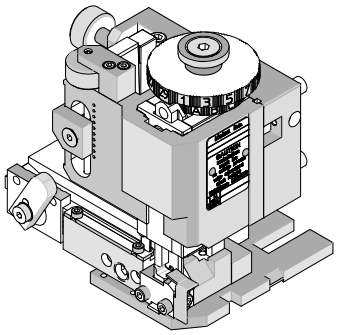
FineAdjust Applicator
Applicator Tooling Specification
Order No. 63901-8100



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

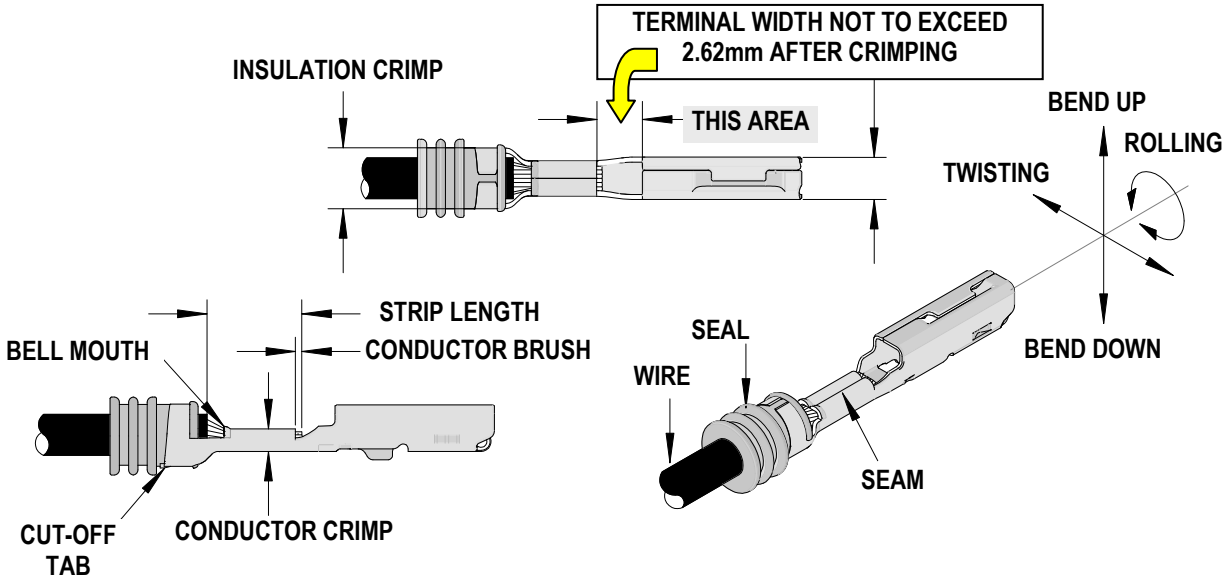
SCOPE

Products: MX150™ Cable Seal Receptacle Crimp Terminals, 18-20 AWG and 0.75 – 1.00 mm² wires.

Terminal Series No.	Terminal Order No.		Wire Size and Type		✖Insulation Diameter		Strip Length	
			AWG	mm²	mm	In.	mm	In.
34081 34083	34081-3004 34081-5002	34083-3002	TXL-18		1.91-2.06	.075-.081	4.70-5.60	.185-.220
			TXL-20		1.70-1.85	.067-.073		
				ISO 1.00	1.90-2.10	.075-.083		
				ISO 0.75	1.70-1.90	.067-.075		

✖ See crimp specification for the individual Insulation Diameter.
Terminals were validated per USCAR-21 using the following wire specifications:
M1L-123A (TXL) and M1L-126A1 (metric).
Customers are required to complete validation testing based on their own tooling practices.

DEFINITION OF TERMS



CRIMP SPECIFICATION

Terminal Series No.		Bell mouth		Cut-off Tab Maximum		▸ Conductor Brush Maximum	
		mm	In.	mm	In.	mm	In.
34081	34083	0.30-0.70	.012-.028	0.50	.020	0.40	.016
▸ Not to exceed above the conductor crimp height.							

