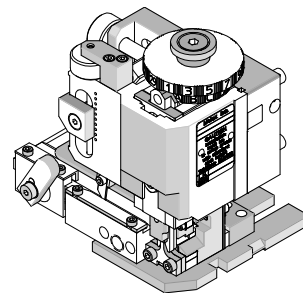




FineAdjust Applicator Specification Sheet Order No. 63900-7300



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

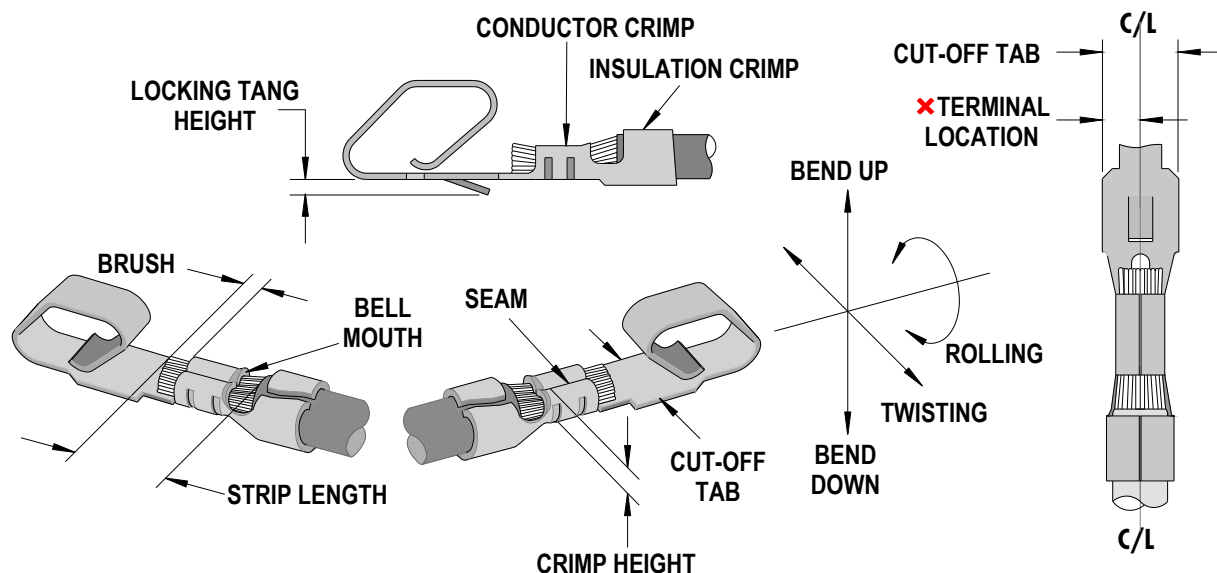
SCOPE

Products: KK®, 3.96mm (.156") Pitch Crimp Terminal, 18-24 AWG.

Note: Special cut-off tab width for 2478 Series terminals using the **7241 Series IDT housing** only.
2478 Series terminals are not rated for USCAR21 compliancy.

Terminal Series No.	Terminal Order No.			Wire Size		Insulation Diameter		Strip Length	
				AWG	mm ²	mm	In.	mm	In.
2478	08-50-0001	08-52-0114	39-00-0103	18 - 24	0.80-0.20	✱2.79	✱.110	2.54-3.18	.100-.125
	08-50-0015	08-52-0811	39-00-0133						
	08-50-0063	08-53-0811	39-00-0286						
	08-50-0073	08-55-0103	39-00-0343						
	08-50-0105	08-55-0133	39-00-0345						
	08-50-0119	08-56-0105	39-00-0347						
	08-50-0146	08-56-0153	39-00-0349						
	08-50-0271	08-58-0103	40-01-1118						
	08-50-0281	08-58-0114	50-29-1689						
	08-52-0071	08-58-0121	50-29-1768						
	08-52-0073	08-65-0114							
✱Insulation below 1.65mm (.065 inch) diameter may produce loose insulation crimps.									

