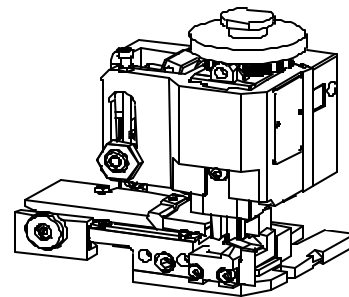




**SPECIFICATION SHEET**  
**FineAdjust Applicator**  
**63865-4100**  
**REVISION A**

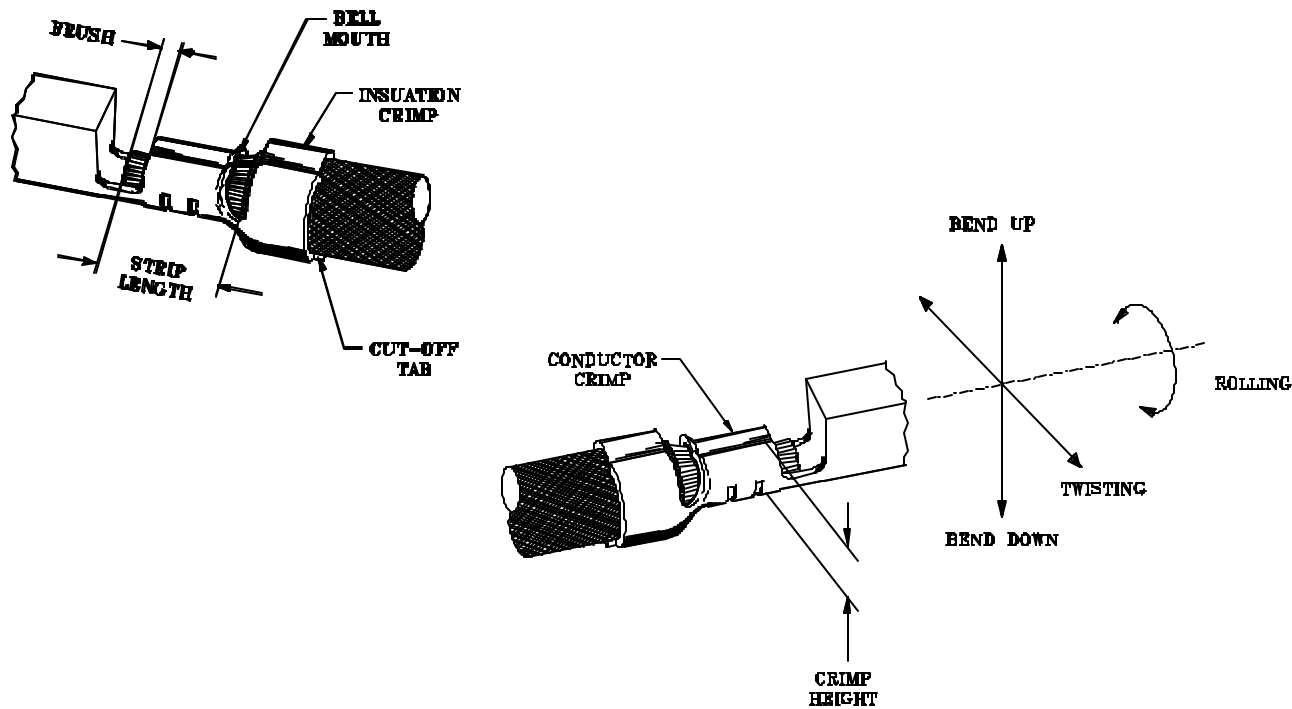


**SCOPE**

| Terminal Series No |               | Wire Size |                    | Insulation Diameter |             | Strip Length |             |
|--------------------|---------------|-----------|--------------------|---------------------|-------------|--------------|-------------|
|                    |               | Awg       | (mm <sup>2</sup> ) | mm                  | (in)        | mm           | (in)        |
| 33012-1003         | Female (tin)  | 22        | (0.36)             | 1.50-1.65           | (.059-.065) | 4.70-5.60    | (.185-.220) |
| 33001-1005         | Female (gold) | 22        | (0.36)             | 1.50-1.65           | (.059-.065) | 4.70-5.60    | (.185-.220) |
|                    |               |           |                    |                     |             |              |             |
|                    |               |           |                    |                     |             |              |             |

Wire Specs: Wires to be thin wall thickness per Ford's specification MIL135-A1 and MIL123-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