Terminal Series No.		Bend up Bend down Degree		Twist Roll Degree		Punch Width (Ref) Conductor mm	Conductor In	Insulation mm	Insulation In	Seam
34081	34083	3	3	3	3	2.073	.082	3.501	.138	Seam shall not be open and no wire allowed out of the crimping area

After crimping, the crimp profiles should measure the following:

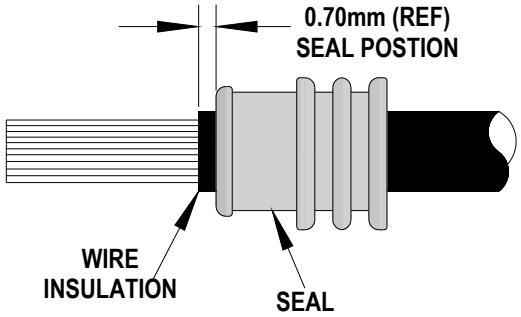
Terminal Series No.	Wire Size and Type		Conductor Crimp Height		Conductor Crimp Width		Pull Force Minimum	
	AWG	mm²	mm	In.	mm	In.	N	Lb.
34081 34083	TXL-18		1.20-1.30	.047-.051	2.05-2.25	.081-.089	90	20.2
	TXL-20		1.10-1.20	.043-.047	2.05-2.25	.081-.089	75	16.9
		ISO 1.00	1.25-1.35	.049-.053	2.05-2.25	.081-.089	120	27.0
		ISO 0.75	1.20-1.30	.047-.051	2.05-2.25	.081-.089	90	20.2

Terminal Series No.	Wire Size and Type		✖Insulation Diameter		Insulation Crimp Height		Insulation Crimp Width	
	AWG	mm²	mm	In.	mm	In.	mm	In.
34081 34083	TXL-18		1.91-2.06	.075-.081	3.60-3.80	.142-.150	3.45-3.65	.136-.144
	TXL-20		1.70-1.85	.067-.073	3.50-3.70	.138-.146	3.45-3.65	.136-.144
		ISO 1.00	1.90-2.10	.075-.083	3.60-3.80	.142-.150	3.45-3.65	.136-.144
		ISO 0.75	1.70-1.90	.067-.075	3.50-3.70	.138-.146	3.45-3.65	.136-.144

Terminal Series No.	Wire Size and Type		✶Cable Seal		
	AWG	mm²	Manufacturer and Part No.		Color
34081 34083	TXL-18		QSR	E-1644-00	Green
	TXL-20		QSR	E-1644-00	Green
		ISO 1.00	QSR	E-1644-00	Green
		ISO 0.75	QSR	E-1644-00	Green

✶Cable Seal Position On a Wire

(Before crimping)



▸ 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.

PARTS LIST

FineAdjust Applicator 63901-8100				
Item	**Order No**	**Engineering No.**	**Description**	**Quantity**
Perishable Tooling				
	63901-8170	63901-8170	Tool Kit (All "Y" Items)	REF
1	63457-0059	63457-0059	Conductor Punch	1 Y
2	63455-0065	63455-0065	Conductor Anvil	1 Y
3	63454-0103	63454-0103	Insulation Punch	1 Y
4	63456-0059	63456-0059	Insulation Anvil	1 Y
5	63443-0037	63443-0037	Cut-Off Plunger Front	1 Y
6	63443-0038	63443-0038	Plunger Retainer Front	1 Y
Other Components				
7	11-18-4094	60709A111	Feed Guide	1
8	63443-0009	63443-0009	Scrap Chute	1
9	63443-0055	63443-0055	Key	1
10	63443-0090	63443-0090	Wire Stop	1
11	63443-0093	63443-0093	Shank	1
12	63443-1714	63443-1714	18.40mm Height Spacer	1
13	63443-2203	63443-2203	3.00mm Coarse Spacer	1
14	63443-2208	63443-2208	8.00mm Coarse Spacer	1
15	63443-2310	63443-2310	3.50mm Fine Spacer	1
16	63443-6122	63443-6122	Rear Cover	1
17	63443-7109	63443-7109	Terminal Hold Down	1
18	63600-3378	63600-3378	Hold Down Spring	1
19	63700-0539	63700-0539	Cut-off Plunger Spring	1
20	63890-0009	63890-0009	Plunger Striker	1
Frame				
21	63800-4901	63800-4901	Top	1
22	63801-3286	63801-3286	Base	1
23	63801-4650	63801-4650	Track	1
24	63459-0001	63459-0001	Terminal Track with Relief Groove	1
25	63890-0073	63890-0073	Feed Cam	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

