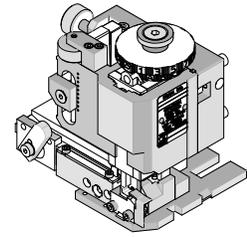


**FineAdjust
Applicator**



**Application Tooling
Specification Sheet**



Order No. 63900-0600

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

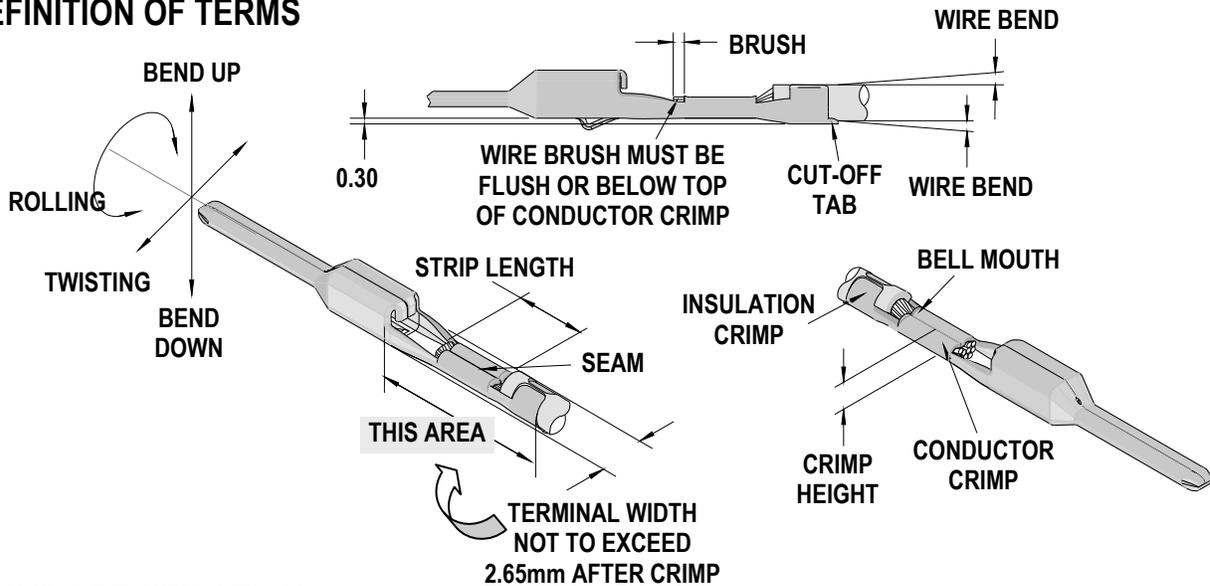
SCOPE

Products: MX150™ Blade Terminals 22 AWG, and 0.50mm².

Terminal Series No.	Terminal Order No.		Wire Size		Insulation Diameter		Strip Length	
			AWG	mm ²	mm	In.	mm	In.
33000	33000-1003	Male (Tin)	22	-	1.50-1.65	.059-.065	4.70-5.60	.185-.220
			-	0.50 (1)	1.40-1.60	.055-.063		
			-	0.50 (2)	1.60-1.70	.063-.067		
33011	33011-0006	Male (Gold)	22	-	1.50-1.65	.059-.065	4.70-5.60	.185-.220
			-	0.50 (1)	1.40-1.60	.055-.063		
			-	0.50 (2)	1.60-1.70	.063-.067		
	33011-3001	Male (Silver)	22	-	1.50-1.65	.059-.065		
			-	0.50 (1)	1.40-1.60	.055-.063		
			-	0.50 (2)	1.60-1.70	.063-.067		
31296	31296-0006	Male (Long)	22	-	1.50-1.65	.059-.065	4.70-5.60	.185-.220

Terminals were validated per USCAR-21 using the following wire specifications:
M1L-123A (TXL), M1L-135A1 (UTX), (1) M1L-126A1(metric-TXL), and (2) JASO D 611 (AVSS)
Customers are required to complete validation testing if tooling purchased outside Molex Inc. and/or wire specifications are different than above.

DEFINITION OF TERMS



CRIMP SPECIFICATION

Terminal Series No.	Bell mouth		Cut-off Tab Maximum		* Conductor Brush	
	mm	In.	mm	In.	mm	In.
33000	0.30-0.70	.012-.028	0.50	.020	0.15-0.40	.006-.016
33011	0.30-0.70	.012-.028	0.50	.020	0.15-0.40	.006-.016
31296	0.30-0.70	.012-.028	0.50	.020	0.15-0.40	.006-.016

* Wire brush must be flush or below top of Conductor Crimp.

