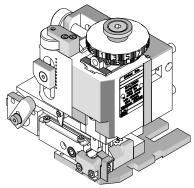# FineAdjust Applicator
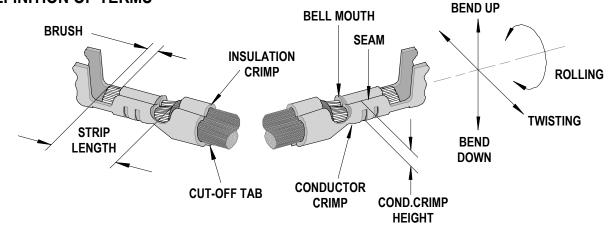# Specification Sheet
Order No. 63862-9200

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

Products: 1.80mm (.070") Board-In Terminal for 18 (2), 20 (2) AWG.

Terminal Series No.	Terminal Order No.	Wire Size		Insulation Diameter				Strip Length	
				IPC/WHMA-A620✦		Terminal Maximum✦✦			
		AWG	mm²	mm	In.	mm	In.	mm	In.
35745	35745-0310	18 (2)-20 (2)	0.80 (2)-0.50 (2)	2.50-2.80	.098-.110	2.80 (2)	.110 (2)	4.00-4.80	.157-.189
35746	35746-0310	18 (2)-20 (2)	0.80 (2)-0.50 (2)	2.50-2.80	.098-.110	2.80 (2)	.110 (2)	4.00-4.80	.157-.189
35747	35747-0310	18 (2)-20 (2)	0.80 (2)-0.50 (2)	2.50-2.80	.098-.110	2.80 (2)	.110 (2)	4.00-4.80	.157-.189
35748	35748-0310	18 (2)-20 (2)	0.80 (2)-0.50 (2)	2.50-2.80	.098-.110	2.80 (2)	.110 (2)	4.00-4.80	.157-.189
✦To achieve optimum IPC-A620 insulation crimps, use this insulation OD range. ✦✦Overall insulation OD specification for terminal.									

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		Cut-off Tab Maximum		Conductor Brush	
	mm	In.	mm	In.	mm	In.
35745	0.20-0.50	.008-.020	0.30	.012	0.30-0.80	.012-.032
35746	0.20-0.50	.008-.020	0.30	.012	0.30-0.80	.012-.032
35747	0.20-0.50	.008-.020	0.30	.012	0.30-0.80	.012-.032
35748	0.20-0.50	.008-.020	0.30	.012	0.30-0.80	.012-.032

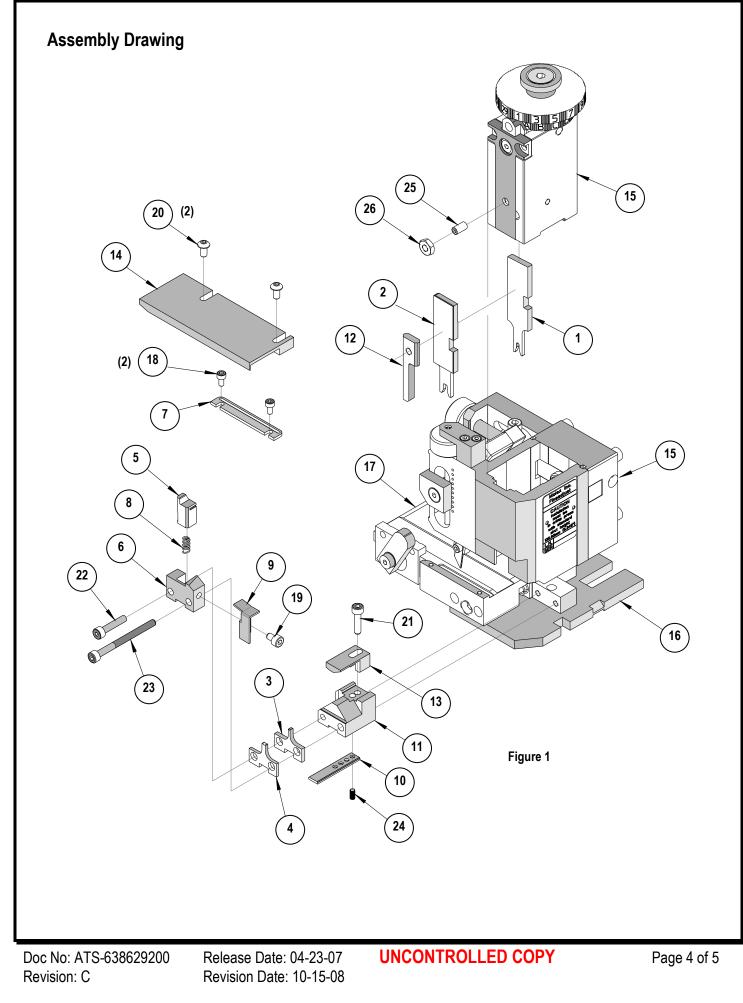| Terminal Series No.	Bend up	Bend down	Twist	Roll	Punch Width (Ref)				Seam
					Conductor		Insulation		
	Degree		Degree		mm	In	mm	In	
35745	3	3	3	5	3.00	.118	5.30	.209	Seam shall not be open
35746	3	3	3	5	3.00	.118	5.30	.209	and no wire allowed out
35747	3	3	3	5	3.00	.118	5.30	.209	of the crimping area
35748	3	3	3	5	3.00	.118	5.30	.209	

