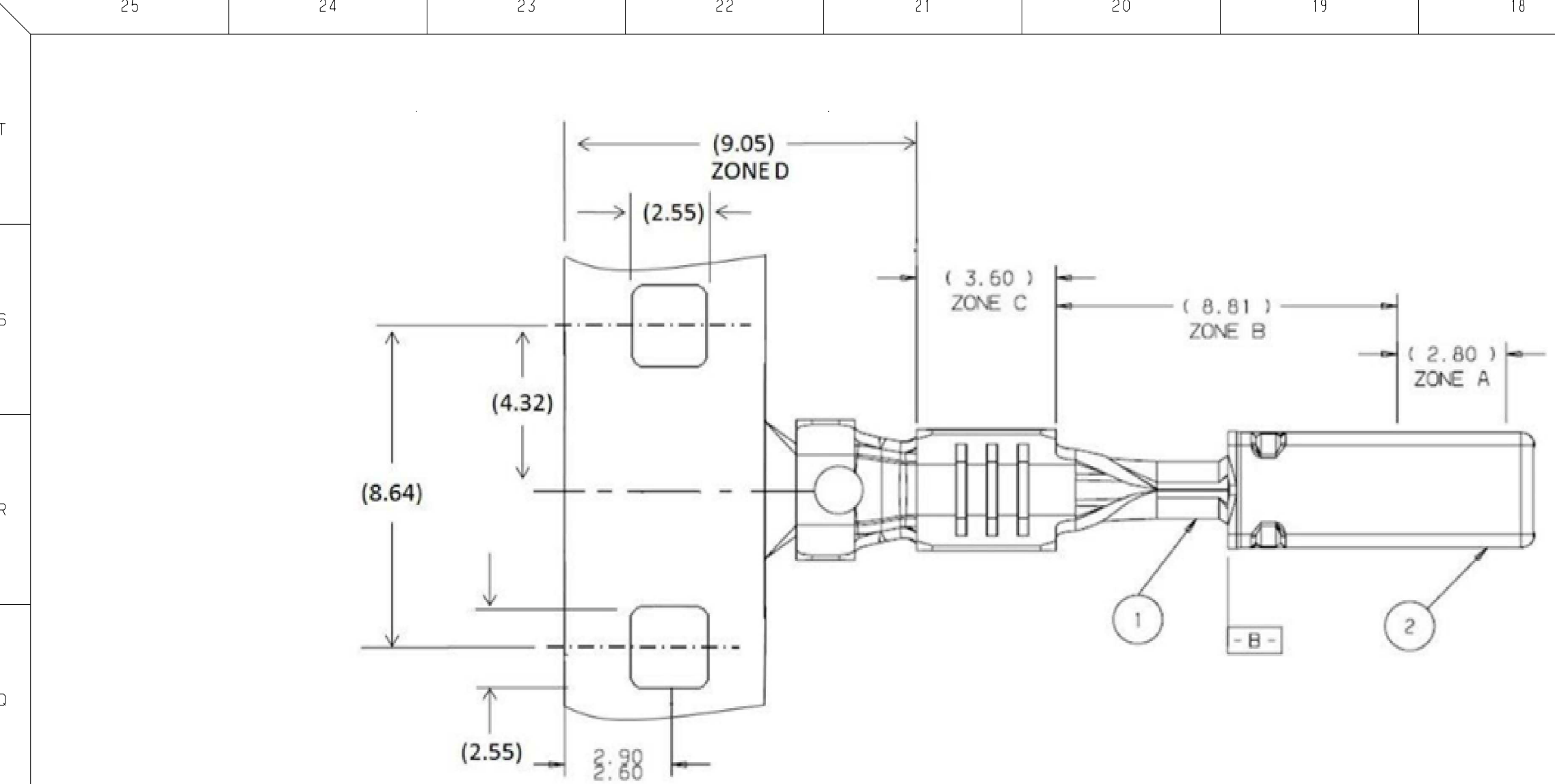