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	3	3	3	3	1.50	.059	1.86	.073	Seam shall not be open and no wire allowed out of the crimping area
33011	3	3	3	3	1.50	.059	1.86	.073	
31296	3	3	3	3	1.50	.059	1.86	.073	

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.
33000	22	-	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	11.3
	-	0.50 (1)	1.05-1.15	.041-.045	1.50-1.70	.059-.067	1.70-1.90	.067-.075	1.80-2.00	.071-.079	75	16.9
	-	0.50 (2)	1.05-1.15	.041-.045	1.50-1.70	.059-.067	1.75-1.95	.069-.077	1.80-2.00	.071-.079	75	16.9
33011	22	-	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	11.3
	-	0.50 (1)	1.05-1.15	.041-.045	1.50-1.70	.059-.067	1.70-1.90	.067-.075	1.80-2.00	.071-.079	75	16.9
	-	0.50 (2)	1.05-1.15	.041-.045	1.50-1.70	.059-.067	1.75-1.95	.069-.077	1.80-2.00	.071-.079	75	16.9
31296	22	-	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	11.3

Wire specification: (1) M1L-126A (metric-TXL), (2) JASO D 611 (AVSS)

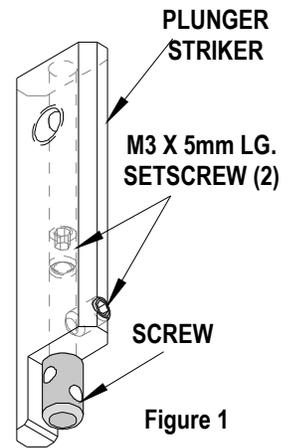
*** Tool Qualification Notes:**

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

Adjusting the Wire Bend Angle (See Item11 in parts list and assembly drawing.)

Note: If the Wire Bend is present after crimping use the following method to remove the bend. This tooling may not be necessary for all wire gauges.

1. The screw is provided for wire straightening. See Figure 1.
2. Loosen the (2) M3 x 5mm long setscrews; see Figure 1, before turning the screw.
3. Start by adjusting the screw so it just touches the insulation outside diameter of the wire being crimped. If wire Bend Up exists, turn the screw a quarter turn clockwise (CW) to lengthen it.
4. Continue to adjust the length of the screw until the wire appears to be straight after crimping. If wire Bend Down exists, turn the screw a quarter turn counter clockwise (CCW) to shorten it. Continue to adjust the length of the screw until the wire appears to be straight after crimping.
5. Tighten the M3 x 5mm long setscrews, when finished adjusting the screw. Two M3 x 5mm long setscrews are provided; the top setscrew is to lock the screw after adjustments. The M3 x 5mm long setscrew on the side of plunger striker is used when making adjustments.



Adjusting the Wire Brush Length (See Item13 in parts list and assembly drawing.)

1. If the wire brush is too long or extends above the top of the conductor crimp, adjust the Wire Stop, Item 13, closer to the conductor punch.
2. If the wire brush is too short, adjust the Wire Stop further away from the conductor punch.

PARTS LIST

FineAdjust Applicator 63900-0600				
Item	Order No	Engineering No.	Description	Quantity
Perishable Tooling				
	63900-0670	63900-0670	Tool Kit (All "Y" Items)	REF
1	63444-1548	63444-1548	Conductor Punch	1 Y
2	63455-0044	63455-0044	Conductor Anvil	1 Y
3	63454-0050	63454-0050	Insulation Punch	1 Y
4	63456-0045	63456-0045	Insulation Anvil	1 Y
5	63443-0037	63443-0037	Cut-Off Plunger	1 Y
6	63443-0038	63443-0038	Front Plunger Retainer	1 Y
Other Components				
7	11-17-0022	1739-21	Hold Down Spring	1
8	11-18-4094	60709A111	Feed Guide	1
9	63443-0009	63443-0009	Scrap Chute	1
10	63443-0024	63443-0024	Key	1
11	63443-0082	63443-0082	Front Plunger Striker	1
12	63443-0083	63443-0083	Striker Screw	1
13	63443-0090	63443-0090	Wire Stop	1
14	63443-0093	63443-0093	Shank	1
15	63443-1717	63443-1717	Height Spacer	1
16	63443-2205	63443-2205	Coarse Spacer (5.00mm)	1
17	63443-2209	63443-2209	Coarse Spacer (9.00mm)	1
18	63443-2306	63443-2306	Fine Spacer (3.30mm)	1
19	63443-6115	63443-6115	Rear Cover	1
20	63443-7102	63443-7102	Terminal Hold Down	1
21	63700-0539	63700-0539	Cut-off Plunger Spring	1
Frame				
22	63800-4901	63800-4901	Top	1
23	63801-3281	63801-3281	Base	1
24	63801-4650	63801-4650	Track	1
25	63459-0001	63459-0001	Terminal Track	1
Hardware				
26	N/A	N/A	M3 by 5Lg. SHSS-Brass Tip	2**
27	N/A	N/A	M3 by 6 Long SHCS	2**
28	N/A	N/A	M3 by 6 Long FHCS	1**
29	N/A	N/A	M3 by 8 Long SHCS	1**
30	N/A	N/A	M4 by 6 Long SHCS	2**
31	N/A	N/A	M4 by 12 Long BHCS	2**
32	N/A	N/A	M4 by 50 Long SHCS	2**
33	N/A	N/A	M5 by 12 Long SHCS	1**
34	N/A	N/A	#10-32 by 3/8" Long Flat Point SSS	1**
35	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