DEFINITION OF TERMS



✗ Terminal is to be centrally located between the two (2) cut-off edges, within $\pm 0.13\text{mm}$ ($\pm .005$).

CRIMP SPECIFICATIONS

Terminal Series No.	Bell mouth		✗ Cut-off Tab		Conductor Brush	
	mm	In.	mm	In.	mm	In.
2478	0.20-0.50	.008-.020	$3.02 \pm .13$	$.119 \pm .005$	0.13-0.64	.005-.025

Terminal Series No.	Locking Tang Height		Bend up Bend down		Twist Roll		Punch Width (Ref)				Seam Seam shall not be open and no wire allowed out of the crimping area
	mm	In	Degree		Degree		Conductor mm	In	Insulation mm	In	
2478	0.64-0.76	.025-.030	3	3	4	8	2.00	.079	2.50	.098	

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.
2478	18	0.80	1.09-1.14	.043-.045	110	25
✗ 08-52-0071	18	0.81	1.07-1.17	.042-.046	110	25
2478	20	0.50	1.02-1.09	.040-.043	66	15
2478	22	0.35	0.97-1.02	.038-.040	44	10
2478	24	0.20	0.91-0.97	.036-.038	35	8
✗ Special for use with 18 AWG UL1015, 16 strand (.010") diameter wire only. 0.81mm ² .254mm						

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

PARTS LIST

FineAdjust Applicator 63900-7300				
Item No.	Order No.	Engineering No.	Description	Quantity
Perishable Tooling				
	63900-7370	63900-7370	Tool Kit (All "Y" Items)	REF
1	63444-2013	63444-2013	Conductor Punch	1 Y
2	63445-2043	63445-2043	Conductor Anvil	1 Y
3	63454-0005	63454-0005	Insulation Punch	1 Y
4	63445-2566	63445-2566	Insulation Anvil	1 Y
5	63443-3314	63443-3314	Cut-Off Die	1 Y
6	63443-3418	63443-3418	Cut-Off Punch	1 Y
Other Components				
7	11-18-4103	60712-3	Cover Plate	1
8	11-18-5015	60805A122	Front Cover	1
9	63443-0025	63443-0025	Key (Dual Carrier)	1
10	63443-1214	63443-1214	Cut-Off Plunger Retainer	1
11	63443-1202	63443-1202	Guide Block	1
12	63443-1203	63443-1203	Rear Cover Retainer	1
13	63443-1204	63443-1204	Wire Stop	1
14	63443-1210	63443-1210	Wire Stop Mounting Bracket	1
15	63443-2310	63443-2310	3.50mm Spacer	1
16	63443-2801	63443-2801	Front Plunger Striker	1
17	63443-2912	63443-2912	Wire Hold-Down Plunger	1
18	63443-3514	63443-3514	Terminal Lifter	1
19	63600-0021	63600-0021	Compression Spring	1
20	63600-2995	63600-2995	Spring Lifter	1
21	63700-0539	63700-0539	Compression Spring	1
22	63820-0012	63820-0012	Terminal Drag Cover	1
Frame				
23	63800-4901	63800-4901	Top	1
24	63801-3285	63801-3285	Base	1
25	63801-6550	63801-6550	Track	1
Hardware				
26	N/A	N/A	M2.5 by 5 Long SHCS	2**
27	N/A	N/A	M3 by 5 Long SHCS	3**
28	N/A	N/A	M3 by 6 Long FHCS	1**
29	N/A	N/A	M3 by 6 Long SHCS	4**
30	N/A	N/A	M3 by 12 Long SHCS	1**
31	N/A	N/A	M4 by 6 Long SHCS	2**
32	N/A	N/A	M4 by 12 Long BHCS	2**
33	N/A	N/A	M4 by 45 Long SHCS	2**
34	N/A	N/A	#10-32 by 3/8" Long SSS (Flat Point)	1**
35	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

