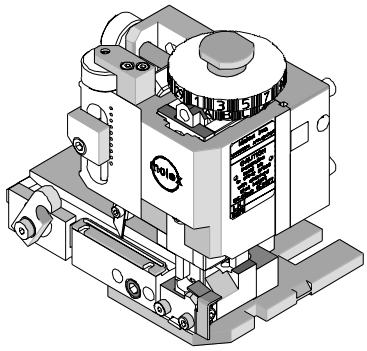
FineAdjust Applicator Specification Sheet Part No. 63860-1100



FEATURES

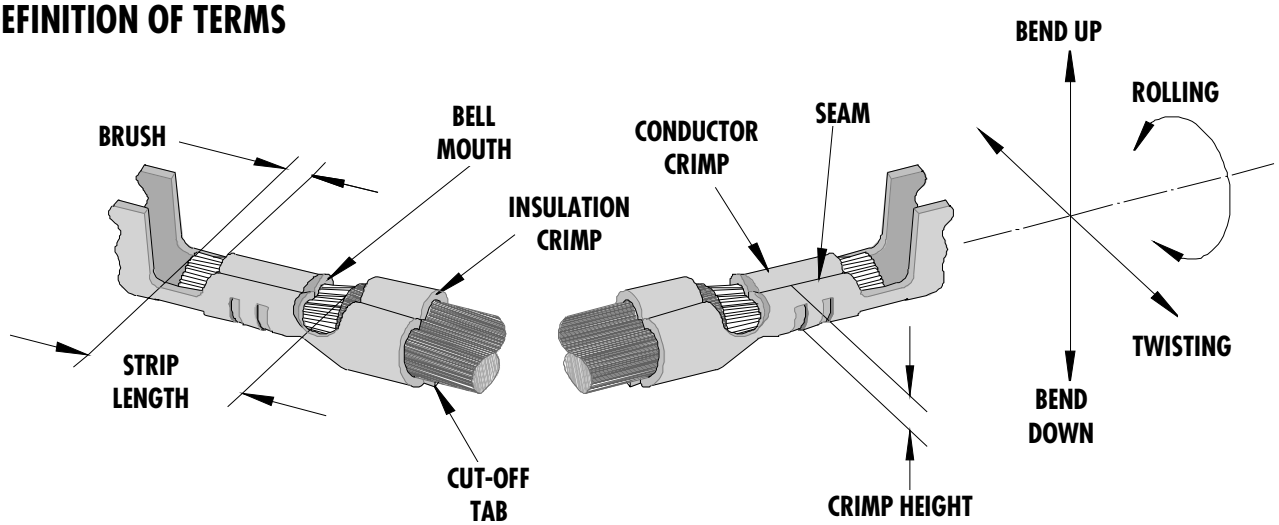
- Quick punch removal with the push of a button for fast and easy tooling change
- Applicator designed to industry standard mounting and shut height 135.80mm (5.346")
- Quick set-up time; plus the crimp height, track and feed adjustments can be set without removing the applicator from the press
- Fine 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: Mini-Fit Jr. ™ Crimp Terminal 22-28 AWG.

Terminal Series No.	Terminal Order No.				Wire Size		Insulation Diameter		Strip Length	
					AWG	mm²	mm	In.	mm	In.
5556	39-00-0046	39-00-0116	39-00-0177	39-00-0215	22-28	0.35-0.08	0.90-1.80	.035-.071	2.80-3.30	.110-.130
	39-00-0065	39-00-0139	39-00-0183	39-00-0231						
	39-00-0085	39-00-0155	39-00-0196	39-00-0434						
	39-00-0091	39-00-0165	39-00-0202							
	39-00-0110	39-00-0171	39-00-0209							
5558	39-00-0048	39-00-0097	39-00-0145	40-01-0854	22-28	0.35-0.08	0.90-1.80	.035-.071	2.80-3.30	.110-.130
	39-00-0067	39-00-0121	39-00-0432	98-00-0175						
	39-00-0087	39-00-0128	39-00-0221							
44485	44485-2211	44485-2311	44485-2411		22-28	0.35-0.08	0.90-1.80	.035-.071	2.80-3.30	.110-.130