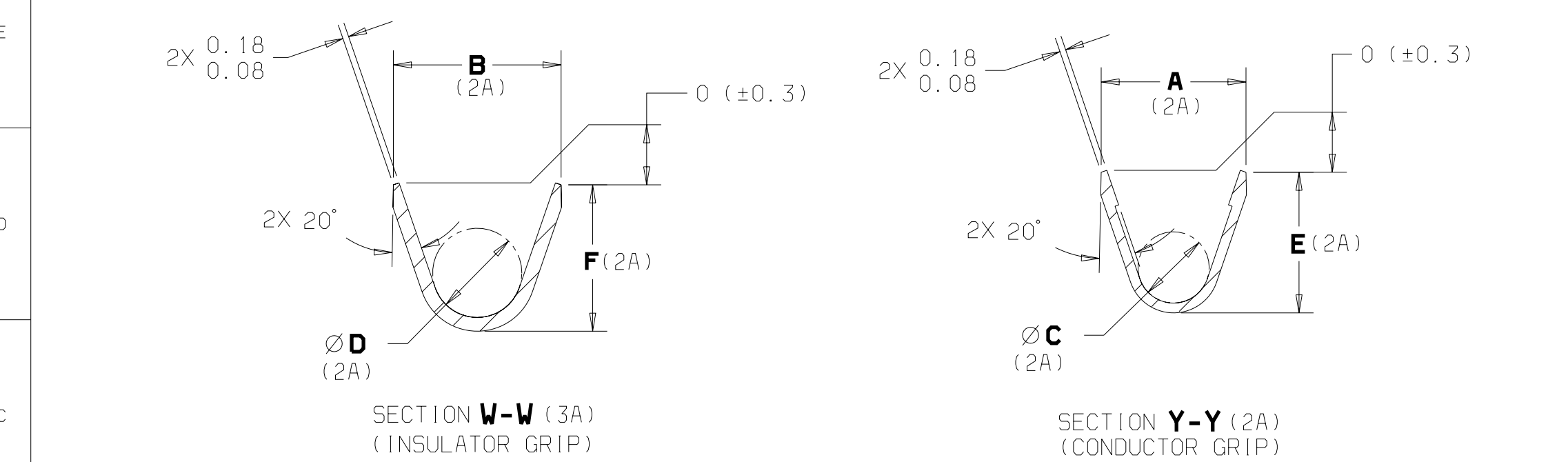