## SPECIFICATIONS

| Terminal Series No. | Bellmouth<br>mm (in)     | Cut-Off Tab Max.<br>mm (in) | Conductor Brush<br>mm (in) |
|---------------------|--------------------------|-----------------------------|----------------------------|
| 33012-1003          | 0.25-1.25<br>(.010-.049) | 0.50<br>(.020)              | 0.15-0.65<br>(.006-.026)   |
| 33001-1005          | 0.25-1.25<br>(.010-.049) | 0.50<br>(.020)              | 0.15-0.65<br>(.006-.026)   |
|                     |                          |                             |                            |
|                     |                          |                             |                            |

| Terminal Series No. | Bend Up<br>Degree | Bend Down<br>Degree | Twist<br>Degree | Roll | Punch Width mm<br>Conductor Insulation |
|---------------------|-------------------|---------------------|-----------------|------|--|
| 33012-1003          | 3                 | 3                   | 3               | 5    | 1.40 1.75                              |
| 33001-1005          | 3                 | 3                   | 3               | 5    | 1.40 1.75                              |
|                     |                   |                     |                 |      |  |
|                     |                   |                     |                 |      |  |

The above specifications are guidelines to an optimum crimp.

## CONDITIONS

After crimping, the crimp profiles should measure the following.

| Terminal Series | Wire Size<br>Awg (mm <sup>2</sup> ) | Conductor Crimp Height<br>mm (in) | Conductor Crimp Width<br>mm (in) | Pull Force Min<br>N (lbs) |
|-----------------|-------------------------------------|-----------------------------------|----------------------------------|---------------------------|
| 33012-1003      | 22 (0.36)                           | 0.90-1.00<br>(.035-.039)          | 1.35-1.55<br>(.053-.061)         | 50.0 (11.25)              |
| 33001-1005      | 22 (0.36)                           | 0.90-1.00<br>(.035-.039)          | 1.35-1.55<br>(.053-.061)         | 50.0 (11.25)              |
|                 |                                     |                                   |                                  |                           |
|                 |                                     |                                   |                                  |                           |
|                 |                                     |                                   |                                  |                           |
|                 |                                     |                                   |                                  |                           |
|                 |                                     |                                   |                                  |                           |
|                 |                                     |                                   |                                  |                           |

| Terminal Series | Wire Size<br>Awg (mm <sup>2</sup> ) | Insulation Crimp Height<br>mm (in) | Insulation Crimp Width<br>mm (in) |
|-----------------|-------------------------------------|------------------------------------|-----------------------------------|
| 33012-1003      | 22 (0.36)                           | 1.50-1.70<br>(.059-.067)           | 1.70-1.90<br>(.067-.075)          |
| 33001-1005      | 22 (0.36)                           | 1.50-1.70<br>(.059-.067)           | 1.70-1.90<br>(.067-.075)          |
|                 |                                     |                                    |                                   |
|                 |                                     |                                    |                                   |
|                 |                                     |                                    |                                   |
|                 |                                     |                                    |                                   |
|                 |                                     |                                    |                                   |
|                 |                                     |                                    |                                   |

Pull Force measured with no influence from the insulation crimp

## PARTS LIST

| Item Number | Order Number | Eng Number | Description              | Qty | Kit Part |
|-------------|--------------|------------|--------------------------|-----|----------|
| 1           | 634570008    | 634570008  | Conductor Punch          | 1   | Y        |
| 2           | 634550011    | 634550011  | Conductor Anvil          | 1   | Y        |
| 3           | 634540018    | 634540018  | Insulation Punch         | 1   | Y        |
| 4           | 634560017    | 634560017  | Insulation Anvil         | 1   | Y        |
| 5           | 634610001    | 634610001  | Cut-Off Plunger          | 1   | Y        |
| 6           | 634430036    | 634430036  | Front Plunger Retainer   | 1   | Y        |
| 7           | 637000539    | 637000539  | Cut-Off Plunger Spring   | 1   |          |
| 8           | 634433160    | 634433160  | Front Plunger Striker    | 1   |          |
| 9           | 634430021    | 634430021  | Lower Tooling Key        | 1   |          |
| 10          | 634436004    | 634436004  | Rear Cover               | 1   |          |
| 11          | 11-18-4094   | 60709A111  | Front Cover              | 1   |          |
| 12          | 634432506    | 634432506  | Anvil Mount              | 1   |          |
| 13          | 11-18-4080   | 60707-5    | Wire Stop                | 1   |          |
| 14          | 634430009    | 634430009  | Scrap Chute              | 1   |          |
| 15          | 638013100    | 638013100  | Wide Track FineAdjust    | 1   |          |
| 49          | 634590001    | 634590001  | Wide Terminal Track      | 1   |          |
| 70          | 638654170    | 638654170  | Tool Kit (All "Y" Items) | 0   |          |

## NOTES

1. We recommend 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.
3. Slugs , Terminals, Dirt and Oil should be kept clear of work area.
4. 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.
5. **\*\* CAUTION\*\*** To prevent injury never operate this Applicator without the guarding supplied with the press or wire processing machine in place. Reference the press or wire processing manufacturer's instruction manual.
6. Wear safety glasses at all times.

# ASSEMBLY DRAWING

The drawing below is a generic drawing representation. Some detail may not be shown. The FineAdjust applicator assembly and parts list can be found in the FineAdjust manual.