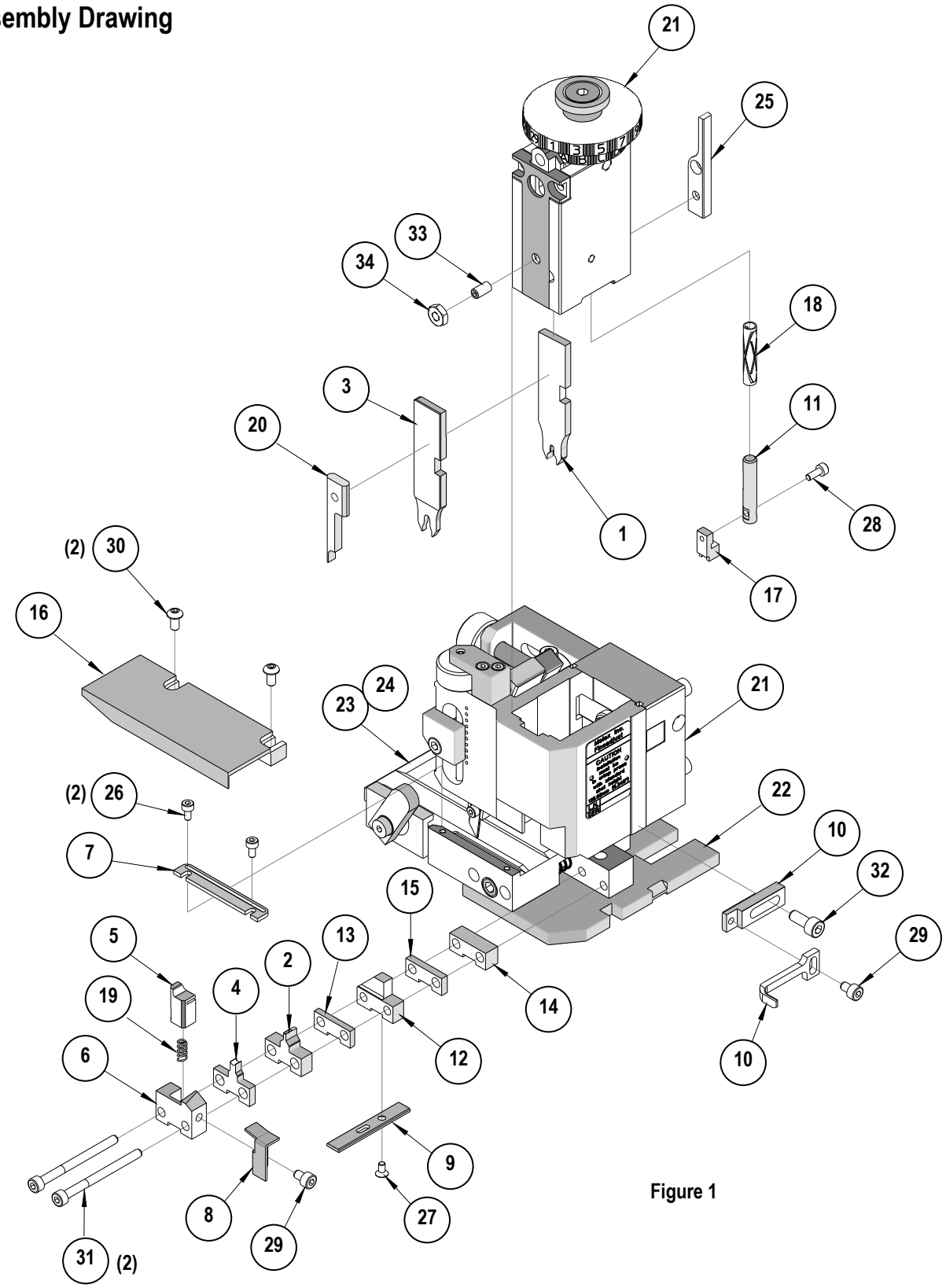


Figure 1

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.

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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