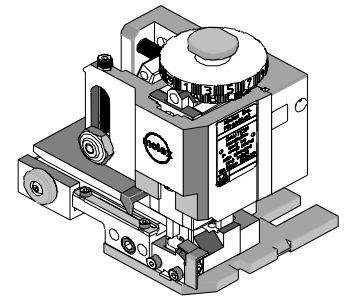




FineAdjust Applicator Specification Sheet Part No. 63865-4000



FEATURES

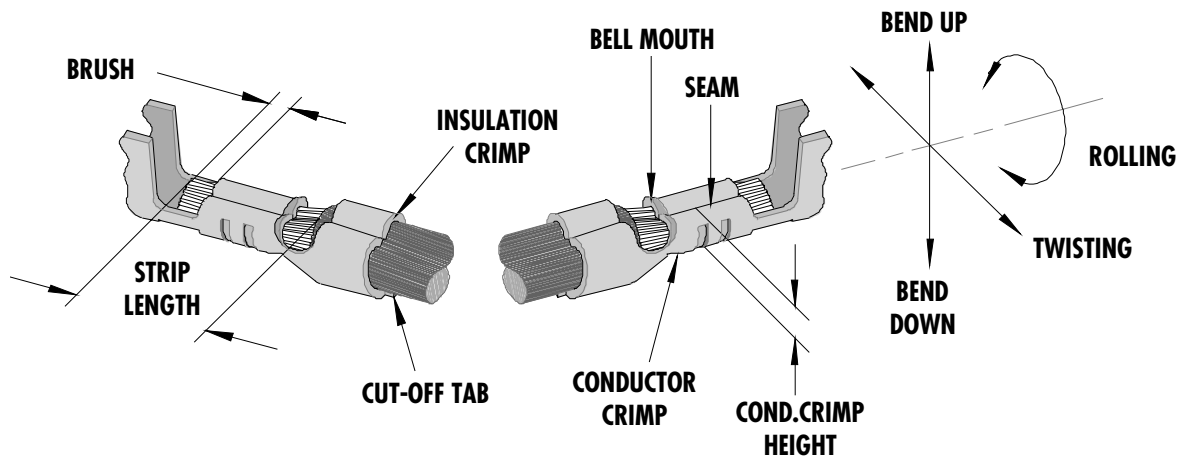
- Quick punch removal with the push of a button for fast and easy tooling change
- Applicator designed to industry standard mounting and shut height 135.80mm (5.346")
- Quick set-up time; plus the crimp height, track and feed adjustments can be set without removing the applicator from the press
- Fine 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 | | Insulation Diameter | | Strip Length | |
|---------------------|-------------|-----------|-----------------|---------------------|-----------|--------------|-----------|
| | | AWG | mm ² | mm | In. | mm | In. |
| 33000-1003 | Male (tin) | 22 | 0.36 | 1.50-1.65 | .059-.065 | 4.70-5.60 | .185-.220 |
| 33011-0006 | Male (gold) | 22 | 0.36 | 1.50-1.65 | .059-.065 | 4.70-5.60 | .185-.220 |
| 31296-0006 | Male (long) | 22 | 0.36 | 1.50-1.65 | .059-.065 | 4.70-5.60 | .185-.220 |

Terminal will accommodate the following wire specification:
Wires to be thin wall thickness per Ford's specification M1L135-A1 and M1L123-A.

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. |
| 33000-1003 | 0.25-1.25 | .010-.049 | 0.50 | .020 | 0.15-0.65 | .006-.026 |
| 33011-0006 | 0.25-1.25 | .010-.049 | 0.50 | .020 | 0.15-0.65 | .006-.026 |
| 31296-0006 | 0.25-1.25 | .010-.049 | 0.50 | .020 | 0.15-0.65 | .006-.026 |

| Terminal Series No. | Bend up Bend down | | Twist | Roll | Punch Width mm (Ref) | | | | Seam |
|---------------------|-------------------|----|-------|------|----------------------|------|-----------|------|---------------------------------------------------------------------|
| | Degree | | | | Degree | | Conductor | | |
| | mm | In | mm | In | mm | In | mm | In | |
| 33000-1003 | 3 | 3 | 3 | 5 | 1.53 | .060 | 1.85 | .073 | Seam shall not be open and no wire allowed out of the crimping area |
| 33011-0006 | 3 | 3 | 3 | 5 | 1.53 | .060 | 1.85 | .073 | |
| 31296-0006 | 3 | 3 | 3 | 5 | 1.53 | .060 | 1.85 | .073 | |

After crimping, the conductor profile should measure the following.

| Terminal Series No. | Wire Size | | Conductor | | | | Insulation | | | | Pull Force Min. | |
|---------------------|-----------|-----------------|--------------|-----------|-------------|-----------|--------------|-----------|-------------|-----------|-----------------|-------|
| | | | Crimp Height | | Crimp Width | | Crimp Height | | Crimp Width | | | |
| | AWG | mm ² | mm | In. | mm | In. | mm | In. | mm | In. | N | Lb. |
| 33000-1003 | 22 | 0.36 | 0.95-1.05 | .037-.041 | 1.50-1.70 | .059-.067 | 1.75-1.95 | .069-.077 | 1.80-2.00 | .071-.079 | 50.0 | 11.25 |
| 33011-0006 | 22 | 0.36 | 0.95-1.05 | .037-.041 | 1.50-1.70 | .059-.067 | 1.75-1.95 | .069-.077 | 1.80-2.00 | .071-.079 | 50.0 | 11.25 |
| 31296-0006 | 22 | 0.36 | 0.95-1.05 | .037-.041 | 1.50-1.70 | .059-.067 | 1.75-1.95 | .069-.077 | 1.80-2.00 | .071-.079 | 50.0 | 11.25 |