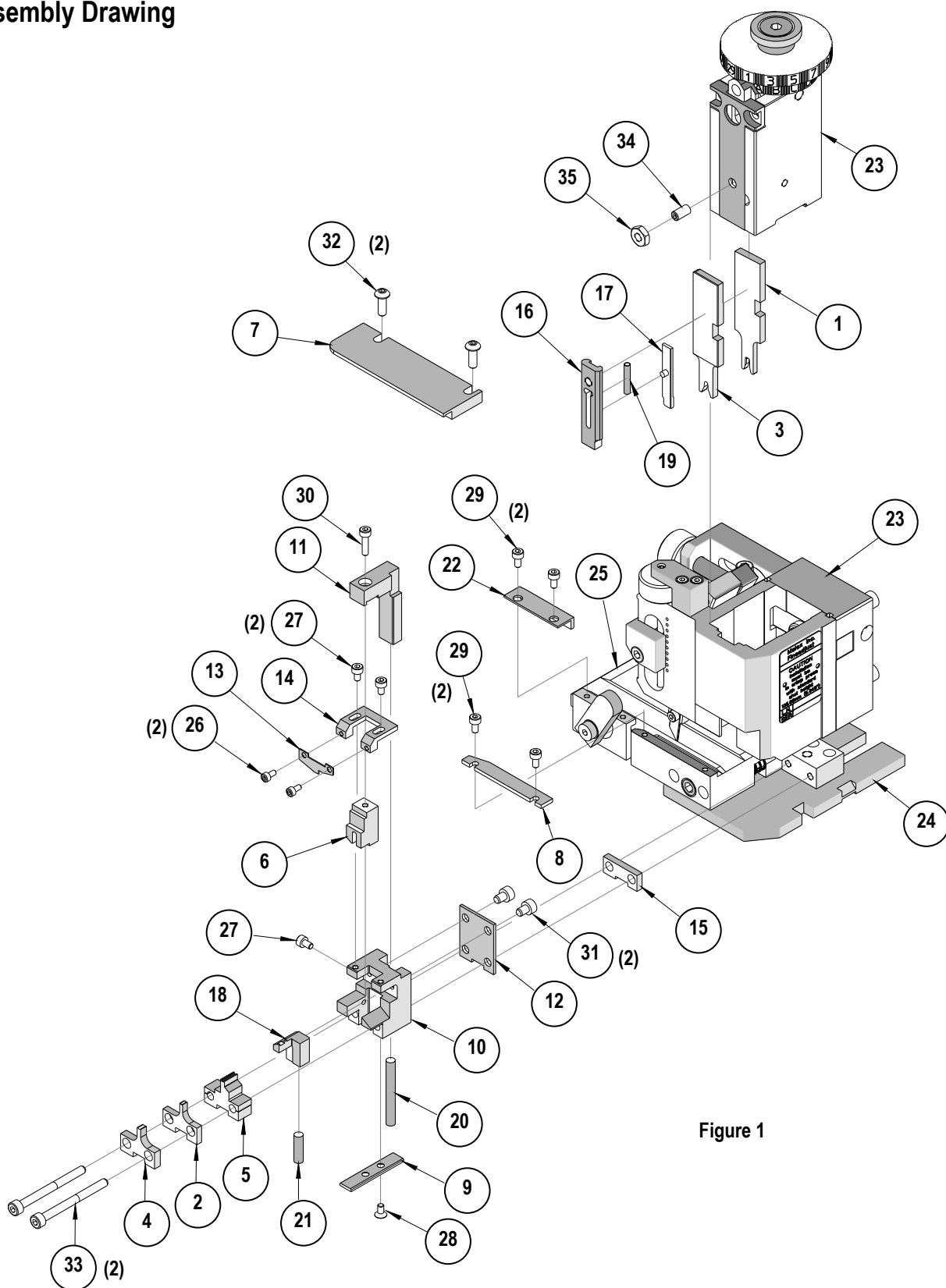


Figure 1

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.

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