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 Max.		Conductor Brush	
	mm	In.	mm	In.	mm	In.
5556	0.20-0.50	.008-.020	0.30	.012	0.00-1.00	.000-.039
5558	0.20-0.50	.008-.020	0.30	.012	0.00-1.00	.000-.039
44485	0.20-0.50	.008-.020	0.30	.012	0.00-1.00	.000-.039

Terminal Series No.	Bend up	Bend down	Twist	Roll	Punch Width (Ref)				Seam
					Conductor		Insulation		
	Degree		Degree		mm	In.	mm	In.	
5556	5	2	5	17	1.40	.055	1.80	.071	Seam shall not be open And no wire allowed out of the crimping area
5558	5	2	5	17	1.40	.055	1.80	.071	
44485	5	2	5	17	1.40	.055	1.80	.071	

After crimping, the crimp profiles should measure the following:

Terminal Series No.	Wire Size		Conductor				Pull Force Min.	
			Crimp Height		Crimp Width (Ref)			
	AWG	mm^2	mm	In.	mm	In.	N	Lb.
5556	22	0.35	0.76-0.83	.030-.033			39.1	8.80
	24	0.20	0.70-0.77	.028-.030			29.3	6.60
	26	0.12	0.66-0.72	.026-.028			19.6	4.40
	28	0.08	0.63-0.69	.025-.027			9.8	2.20
5558	22	0.35	0.76-0.83	.030-.033			39.1	8.80
	24	0.20	0.70-0.77	.028-.030			29.3	6.60
	26	0.12	0.66-0.72	.026-.028			19.6	4.40
	28	0.08	0.63-0.69	.025-.027			9.8	2.20
44485	22	0.35	0.76-0.83	.030-.033			39.1	8.80
	24	0.20	0.70-0.77	.028-.030			29.3	6.60
	26	0.12	0.66-0.72	.026-.028			19.6	4.40
	28	0.08	0.63-0.69	.025-.027			9.8	2.20

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

FineAdjust Applicator 63860-1100				
Item	**Order No**	**Engineering No.**	**Description**	**Quantity**
Perishable Tooling				
	63860-1170	63860-1170	Tool Kit (All "Y" Items)	REF
1	63444-1421	63444-1421	Conductor Punch	1 Y
2	63445-1441	63445-1441	Conductor Anvil	1 Y
3	63446-1816	63446-1816	Insulation Punch	1 Y
4	63445-1819	63445-1819	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				
7	11-18-4083	60707-8	Front Cover	1
8	11-24-1067	4996-4	Cut-Off Plunger Spring	1
9	11-40-4039	8302-5	Front Plunger Striker	1
10	63443-0009	63443-0009	Scrap Chute	1
11	63443-0021	63443-0021	Lower Tooling Key	1
12	63443-2408	63443-2408	Anvil Mount	1
13	63443-4018	63443-4018	Wire Stop	1
14	63443-6003	63443-6003	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 6Long SHCS	2**
19	N/A	N/A	M4 by 6Long SHCS	1**
20	N/A	N/A	M4 by 12Long BHCS	2**
21	N/A	N/A	M4 by 16Long SHCS	1**
22	N/A	N/A	M4 by 20Long SHCS	1**
23	N/A	N/A	M4 by 50Long SHCS	1**
24	N/A	N/A	3MM by 6Long Roll Pin	1**
25	N/A	N/A	#10-32 by 1/4"Long BHCS	1**
** Available from an industrial supply company such as MSC (1-800-645-7270).				