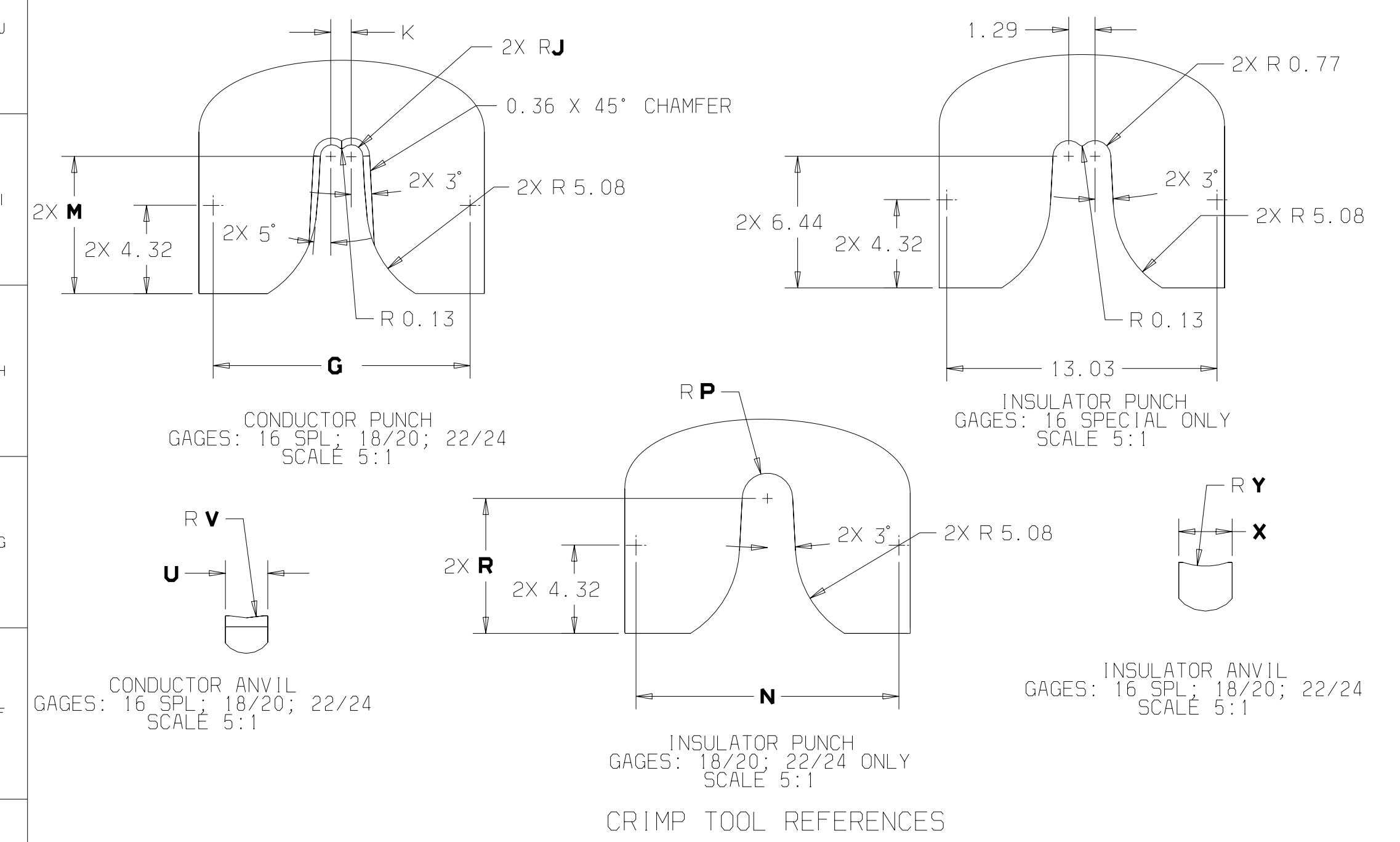


