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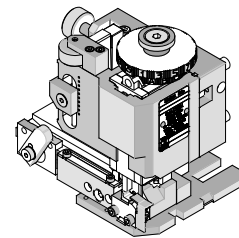
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**FineAdjust
Applicator**



**Application Tooling
Specification Sheet**



Order No. 63904-0800

FEATURES THIS APPLICATOR IS FOR AUTOMATIC WIRE PROCESSOR USE ONLY.

- 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

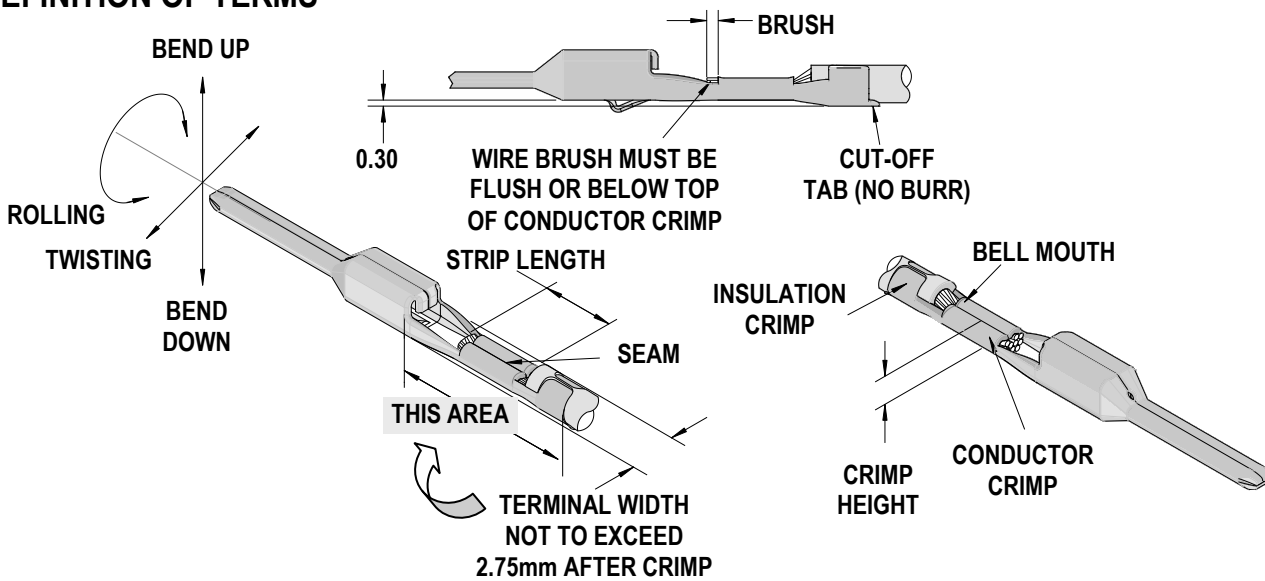
SCOPE

Products: SRC Connector using MX150 Blade Terminals, 0.75mm² wires.

| Terminal Series No. | Terminal Order No. | | Wire Size | | Insulation Diameter | | Strip Length | |
|---------------------|--------------------|------------|-----------|-----------------|---------------------|-----------|--------------|-----------|
| | | | Wire Type | mm ² | mm | In. | mm | In. |
| 33000 | 33000-1002 | | FLRY-B | 0.75 | 1.70-1.90 | .067-.075 | 4.70-5.60 | .185-.220 |
| 33011 | 33011-0004 | 33011-3002 | FLRY-B | 0.75 | 1.70-1.90 | .067-.075 | 4.70-5.60 | .185-.220 |

Terminals were validated using the following wire specifications: ISO 6722-1, Class B

DEFINITION OF TERMS



CRIMP SPECIFICATION

| Terminal Series No. | Bell mouth | | Cut-off Tab (Max) | | ◆ Conductor Brush (Max) | |
|---------------------|------------|-----------|-------------------|------|-------------------------|------|
| | mm | In. | mm | In. | mm | In. |
| 33000 | 0.30-0.70 | .012-.028 | 0.50 | .020 | 0.40 | .016 |
| 33011 | 0.30-0.70 | .012-.028 | 0.50 | .020 | 0.40 | .016 |

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

◆ THIS APPLICATOR IS INTENDED FOR AUTOMATIC WIRE PROCESSOR USE ONLY.