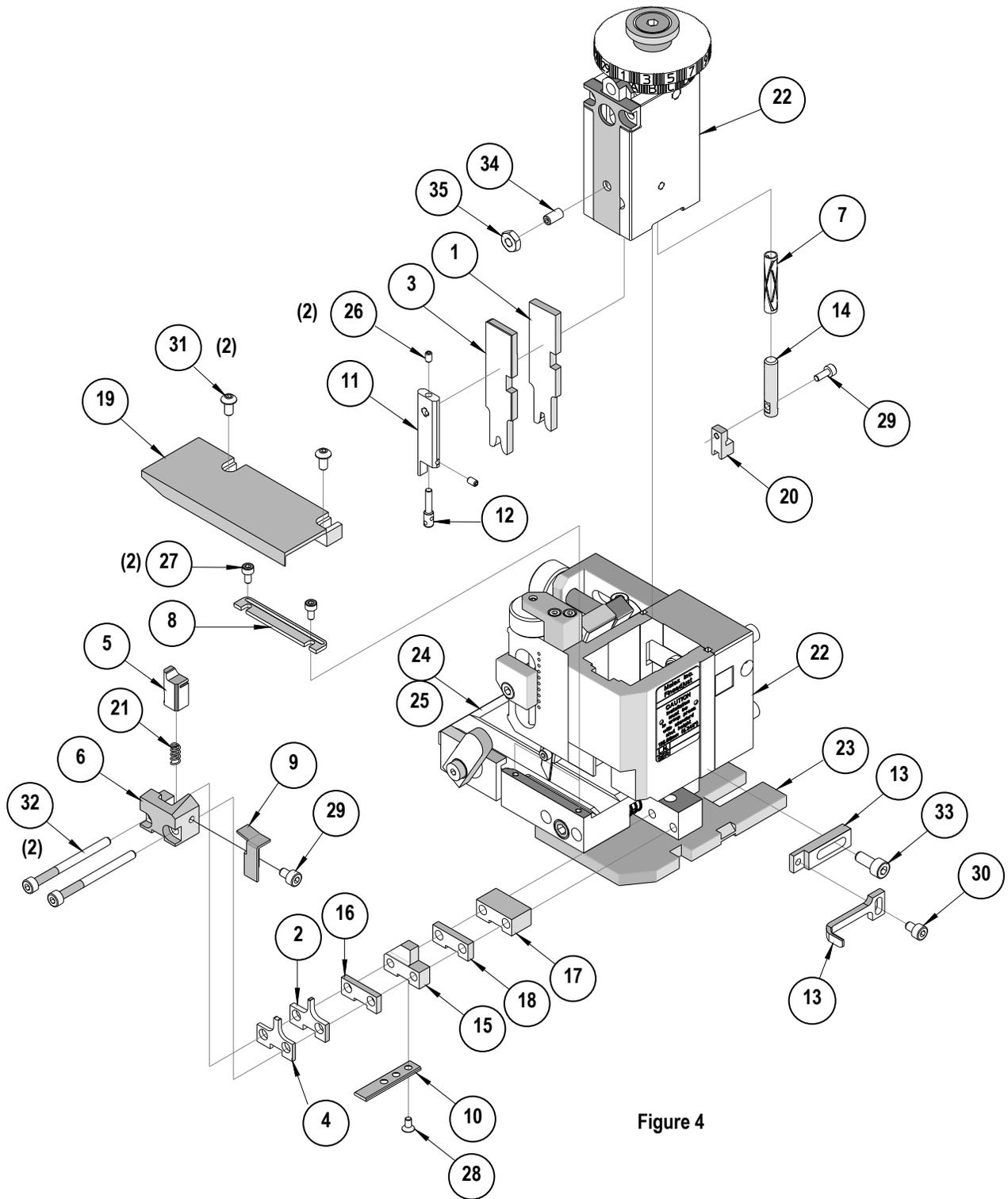


Figure 4

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.

<http://www.molex.com>