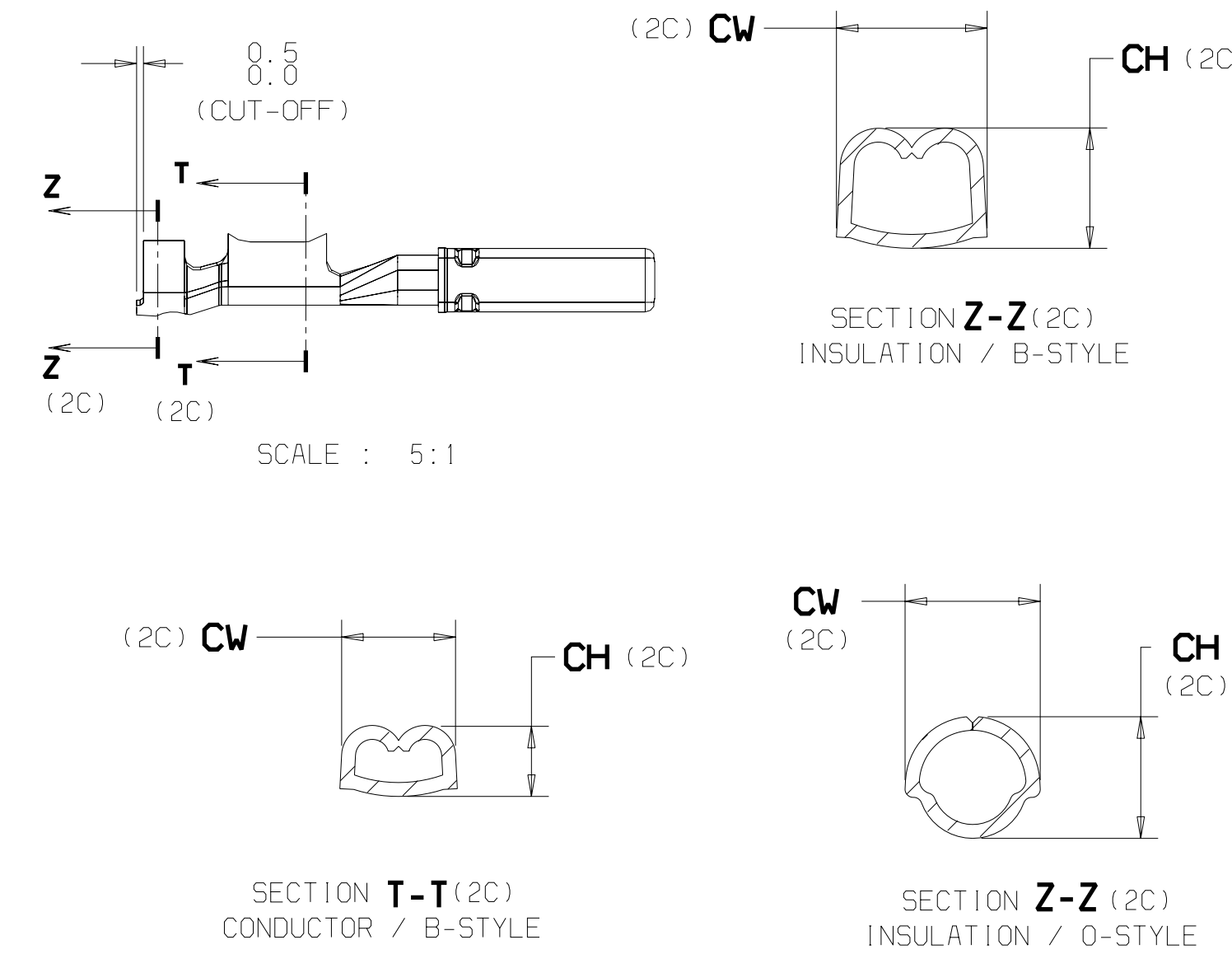


1. ITEM ① PRECIOUS METAL: GOLD OVER NICKEL
- A. PLATE 1.25-2.25 MICROMETERS MIN WITH SULFAMATE DUCTILE NICKEL OVERALL (BASE LAYER) REDUCED NICKEL THICKNESS IN ZONE D IS PERMITTED
- B. PLATE .762 MIN MICROMETERS HARD GOLD CAP FLASH ZONE A. REDUCED GOLD FLASH THICKNESS IN ZONE B IS PERMITTED
- C. PLATE 2.50-4.00 MICROMETERS ELECTRO-TIN MATTE FINISH ZONE C. REDUCED TIN THICKNESS IS PERMITTED IN ZONE B AND D.
- D. POROSITY: TWO PORES/CM² MAX PERMITTED IN CONTACT ZONE A USING ASTM 798
2. ITEM ① TIN PLATING OPTIONS:
REFLOW TIN:
A. PRE-PLATE COIL MATERIAL WITH 1.905-3.302 MICROMETERS ELECTRO-TIN REFLOW
B. 0.127-0.508 MICROMETERS SULFAMATE DUCTILE NICKEL (BASE LAYER) PERMITTED
3. ITEM ② PLATING:
A. PLATE WITH SULFAMATE DUCTILE NICKEL 0.762 MICROMETERS MIN PER ASTM B-689 TYPE 2 (PRECIOUS METAL PLATED TERMINAL ONLY)

