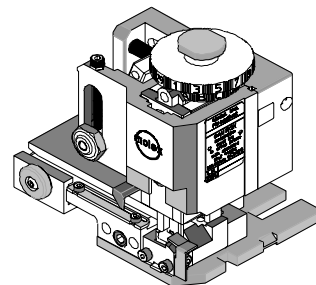




FineAdjust Applicator Specification Sheet Part No. 63867-3100



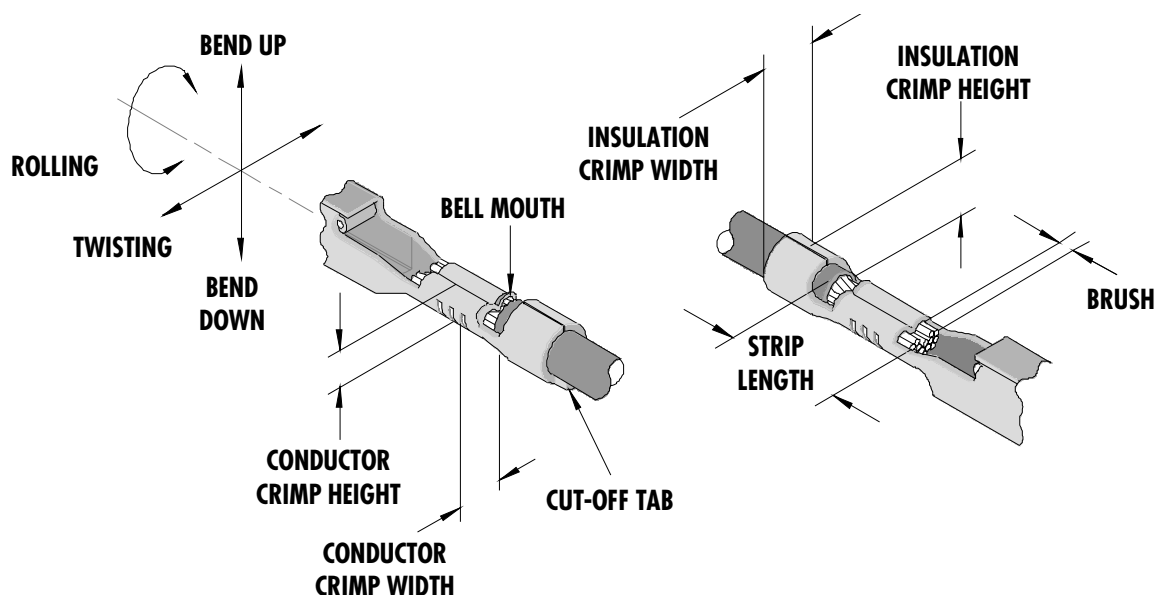
FEATURES

- 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.
33467-0004	Female (Gold)	22	0.36	1.50-1.65	.059-.065	2.70-3.50	.106-.138
33468-0002	Female (Tin)	22	0.36	1.50-1.65	.059-.065	2.70-3.50	.106-.138
Terminal will accommodate the following wire specification: SAE: ESB-M1L123-A, WSS-M1L135-A1, and SAE-J1128 Metric: WSK-M1L126-A1.							

DEFINITION OF TERMS



CRIMP SPECIFICATION

Terminal Series No.	Bell mouth		Cut-off Tab Max.		Conductor Brush	
	mm	In.	mm	In.	mm	In.
33467-0004	0.25-1.25	.010-.049	0.50	.020	0.10-0.55	.004-.022
33468-0002	0.25-1.25	.010-.049	0.50	.020	0.10-0.55	.004-.022