Assembly Drawing

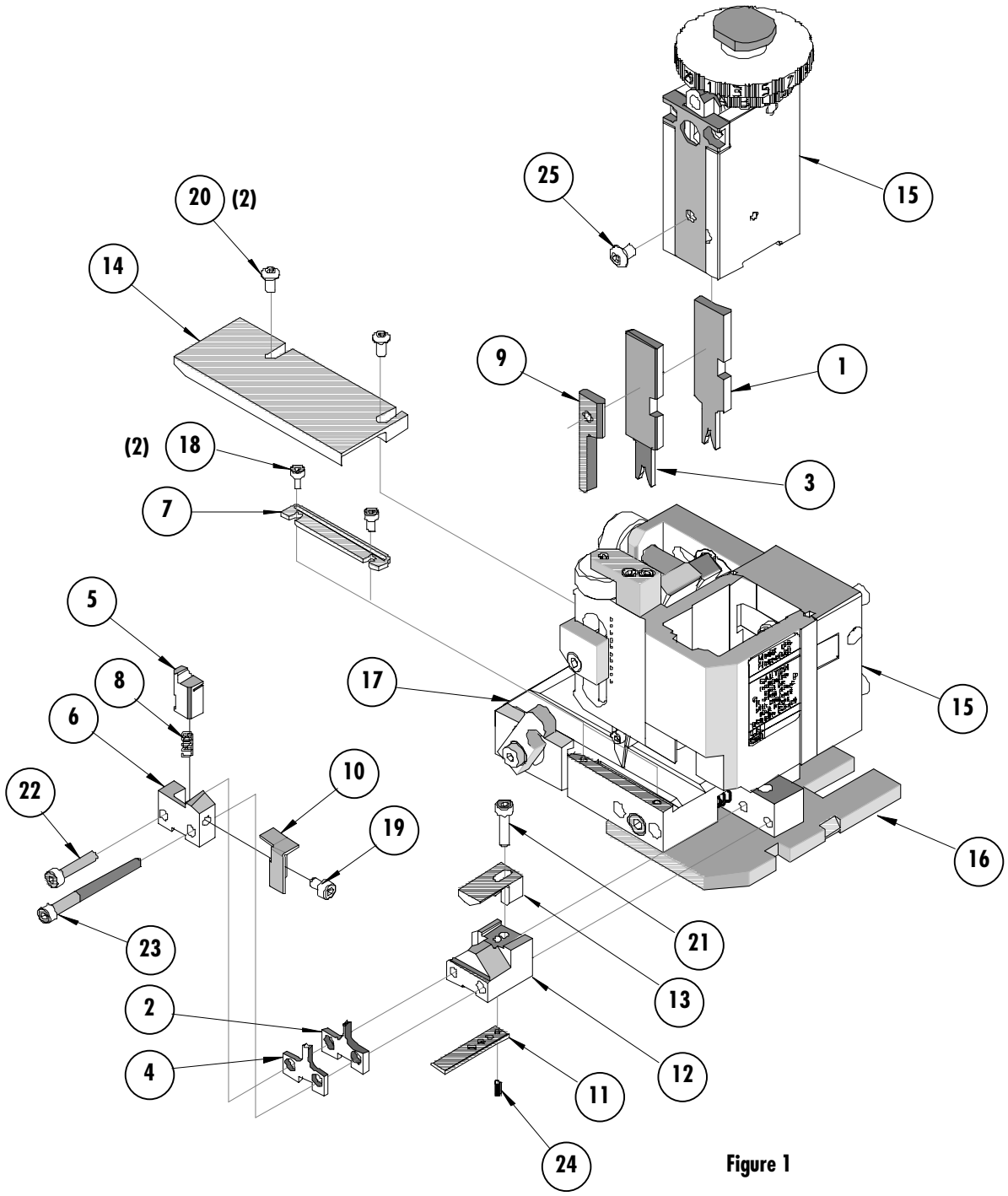


Figure 1

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 135.80 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.

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