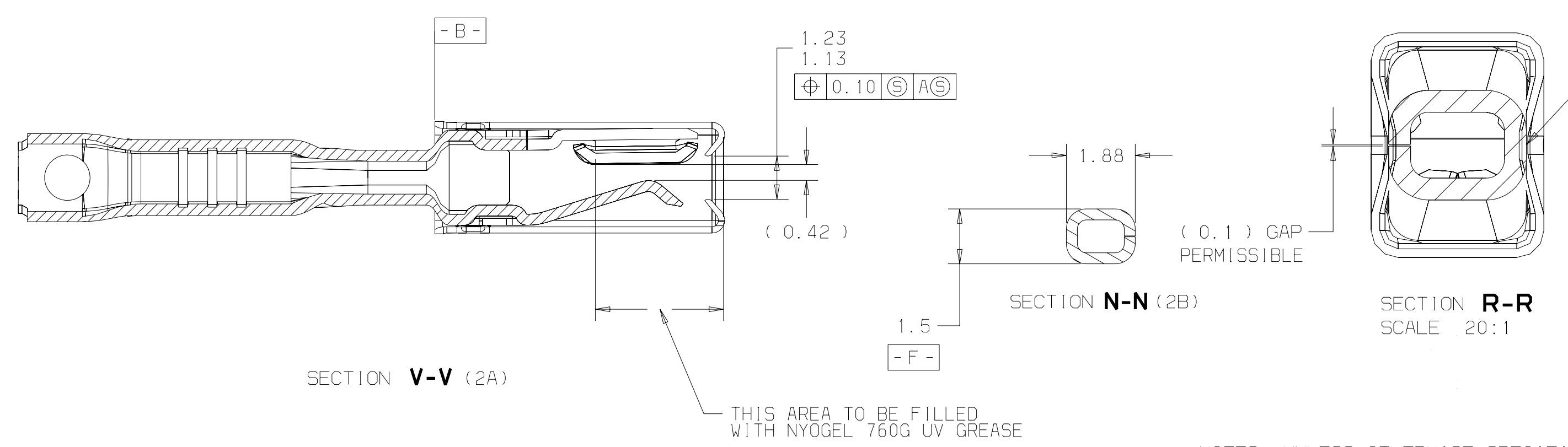


4793039	MOLEX CORPORATION	85397	0331190001	J	YES	22/24	22/24	REFLOW TIN	1+10	COLD CRIMP	1	22	2.3	2.3	0.69	0.69	2.15	2.15	11.90	0.37	0.66	6.49	12.35	0.98	6.41	1.42	1.82	1.93	0.76	0.0008
N/A	MOLEX CORPORATION	---	0331190009	J	YES	22/24	---	REFLOW TIN	1+10	COLD CRIMP	1	22	2.3	2.3	0.69	0.69	2.15	2.15	11.90	0.37	0.66	6.49	12.35	0.98	6.41	1.42	1.82	1.93	0.76	0.0008
N/A	MOLEX CORPORATION	---	0331190006	J	YES	18/20	---	REFLOW TIN	1+10	COLD CRIMP	1	18	3.0	3.0	0.97	1.05	2.85	2.65	12.40	0.50	0.88	6.66	12.89	1.23	6.60	1.88	2.44	2.41	1.01	0.0008
04794358AA	MOLEX CORPORATION	85397	0331190005	J	NO	18/20	18/20	REFLOW TIN	1+10	COLD CRIMP	1	18	3.0	3.0	0.97	1.05	2.85	2.65	12.40	0.50	0.88	6.66	12.89	1.23	6.60	1.88	2.44	2.41	1.01	0.0008
4760759	MOLEX CORPORATION	85397	0331200008	J	NO	16	16	PRECIOUS METALS	1+6+7	COLD CRIMP	1	16	3.3	3.6	1.39	1.95	3.25	3.40	12.60	0.56	0.97	6.73	N/A	N/A	N/A	2.07	2.69	2.61	3.84	0.0008
4793039	MOLEX CORPORATION	85397	0331190008	J	YES	16	16	REFLOW TIN	1+10	COLD CRIMP	1	16	3.3	3.6	1.39	1.95	3.25	3.40	12.60	0.56	0.97	6.73	N/A	N/A	N/A	2.07	2.69	2.61	3.84	0.0008
4760759	MOLEX CORPORATION	85397	0331200006	J	NO	18/20	18/20	PRECIOUS METALS	1+6+7	COLD CRIMP	1	18	3.0	3.0	0.97	1.05	2.85	2.65	12.40	0.50	0.88	6.66	12.89	1.23	6.60	1.88	2.44	2.41	1.01	0.0008
4793039	MOLEX CORPORATION	85397	0331190004	J	YES	18/20	18/20	REFLOW TIN	1+10	COLD CRIMP	1	18	3.0	3.0	0.97	1.05	2.85	2.65	12.40	0.50	0.88	6.66	12.89	1.23	6.60	1.88	2.44	2.41	1.01	0.0008
4760759	MOLEX CORPORATION	85397	0331200004	J	NO	22/24	22/24	PRECIOUS METALS	1+6+7	COLD CRIMP	1	22	2.3	2.3	0.69	0.69	2.15	2.15	11.90	0.37	0.66	6.49	12.35	0.98	6.41	1.42	1.82	1.93	0.76	0.0008