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 |
|------|-------------------|-------------------|-----------------------------------------|------------|
| | 63865-4000 | 63865-4000 | FineAdjust Applicator (Fig. 1) | REF |
| 1 | 63457-0007 | 63457-0007 | Conductor Punch | 1 Y |
| 2 | 63455-0009 | 63455-0009 | Conductor Anvil | 1 Y |
| 3 | 63454-0014 | 63454-0014 | Insulation Punch | 1 Y |
| 4 | 63456-0013 | 63456-0013 | 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 | 63443-3160 | 63443-3160 | Front Plunger Striker | 1 |
| 9 | 63443-0021 | 63443-0021 | Lower Tooling Key | 1 |
| 10 | 63443-6004 | 63443-6004 | Rear Cover | 1 |
| 11 | 11-18-4094 | 60709A111 | Front Cover | 1 |
| 12 | 63443-2506 | 63443-2506 | 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 Applicator Frame | 1 |
| 16 | 63459-0001 | 63459-0001 | * Wide Terminal Track | 1 |
| 17 | N/A | N/A | M3 by 6Lg. SHCS | 2** |
| 18 | N/A | N/A | M4 by 6Lg. SHCS | 1** |
| 19 | N/A | N/A | M4 by 12Lg. BHCS | 2** |
| 20 | N/A | N/A | M4 by 50Lg. SHCS | 2** |
| 21 | N/A | N/A | M5 by 12Lg SHCS | 1** |
| 22 | N/A | N/A | 3MM by 6Lg. Roll Pin | 1** |
| 23 | N/A | N/A | #10-32 by 1/4"Lg. BHCS | 1** |
| | 63865-4070 | 63865-4070 | Tool Kit (All Y Items) | REF |

* Frame Part to be Modified

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

Assembly Drawing

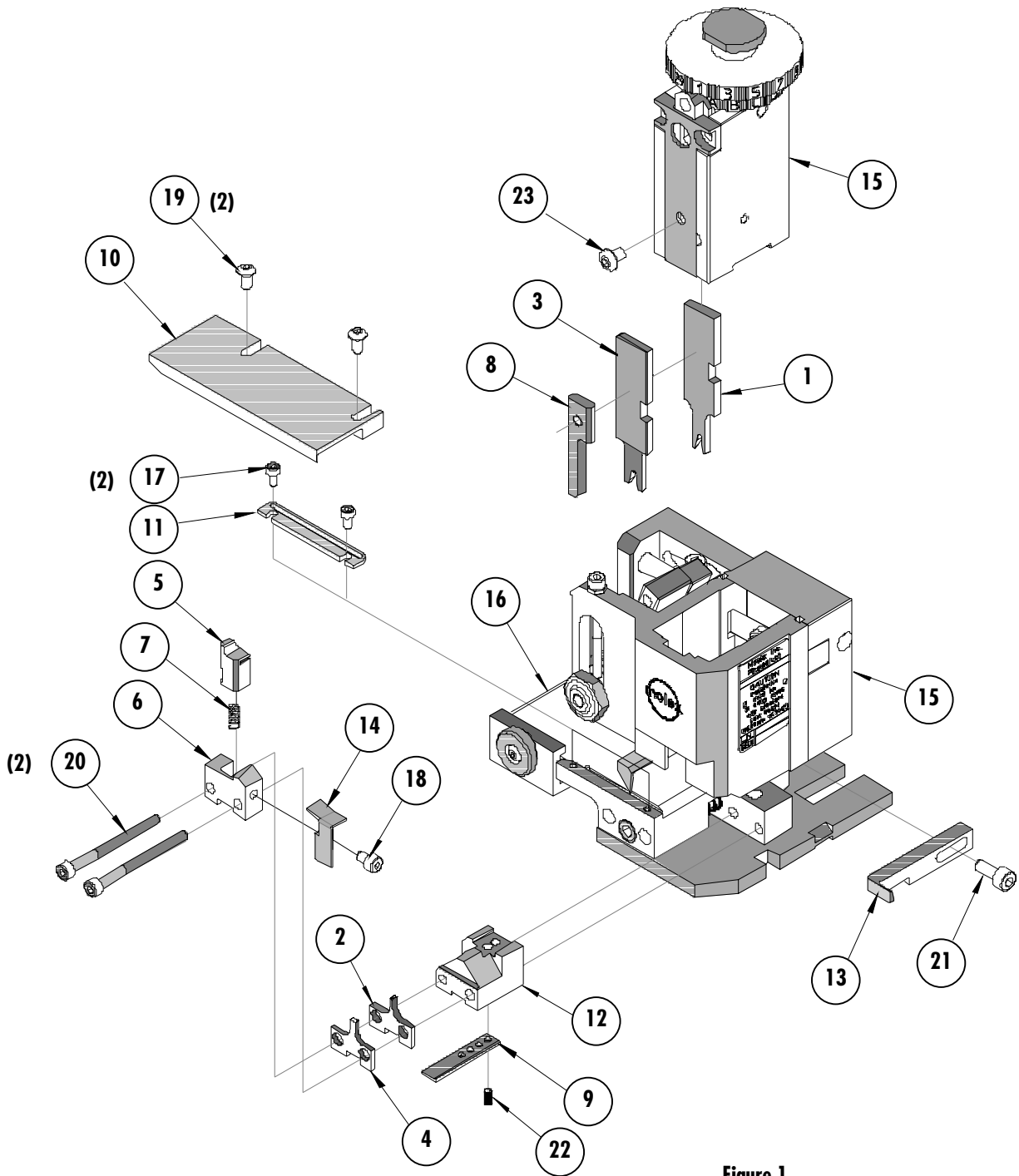


Figure 1

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.

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