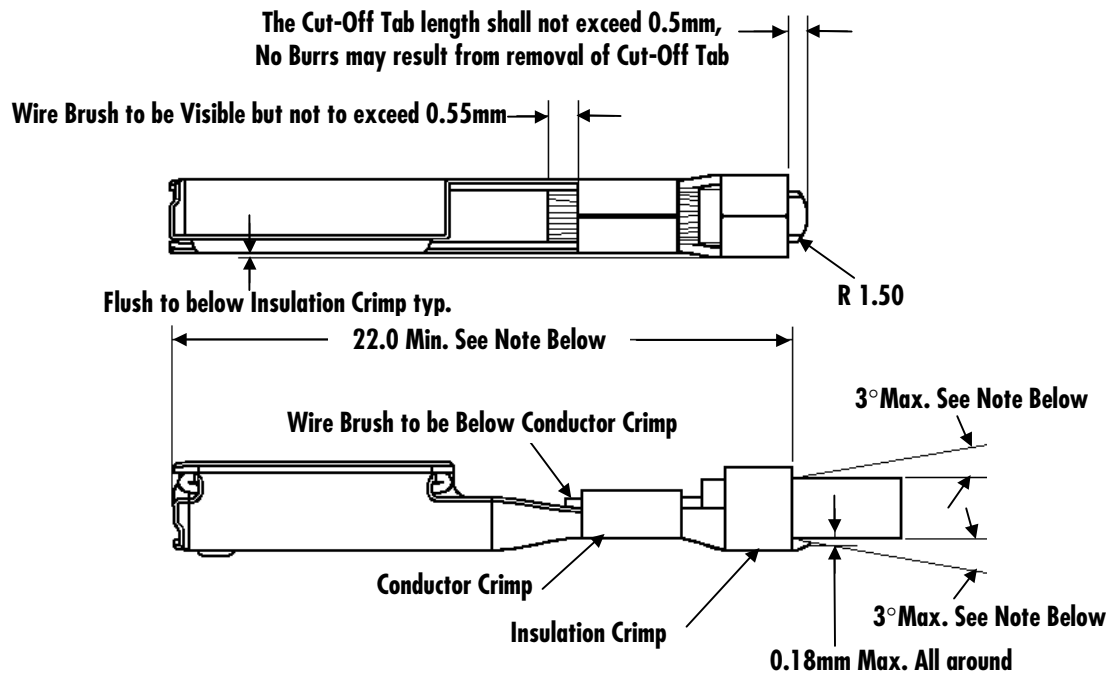
Terminal Series No.	Bend up Bend down	Twist	Roll	Seam
33467-0004	Crimped Samples must pass thru the 63867-3008 Checking Aid *			Seam shall not be open and no wire allowed Out of the crimping area
33468-0002				

* Ordered separately

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.
33467-0004	22	0.36	0.90-1.00	.035-.039	1.40-1.50	.055-.059	1.50-1.70	.059-.067	1.70-1.90	.067-.075	50.0	11.25
33468-0002	22	0.36	0.90-1.00	.035-.039	1.40-1.50	.055-.059	1.50-1.70	.059-.067	1.70-1.90	.067-.075	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.

**NOTE:**

Straightness:

A Crimped terminal lead must be able to pass freely through the Checking Aid *, Part No.63867-3008.

B Wire on the crimped lead must meet all specification above.

PARTS LIST

Item	Order No	Engineering No.	Description	Quantity
	63867-3100	63867-3100	FineAdjust Applicator (Fig. 1)	REF
1	63867-3101	63867-3101	Conductor Punch	1 Y
2	63867-3102	63867-3102	Conductor Anvil	1 Y
3	63867-3103	63867-3103	Insulation Punch	1 Y
4	63867-3104	63867-3104	Insulation Anvil	1 Y
5	63867-3005	63867-3005	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	63443-6009	63443-6009	Rear Cover	1
11	11-18-4083	60707-8	Front Cover	1
12	63867-3006	63867-3006	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	63867-3007	63867-3007	Bottom Cap	1
17	* 63867-3008	* 63867-3008	* Checking Aid (for Terminal)	REF
18	N/A	N/A	M3 by 6Lg. SHCS	2**
19	N/A	N/A	M4 by 6Lg. SHCS	1**
20	N/A	N/A	M4 by 8Lg. SHSS	1**
21	N/A	N/A	M4 by 12Lg. BHCS	2**
22	N/A	N/A	M4 by 12Lg. SHCS	2**
23	N/A	N/A	M4 by 16Lg. SHCS	1**
24	N/A	N/A	M4 by 50Lg. SHCS	2**
25	N/A	N/A	M5 by 12Lg SHCS	1**
26	N/A	N/A	3MM by 6Lg. Roll Pin	1**
27	N/A	N/A	#10-32 by 1/4"Lg. BHCS	1**
	63867-3170	63867-3170	Tool Kit (All Y Items)	REF