4793039	MOLEX CORPORATION	85397	0331190002	J	YES	22/24	22/24	REFLOW TIN	1+10	COLD CRIMP	1	22	2.3	2.3	0.69	0.69	2.15	2.15	11.90	0.37	0.66	6.49	12.35	0.98	6.41	1.42	1.82	1.93	0.76	0.0008
REF/CHRYSLER PART NO.	NAME	CODE	PROD. P/N	PCL	GREASE	MS-9502 (MS-1689) SINGLE WIRE		PLATING	MATERIAL	WIRE ATTACH	GRIP (MATE SEAL)	GRIP A B	C+0.30	D+0.30	E+0.30	F+0.30	G	J	K	M	N	P	R	U	V	X	Y	ESTIMATED WEIGHT (LB)		
	VENDOR											CODE	(3A)	(3A)	(3A)	(3A)	(3A)	(3B)	(3B)	(3B)	(3B)	(3B)	(3B)	(3B)	(3B)	(3B)	(3B)	(3B)		

REFERENCE															
CRIMP DIMENSIONS															
CHRYSLER P/N(REF.)	WIRE AWG.	CONDUCTOR CH (REF. 1-1)	CONDUCTOR CW (REF. 1-1)	INSULATION CH (REF. 2-2)	INSULATION CW (REF. 2-2)	INSULATION FORM									
4793039	16	1.45±0.05	2.15±0.10	2.35±0.10	2.90±0.20	B-STYLE									
4793039	18	1.30±0.05	1.95±0.10	2.35±0.10	2.50±0.05	O-STYLE									
4793039	20	1.25±0.05	1.95±0.10	2.20±0.20	2.50±0.05	O-STYLE									
4793039	22	1.05±0.05	1.45±0.10	2.05±0.20	2.00±0.05	O-STYLE									
4760759 (GOLD)	16	1.45±0.05	2.15±0.10	2.35±0.10	2.90±0.20	B-STYLE									
4760759 (GOLD)	18	1.30±0.05	1.95±0.10	2.35±0.10	2.50±0.05	O-STYLE									
4760759 (GOLD)	20	1.25±0.05	1.95±0.10	2.20±0.20	2.50±0.05	O-STYLE									
4760759 (GOLD)	22	1.05±0.05	1.45±0.10	2.05±0.20	2.00±0.05	O-STYLE									
04794328AA	18	1.30±0.05	1.95±0.10	2.35±0.10	2.50±0.05	O-STYLE									
REF. MOLEX P/N A36XD-FT-A	18	1.30±0.05	1.95±0.10	2.35±0.20	2.50±0.05	O-STYLE									
REF. MOLEX P/N A36XD-C1-A	22	1.05±0.05	1.45±0.10	2.05±0.20	2.00±0.05	O-STYLE									