It is very important that the brush length is consistently within specification for this sealed connector system to work properly. This applicator should only be run in a properly setup automatic wire processor in order to consistently achieve the brush length. Any attempt to use this applicator outside a properly setup automatic wire processor will likely not meet the brush specification and cause this sealed connector system to not work properly.

| Terminal Series No. | Bend up | Bend down | Twist Roll | | Punch Width (Ref) | | | | Conductor Seam Seam shall not be open and no wire allowed out of the crimping area |
|---------------------|---------|-----------|------------|---|-------------------|------|------------|------|---|
| | | | | | Conductor | | Insulation | | |
| | Degree | | Degree | | mm | In | mm | In | |
| 33000 | 3 | 3 | 3 | 3 | 2.10 | .083 | 2.16 | .085 | |
| 33011 | 3 | 3 | 3 | 3 | 2.10 | .083 | 2.16 | .085 | |

After crimping, the crimp profiles should measure the following:

| Terminal Series No. | Wire Size | | Conductor | | | | Insulation | | | | Pull Force Minimum | |
|---------------------|-----------|-----------------|--------------|-----------|-------------|-----------|--------------------|------|-------------------|------|--------------------|------|
| | | | Crimp Height | | Crimp Width | | Crimp Height (Ref) | | Crimp Width (Ref) | | | |
| | Wire Type | mm ² | mm | In. | mm | In. | mm | In. | mm | In. | N | Lb. |
| 33000 | FLRY-B | 0.75 | 1.20-1.30 | .047-.051 | 2.05-2.25 | .081-.089 | 2.30 | .091 | 2.20 | .087 | 90 | 20.2 |
| 33011 | FLRY-B | 0.75 | 1.20-1.30 | .047-.051 | 2.05-2.25 | .081-.089 | 2.30 | .091 | 2.20 | .087 | 90 | 20.2 |

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 Brush Length

(See Item 11 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 11, 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 63904-0800 | | | | |
|--|------------|-----------------|------------------------------------|----------|
| Item | Order No | Engineering No. | Description | Quantity |
| Perishable Tooling | | | | |
| | 63904-0870 | 63904-0870 | Tool Kit (All "Y" Items) | REF |
| 1 | 63444-2137 | 63444-2137 | Conductor Punch | 1 Y |
| 2 | 63445-2168 | 63445-2168 | Conductor Anvil | 1 Y |
| 3 | 63454-0025 | 63454-0025 | Insulation Punch | 1 Y |
| 4 | 63456-0116 | 63456-0116 | Insulation Anvil | 1 Y |
| 5 | 63443-0039 | 63443-0039 | 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 | 63443-0090 | 63443-0090 | Wire Stop | 1 |
| 12 | 63443-0093 | 63443-0093 | Shank | 1 |
| 13 | 63443-1719 | 63443-1719 | Height Spacer (18.90mm) | 1 |
| 14 | 63443-2205 | 63443-2205 | Coarse Spacer (5.00mm) | 1 |
| 15 | 63443-2209 | 63443-2209 | Coarse Spacer (9.00mm) | 1 |
| 16 | 63443-2306 | 63443-2306 | Fine Spacer (3.30mm) | 1 |
| 17 | 63443-2804 | 63443-2804 | Front Plunger Striker | 1 |
| 18 | 63443-2915 | 63443-2915 | Wire Hold Down Plunger | 1 |
| 19 | 63443-6122 | 63443-6122 | Rear Cover | 1 |
| 20 | 63443-7102 | 63443-7102 | Terminal Hold Down | 1 |
| 21 | 63600-1057 | 63600-1057 | Striker Plunger Spring | 1 |
| 22 | 63700-0539 | 63700-0539 | Cut-off Plunger Spring | 1 |
| Frame | | | | |
| 23 | 63800-4901 | 63800-4901 | Top | 1 |
| 24 | 63801-3281 | 63801-3281 | Base | 1 |
| 25 | 63801-4650 | 63801-4650 | Track | 1 |
| 25A | 63459-0001 | 63459-0001 | Terminal Track | 1 |
| Hardware | | | | |
| 26 | N/A | N/A | M3 by 6 Long SHCS | 2** |
| 27 | N/A | N/A | M3 by 6 Long FHCS | 1** |
| 28 | N/A | N/A | M3 by 8 Long SHCS | 1** |
| 29 | N/A | N/A | M4 by 6 Long SHCS | 2** |
| 30 | N/A | N/A | M4 by 12 Long BHCS | 2** |
| 31 | N/A | N/A | M4 by 50 Long SHCS | 2** |
| 32 | N/A | N/A | M5 by 12 Long SHCS | 1** |
| 33 | N/A | N/A | #10-32 by 3/8" Long Flat Point SSS | 1** |
| 34 | 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

