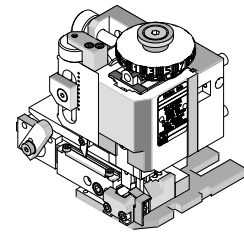


**FineAdjust
Applicator**



**Application Tooling
Specification Sheet**



Order No. 63867-3000

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

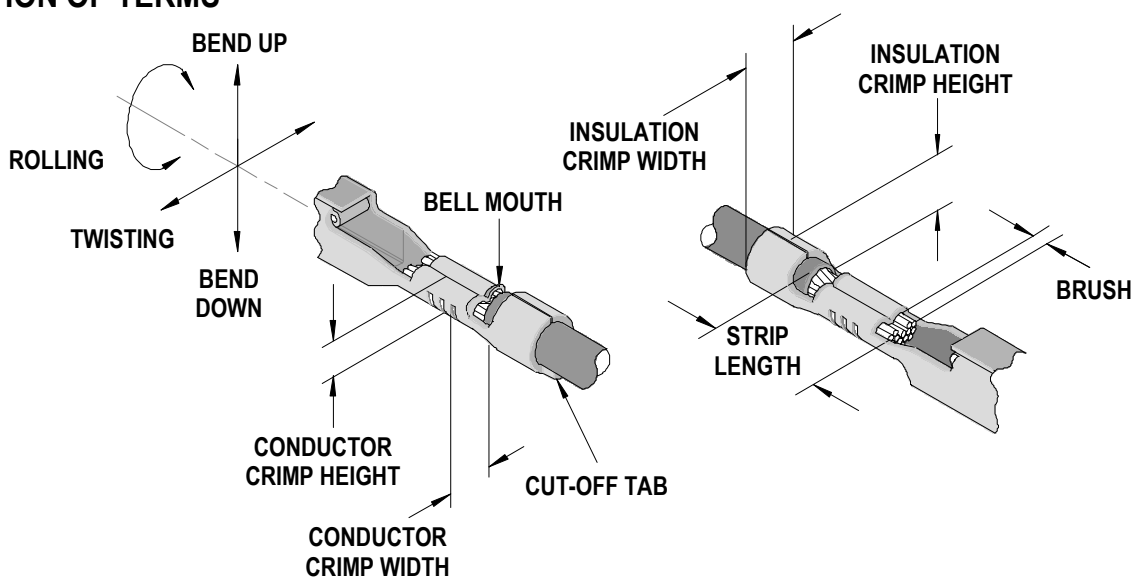
SCOPE

Products: 2.54mm (.100") Pitch MX64™ Terminal, 18-20 AWG and 0.75mm² wire.

| Terminal Series No. | Terminal Order No. | Wire Size | | Insulation Diameter | | Strip Length (Ref) | |
|---------------------|--------------------|-------------|-----------------|---------------------|-----------|--------------------|------|
| | | AWG | mm ² | mm | In. | mm | In. |
| 33467 | 33467-0006 | 18 | 0.83 | 1.91-2.06 | .075-.081 | 4.20 | .165 |
| 33468 | 33468-0004 | Metric Only | 0.75 | 1.70-1.90 | .067-.075 | 4.20 | .165 |
| 34736 | 34736-1002 | 20 | 0.58 | 1.70-1.85 | .067-.073 | 4.20 | .165 |

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 | 0.25-1.25 | .010-.049 | 0.50 | .020 | 0.10-0.55 | .004-.022 |
| 33468 | | | | | | |
| 34736 | | | | | | |