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

* The Checking Aid 63867-3008 to be ordered separately if required.
(This item is not included with the Applicator and is shown for Reference purpose only)

Assembly Drawing

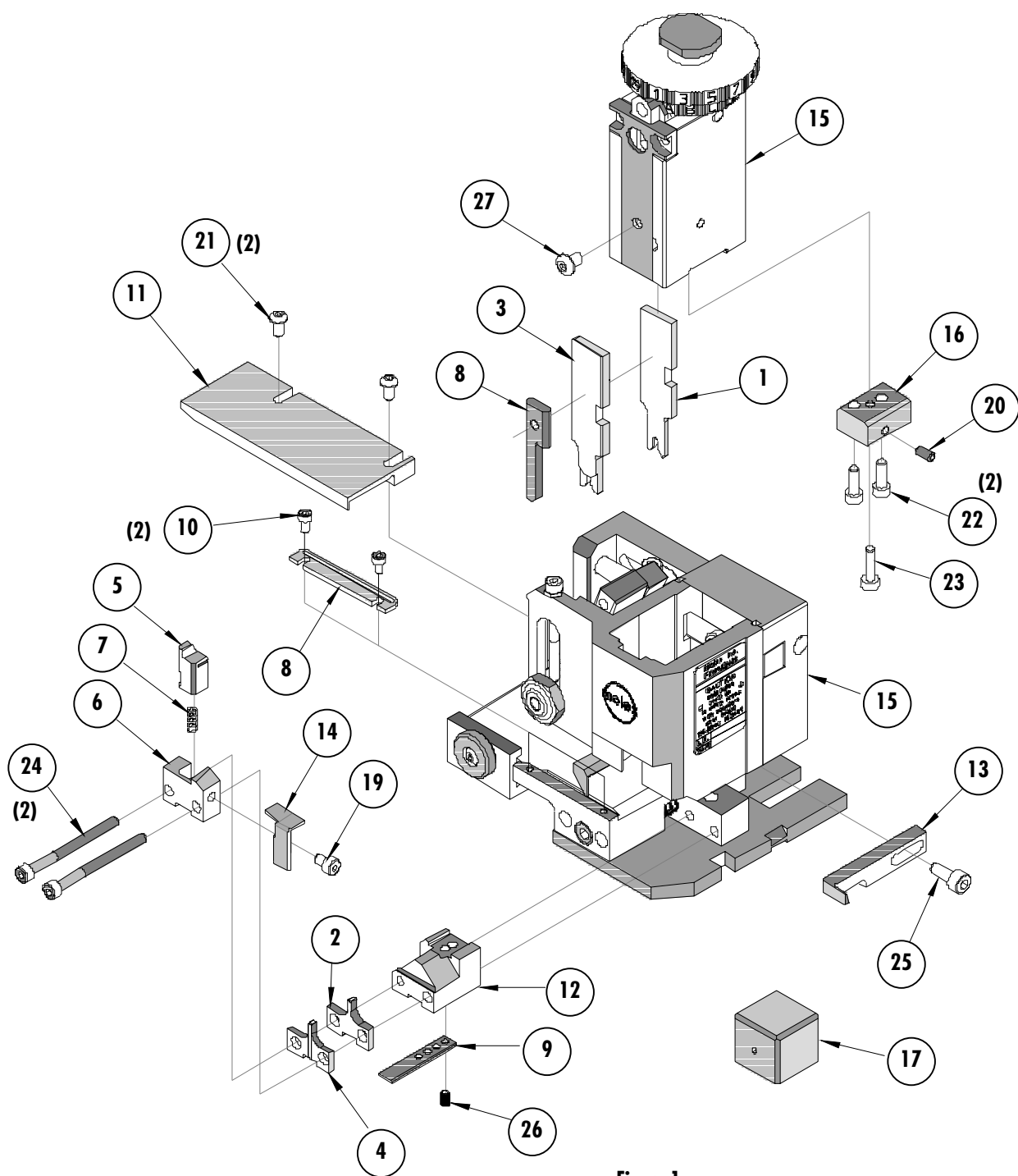


Figure 1

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 135.8mm (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

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Fax: (630) 505-0049

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

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