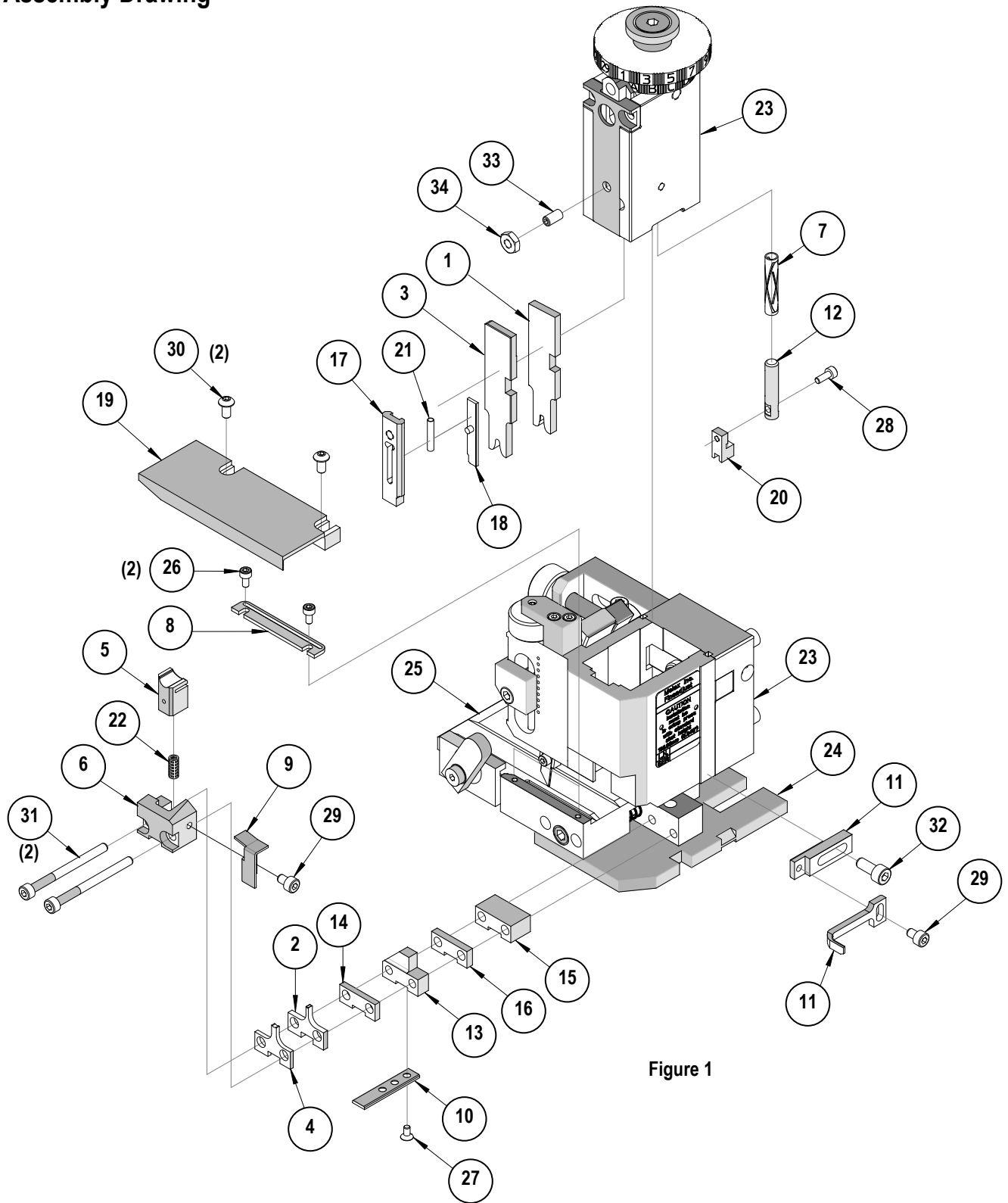


Figure 1

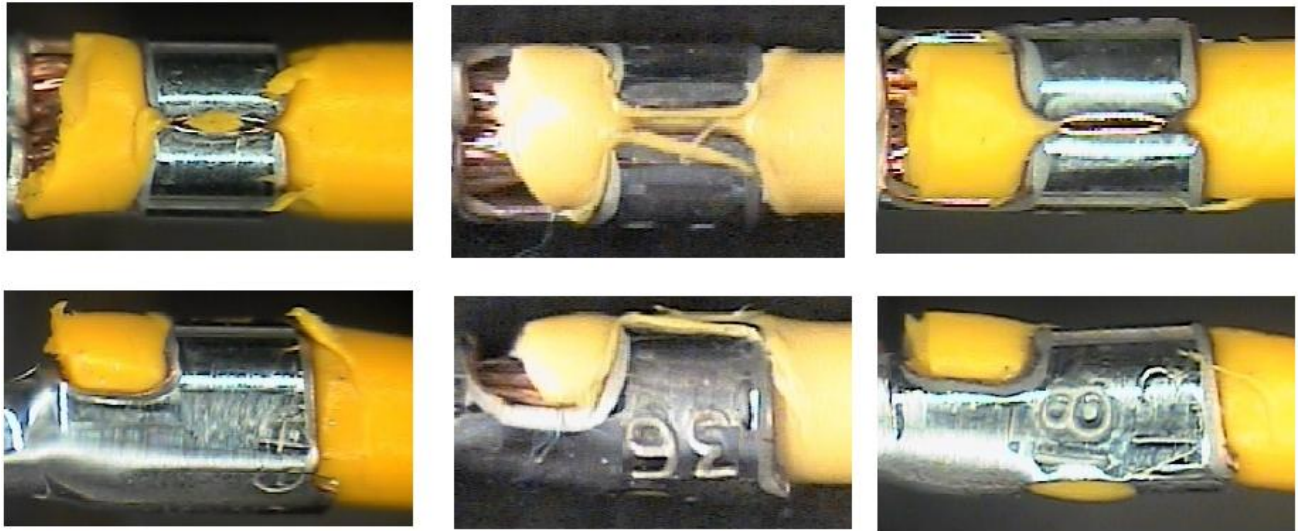
NOTES

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.

Insulation Attribute Notes:

In order to help ensure the integrity of the connector seal, the design intent is to partially bury the insulation grips into the wire insulation. Due to this, skiving of the insulation may occur. This skiving attribute is acceptable.

Below are examples of insulation skiving that may be seen with this connector system.



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: These Molex crimp specifications are valid only when used with Molex terminals, applicators and tooling qualified by Molex. When using non-Molex tooling with this specific connector system listed in this document, the Molex qualification does not apply and the responsibility for full qualification of the connector system is that of the customer. Molex accepts no liability for tooling support where non-Molex tooling is used.

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