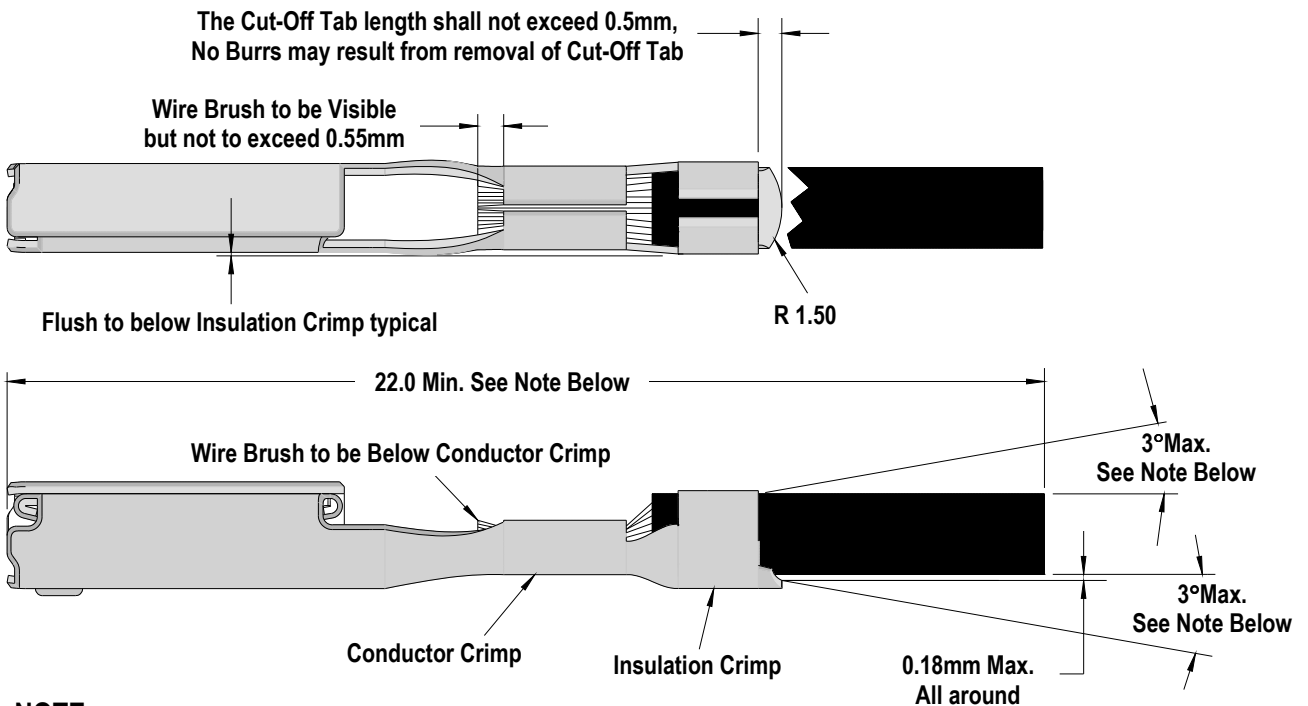
| Terminal Series No. | Bend up Bend down | Twist | Roll | Seam |
|---------------------|--|-------|------|---|
| 33467 | Crimped Samples must pass thru the 63867-3008 Checking Aid * | | | Seam shall not be open and no wire allowed out of the crimping area |
| 33468 | | | | |
| 34736 | | | | |

* Ordered separately

After crimping, the conductor profile should measure the following.

| Terminal Series No. | Wire Size | | Conductor | | | | Insulation | | | | Pull Force Minimum | |
|---------------------|-------------|-----------------|--------------|-----------|-------------|-----------|--------------|-----------|-------------|-----------|--------------------|------|
| | | | Crimp Height | | Crimp Width | | Crimp Height | | Crimp Width | | | |
| | AWG | mm ² | mm | In. | mm | In. | mm | In. | mm | In. | N | Lb. |
| 33467 | 18 | 0.83 | 1.10-1.20 | .043-.047 | 1.75-1.85 | .069-.073 | 2.00-2.20 | .079-.087 | 1.85-2.05 | .073-.081 | 90 | 20.3 |
| 33468 | Metric Only | 0.75 | 1.05-1.15 | .041-.045 | 1.75-1.85 | .069-.073 | 2.00-2.20 | .079-.087 | 1.85-2.05 | .073-.081 | 90 | 20.3 |
| 34736 | 20 | 0.58 | 1.05-1.15 | .041-.045 | 1.75-1.85 | .069-.073 | 1.85-2.05 | .073-.081 | 1.85-2.05 | .073-.081 | 75 | 17.0 |

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



NOTE:

Straightness:

