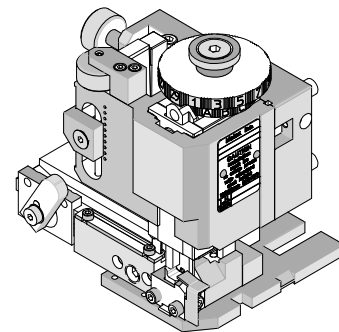




## FineAdjust Applicator Applicator Tooling Specification Order No. 63901-7400



### FEATURES

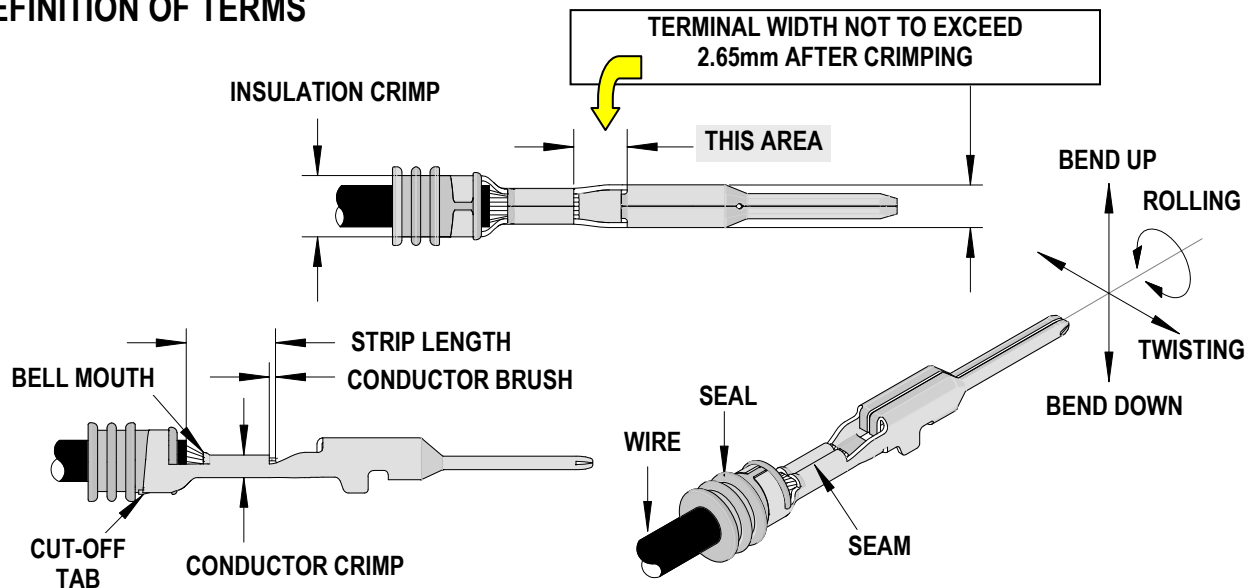
- Quick punch removal with the push of a button for fast and easy tooling change
- Applicator designed to industry standard mounting and shut height 135.80mm (5.346")
- Quick set-up time; plus the crimp height, track and feed adjustments can be set without removing the applicator from the press
- Fine 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 Blade Crimp Terminals, 22 AWG and 0.50mm<sup>2</sup> wires.

Terminal Series No.	Terminal Order No.	Wire Size and Type		✖ Insulation Diameter		Strip Length	
		AWG	mm²	mm	In.	mm	In.
34080	34080-1003	TXL-22		1.50-1.65	.059-.065	4.70-5.60	.185-.220
	34080-1106		ISO 0.50	1.40-1.60	.055-.063		
	34080-1206		AVSS 0.50	1.60-1.70	.063-.067		
<p>✖ See crimp specification for the individual Insulation Diameter.</p> <p>Terminals were validated per USCAR-21 using the following wire specifications: M1L-123A (TXL), M1L-126A1 (metric) and JASO D 611(AVSS).</p> <p>Customers are required to complete validation testing based on their own tooling practices.</p>							

### DEFINITION OF TERMS



**CRIMP SPECIFICATION**

Terminal Series No.	Bell mouth		Cut-off Tab Maximum		▶ Conductor Brush Maximum	
	mm	In.	mm	In.	mm	In.
34080	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		Twist   Roll		Punch Width (Ref)				Seam Seam shall not be open and no wire allowed out of the crimping area
	Degree		Degree		Conductor		Insulation		
					mm	In	mm	In	
34080	3	3	3	3	1.541	.061	3.469	.137	

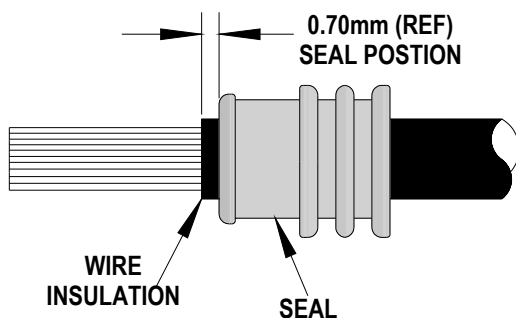
After crimping, the crimp profiles should measure the following:

Terminal Series No.	Wire Size and Type		Conductor				Pull Force Minimum	
			Crimp Height		Crimp Width			
	AWG	mm²	mm	In.	mm	In.	N	Lb.
34080	TXL-22		0.95-1.05	.037-.041	1.50-1.70	.059-.067	50	11.2
		ISO 0.50	1.05-1.15	.041-.045	1.50-1.70	.059-.067	75	16.9
		AVSS 0.50	1.05-1.15	.041-.045	1.50-1.70	.059-.067	75	16.9

