm ²	0.214	WSK-M1L124-A	N/A	1.50-1.70	.059-.067	1.60-1.80	.063-.071

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



PARTS LIST

Item	Order No	Engineering No.	Description	Quantity
	63866-5100	63866-5100	FineAdjust Applicator (Fig. 1)	REF
1	63457-0021	63457-0021	Conductor Punch	1 Y
2	63455-0021	63455-0021	Conductor Anvil	1 Y
3	63454-0033	63454-0033	Insulation Punch	1 Y
4	63456-0028	63456-0028	Insulation Anvil	1 Y
5	63461-0001	63461-0001	Cut-Off Plunger	1 Y
6	63443-0036	63443-0036	Front Plunger Retainer	1 Y
7	63700-0539	63700-0539	Cut-off Plunger Spring	1
8	634433160	634433160	Front Plunger Striker	1
9	63443-0021	63443-0021	Lower Tooling Key	1
10	63443-6009	63443-6009	Rear Cover	1
11	11-18-4094	60709A111	Front Cover	1
12	63443-2510	63443-2510	Anvil Mount	1
13	11-18-4080	60707-5	Wire Stop	1
14	63443-0009	63443-0009	Scrape Chute	1
15	63801-3100	63801-3100	Wide Track Fine Adjust Frame	1
16	N/A	N/A	M3 by 6Lg. SHCS	2**
17	N/A	N/A	M4 by 6Lg. SHCS	1**
18	N/A	N/A	M4 by 12Lg. BHCS	2**
19	N/A	N/A	M4 by 50Lg. SHCS	2**
20	N/A	N/A	M5 by 12Lg SHCS	1**
21	N/A	N/A	3MM by 6Lg. Roll Pin	1**
22	N/A	N/A	#10-32 by 1/4"Lg. BHCS	1**
	63866-5170	63866-5170	Tool Kit (All Y Items)	REF

** The following purchased parts are available from an Industrial supply company such as MSC (1-800-645-7270).

Assembly Drawing

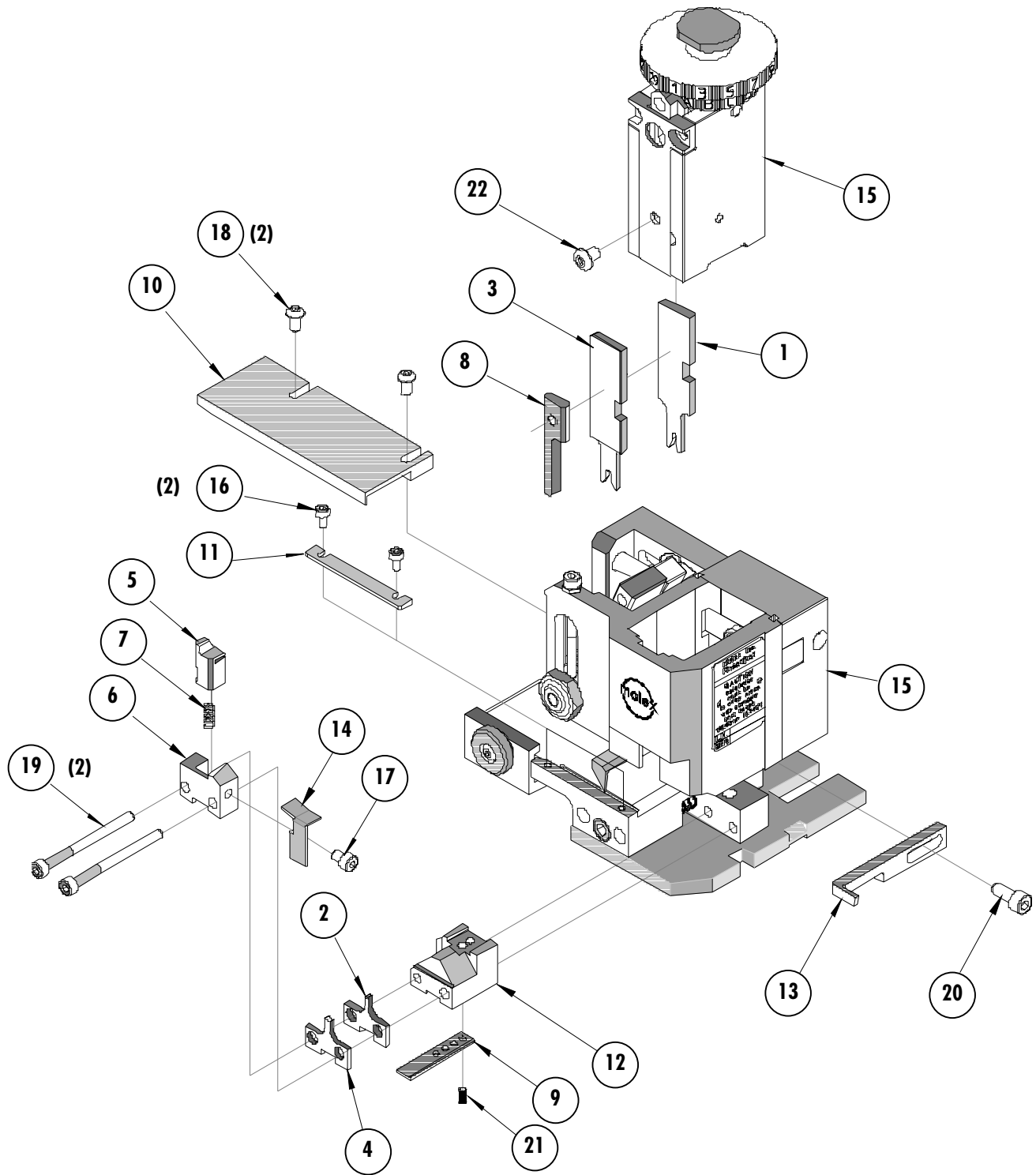


Figure 1

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.

Molex Application Tooling Group

1150 E. Diehl Road
Naperville, IL 60563
Tel: (630) 969-4550
Fax: (630) 505-0049

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