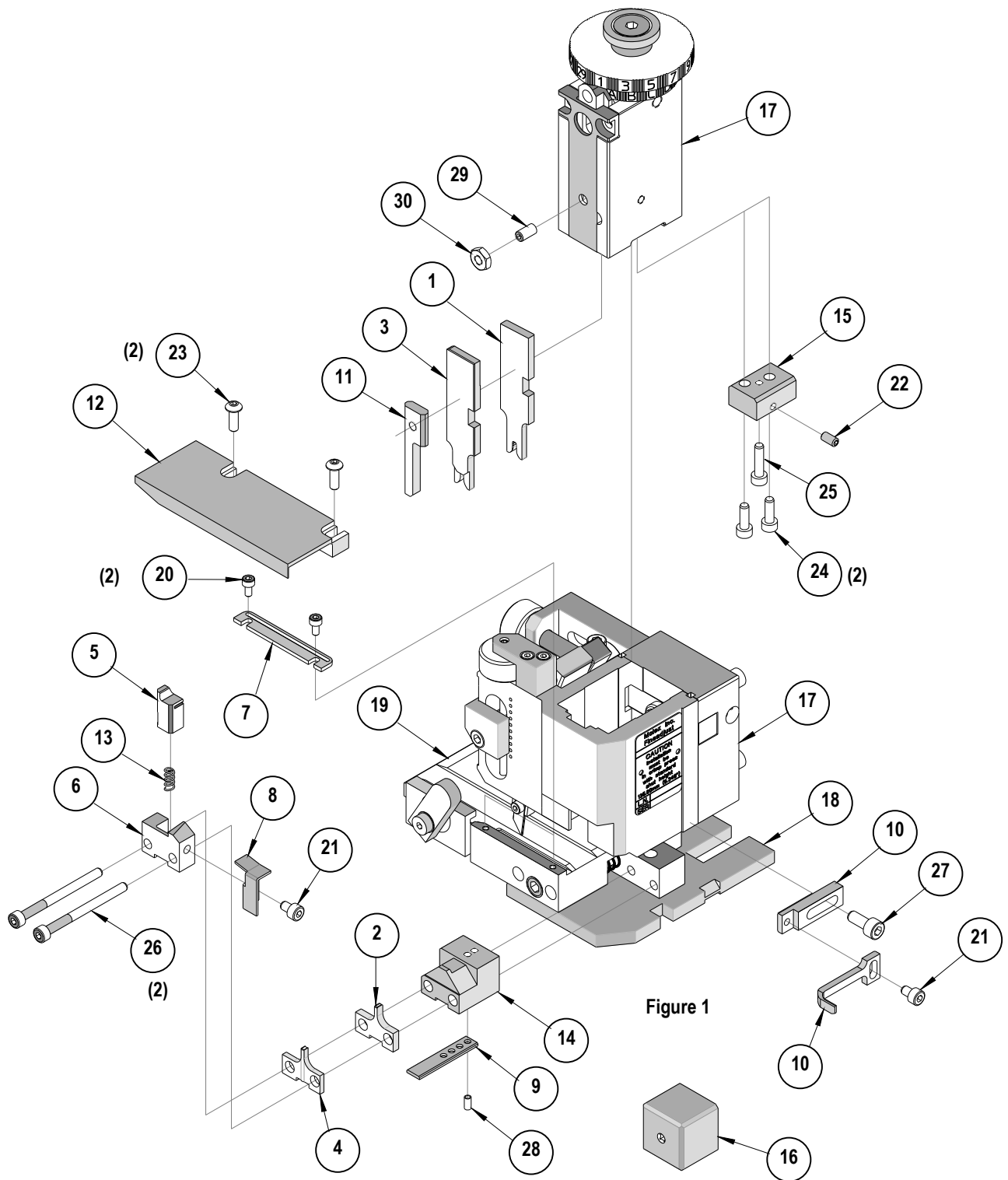
- A Crimped terminal lead must be able to pass freely through the Checking Aid *, Part No.63867-3008.
- B Wire on the crimped lead must meet all specification above.

PARTS LIST

| FineAdjust Applicator 63867-3000 | | | | |
|--|------------|-----------------|------------------------------------|----------|
| Item | Order No | Engineering No. | Description | Quantity |
| Perishable Tooling | | | | |
| | 63867-3070 | 63867-3070 | Tool Kit (All "Y" Items) | REF |
| 1 | 63867-3001 | 63867-3001 | Conductor Punch | 1 Y |
| 2 | 63867-3002 | 63867-3002 | Conductor Anvil | 1 Y |
| 3 | 63867-3003 | 63867-3003 | Insulation Punch | 1 Y |
| 4 | 63867-3004 | 63867-3004 | Insulation Anvil | 1 Y |
| 5 | 63867-3005 | 63867-3005 | Cut-Off Plunger | 1 Y |
| 6 | 63443-0036 | 63443-0036 | Front Plunger Retainer | 1 Y |
| Other Components | | | | |
| 7 | 11-18-4083 | 60707-8 | Feed Guide | 1 |
| 8 | 63443-0009 | 63443-0009 | Scrap Chute | 1 |
| 9 | 63443-0021 | 63443-0021 | Key | 1 |
| 10 | 63443-0090 | 63443-0090 | Wire Stop | 1 |
| 11 | 63443-3160 | 63443-3160 | Front Plunger Striker | 1 |
| 12 | 63443-6117 | 63443-6117 | Rear Cover | 1 |
| 13 | 63700-0539 | 63700-0539 | Cut-off Plunger Spring | 1 |
| 14 | 63867-3006 | 63867-3006 | Anvil Mount | 1 |
| 15 | 63867-3007 | 63867-3007 | Bottom Cap | 1 |
| 16 | 63867-3008 | 63867-3008 | ★ Checking Aid | REF |
| Frame | | | | |
| 17 | 63800-4901 | 63800-4901 | Top | 1 |
| 18 | 63801-3281 | 63801-3281 | Base | 1 |
| 19 | 63801-4650 | 63801-4650 | Track | 1 |
| Hardware | | | | |
| 20 | N/A | N/A | M3 by 6 Long SHCS | 2** |
| 21 | N/A | N/A | M4 by 6 Long SHCS | 2** |
| 22 | N/A | N/A | M4 by 8 Long SHSS | 1** |
| 23 | N/A | N/A | M4 by 12 Long BHCS | 2** |
| 24 | N/A | N/A | M4 by 12 Long SHCS | 2** |
| 25 | N/A | N/A | M4 by 16 Long SHCS | 1** |
| 26 | N/A | N/A | M4 by 50 Long SHCS | 2** |
| 27 | N/A | N/A | M5 by 12 Long SHCS | 1** |
| 28 | N/A | N/A | 3MM by 6 Long Roll Pin | 1** |
| 29 | N/A | N/A | #10-32 by 3/8" Long Flat Point SSS | 1** |
| 30 | N/A | N/A | #10-32 Hex Jam Nut | 1** |
| ** 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



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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