Terminal Series No.	Wire Size and Type		✗ Insulation Diameter		Insulation			
					Crimp Height		Crimp Width	
	AWG	mm <sup>2</sup>	mm	In.	mm	In.	mm	In.
34080	TXL-22		1.50-1.65	.059-.065	3.40-3.60	.134-.142	3.35-3.55	.132-.140
		ISO 0.50	1.40-1.60	.055-.063	3.40-3.60	.134-.142	3.35-3.55	.132-.140
		AVSS 0.50	1.60-1.70	.063-.067	3.40-3.60	.134-.142	3.35-3.55	.132-.140

Terminal Series No.	Wire Size and Type		★ Cable Seal		
	AWG	mm <sup>2</sup>	Manufacturer and Part No.		Color
34080	TXL-22		QSR	E-1644-01	Pink
		ISO 0.50	QSR	E-1644-01	Pink
		AVSS 0.50	QSR	E-1644-01	Pink

★ **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**

<b>FineAdjust Applicator 63901-7400</b>				
<b>Item</b>	<b>Order No</b>	<b>Engineering No.</b>	<b>Description</b>	<b>Quantity</b>
<b>Perishable Tooling</b>				
	63901-7470	63901-7470	Tool Kit (All "Y" Items)	REF
1	63457-0061	63457-0061	Conductor Punch	1 Y
2	63455-0066	63455-0066	Conductor Anvil	1 Y
3	63454-0104	63454-0104	Insulation Punch	1 Y
4	63456-0061	63456-0061	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
<b>Other Components</b>				
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	63443-1717	63443-1717	18.70mm 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	63443-7108	63443-7108	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
<b>Frame</b>				
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
<b>Hardware</b>				
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

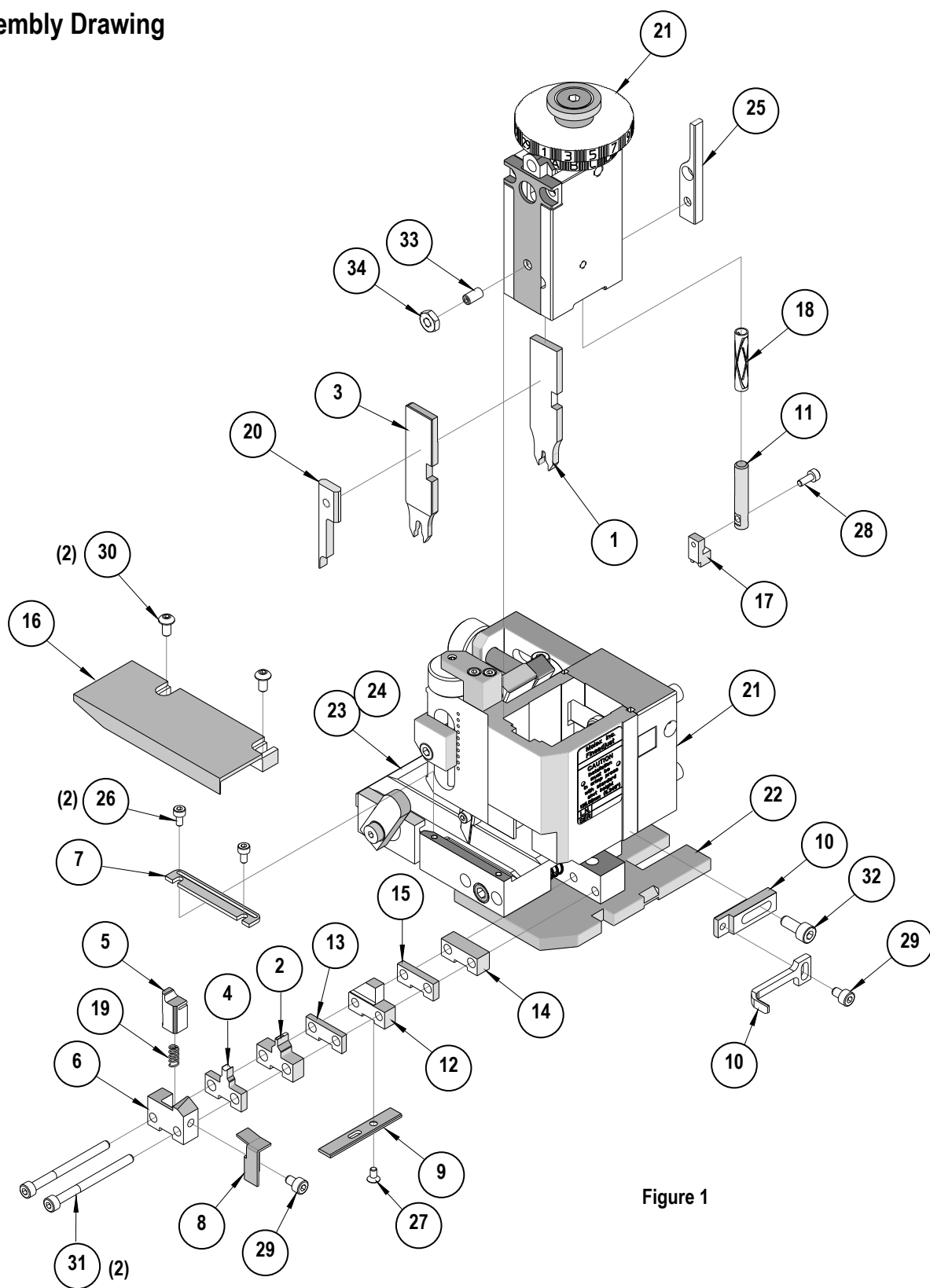


Figure 1

## 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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