After crimping, the conductor profile should measure the following.

Terminal Series No.	Wire Size		Conductor				Pull Force Minimum	
			Crimp Height		Crimp Width (Ref.)			
	AWG	mm²	mm	In.	mm	In.	N	Lb.
35745	18 (2)	0.80 (2)	1.45-1.55	.057-.061	2.90-3.10	.114-.122	97.9	22.0
	20 (2)	0.50 (2)	1.35-1.45	.053-.057	2.90-3.10	.114-.122	58.7	13.2
35746	18 (2)	0.80 (2)	1.45-1.55	.057-.061	2.90-3.10	.114-.122	97.9	22.0
	20 (2)	0.50 (2)	1.35-1.45	.053-.057	2.90-3.10	.114-.122	58.7	13.2
35747	18 (2)	0.80 (2)	1.45-1.55	.057-.061	2.90-3.10	.114-.122	97.9	22.0
	20 (2)	0.50 (2)	1.35-1.45	.053-.057	2.90-3.10	.114-.122	58.7	13.2
35748	18 (2)	0.80 (2)	1.45-1.55	.057-.061	2.90-3.10	.114-.122	97.9	22.0
	20 (2)	0.50 (2)	1.35-1.45	.053-.057	2.90-3.10	.114-.122	58.7	13.2

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
-FineAdjust Applicator 63862-9200				
-Perishable Tooling				
	63862-9270	63862-9270	Tool Kit (All "Y" Items)	REF
1	63444-3012	63444-3012	Conductor Punch	1 Y
2	63445-3068	63445-3068	Conductor Anvil	1 Y
3	63446-5309	63446-5309	Insulation Punch	1 Y
4	63445-5306	63445-5306	Insulation Anvil	1 Y
5	63443-0002	63443-0002	Cut-Off Plunger	1 Y
6	63443-0012	63443-0012	Front Plunger Retainer	1 Y
-Other Components (REF 629050)				
7	11-18-4083	60707-8	Front Cover	1
8	11-24-1067	4996-4	Cut-off Plunger Spring	1
9	63443-0009	63443-0009	Scrap Chute Front	1
10	63443-0021	63443-0021	Lower Tooling Key	1
11	63443-2415	63443-2415	Anvil Mount	1
12	63443-3160	63443-3160	Front Plunger Striker	1
13	63443-4006	63443-4006	Wire Stop	1
14	63443-6011	63443-6011	Rear Cover	1
-Frame				
15	63800-4901	63800-4901	Top	1
16	63801-3281	63801-3281	Base	1
17	63801-4650	63801-4650	Track	1
-Hardware				
18	N/A	N/A	M3 by 6 Long SHCS	2**
19	N/A	N/A	M4 by 6 Long SHCS	1**
20	N/A	N/A	M4 by 12 Long BHCS	2**
21	N/A	N/A	M4 by 16 Long SHCS	1**
22	N/A	N/A	M4 by 20 Long SHCS	1**
23	N/A	N/A	M4 by 50 Long SHCS	1**
24	N/A	N/A	3mm by 6 Long Roll Pin	1**
25	N/A	N/A	#10-32 by 3/8" Long Flat Point SSS	1**
26	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.