CRIMP INFORMATION



NOTES: UNLESS OTHERWISE SPECIFIED

- PARTS ARE TO BE FREE OF SCRATCHES, DISCOLORATION, SALT RESIDUE OR OTHER IMPERFECTIONS THAT MAY AFFECT FUNCTION OR DETRACT FROM APPEARANCE.
- MATERIAL THICKNESS: 0.30±0.01
- VENDOR TRADEMARK AND GRIP CODE MUST APPEAR ON PART
- PRINT TOLERANCE
1 PLACE DIMENSION: ±0.3
2 PLACE DIMENSION: ±0.10
ANGULAR DIMENSION: ±3°
- FORCE REQUIREMENTS:

A. BLADE INSERTION FORCE TO BE <= 4.5 NEWTONS WITH MATING TERMINAL (REF 4793773) GOLD 33120-XXXX
BE <= 7.5 NEWTONS WITH MATING TERMINAL (REF 4793031) TIN 33119-XXXX

B. BLADE EXTRACTION FORCE TO BE >= 1.0 NEWTON WITH MATING TERMINAL

C. MAX GAGE BLADE INSERTION FORCE WITH MAX SIZE BLADE TO BE <= 4.5 NEWTONS

D. MIN GAGE BLADE EXTRACTION FORCE WITH MIN SIZE BLADE TO BE >= 0.30 NEWTONS
- QUALITY ASSURANCE REQUIREMENTS PER ITEM ③: 1 PLACE
- INDICATES CRITICAL INSPECTION DIMENSIONS OR SPECIFICATION PER ITEM ④: 3 PLACES
- WIRING FABRICATORS MUST PURCHASE FROM SOURCES SHOWN
- MATING TERMINAL - SEE CHART SD-33121-001
- EXCEPTIONS TO PF-9600:
A. VOLTAGE DROP MV/AMP REQUIREMENT OF THE INITIAL CRIMP OF 0.50 AND THE INITIAL INTERFACE OF 1.00, PER 5.2.4.2 OF PF-9600, TO BE 1.3 MV/AMP
B. TERMINAL BEND RESISTANCE REQUIREMENT OF 22N, PER FIGURE 6.2.2.2 OF PF-9600, TO BE 16N FOR 22GA GRIP
- P/N 33119-0005 (REF 04794358AA) TO BE USED FOR OXYGEN SENSOR APPLICATION ONLY

ITEM	STANDARDS - NAME AND NUMBER
1	MS-8570 C7026-H08
2	MS-8570 C23000 DRAW QUALITY
3	PS-7300
4	PF-9600 (SEE NOTE #10)
5	TIN PLATE PER PS-39
6	SEE PLATING NOTES
7	NICKEL HOOD PLATING (SEE ITEM 2 AND PLATING NOTE 3)
8	PS-8335
9	MS-9469 NYOGEL 760G UV GREASE
10	ELECTRO DEPOSIT REFLOW SN

EC NO.: 107808
DRWN: MNS02
CH'K: ISAP
APPR: ISAP
REV: N1

QUALITY SYMBOLS
▽ = 0
▽ = 0

GENERAL TOLERANCES (UNLESS SPECIFIED)

	mm	INCH
4 PLACES	+ ---	+ ---
3 PLACES	+ ---	+ ---
2 PLACES	+ 0.10	+ ---
1 PLACE	+ 0.3	+ ---
ANGULAR	± 3°	

SCALE 1:1
DESIGN UNITS mm
DIMENSION STYLE mm/IN
DRAWN BY C BITTICK
DATE 7/13/95
CHECKED BY R BELL
DATE 7/13/95
APPROVED BY H ZAVERZEN
DATE 1/10/96

THIRD ANGLE PROJECTION
TITLE
TERMINAL ASSY-RECEPTACLE
1.5 MM BLADE SYSTEM (FEMALE)
CHART-DAIMLER CHRYSLER
MOLEX MOLEX INCORPORATED
MATERIAL NO.
DOCUMENT NO.
SD-33119-001
SHEET NO.
1 OF 1

REVISE ON CAD ONLY
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