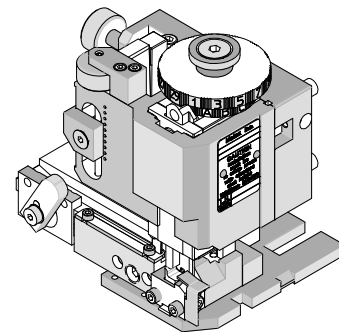




FineAdjust Applicator Applicator Tooling Specification Order No. 63901-8000



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

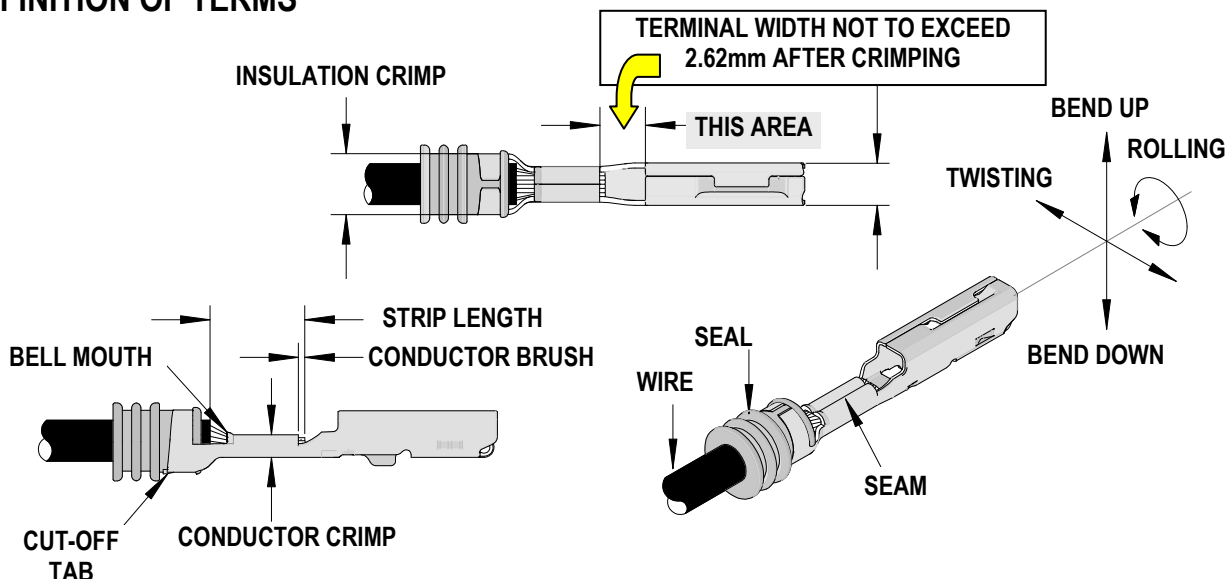
SCOPE

Products: MX150™ Cable Seal Receptacle Crimp Terminals, 14-16 AWG and 1.50 – 2.00 mm² wires.

Terminal Series No.	Terminal Order No.	Wire Size and Type	✗ Insulation Diameter		Strip Length	
			AWG	mm ²	mm	In.
34081 34083	34081-3003 34081-5001	34083-3001	UTX-14		2.34-2.49	.092-.098
			TXL-14		2.54-2.69	.100-.106
			TXL-16		2.18-2.34	.086-.092
			AVSS 2.00		2.60-2.70	.102-.106
			ISO 1.50		2.20-2.40	.087-.094

✗ See crimp specification for the individual Insulation Diameter.
Terminals were validated per USCAR-21 using the following wire specifications:
M1L-123A (TXL), M1L-135A1 (UTX), M1L-126A1(metric) and JASO D 611(AVSS)
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	1.60	.063
▶ 0.40mm (.016") maximum exceeds above the conductor crimp height allowable.							

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	
34081	34083	3	3	3	3	2.392	.094	3.551	.140	

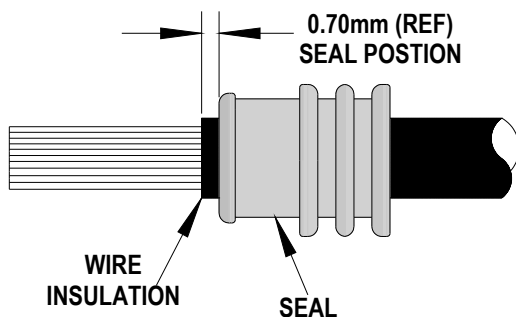
After crimping, the crimp profiles should measure the following:

Terminal Series No.	Wire Size and Type		Conductor				Pull Force Minimum	
			Crimp Height		Crimp Width			
	AWG	mm ²	mm	In.	mm	In.	N	Lb.
34081 34083	UTX-14		1.60-1.70	.063-.067	2.35-2.55	.093-.100	180	40.5
	TXL-14		1.60-1.70	.063-.067	2.35-2.55	.093-.100	180	40.5
	TXL-16		1.30-1.40	.051-.055	2.35-2.55	.093-.100	120	27.0
		AVSS 2.00	1.55-1.65	.061-.065	2.35-2.55	.093-.100	180	40.5
		ISO 1.50	1.35-1.45	.053-.057	2.35-2.55	.093-.100	150	33.7

Terminal Series No.	Wire Size and Type		✗ Insulation Diameter		Insulation			
					Crimp Height		Crimp Width	
	AWG	mm ²	mm	In.	mm	In.	mm	In.
34081 34083	UTX-14		2.34-2.49	.092-.098	3.70-3.90	.146-.154	3.55-3.75	.140-.148
	TXL-14		2.54-2.69	.100-.106	3.85-4.05	.152-.160	3.55-3.75	.140-.148
	TXL-16		2.18-2.34	.086-.092	3.70-3.90	.146-.154	3.55-3.75	.140-.148
		AVSS 2.00	2.60-2.70	.102-.106	3.85-4.05	.152-.160	3.55-3.75	.140-.148
		ISO 1.50	2.20-2.40	.087-.094	3.70-3.90	.146-.154	3.55-3.75	.140-.148

Terminal Series No.	Wire Size and Type		★ Cable Seal		
	AWG	mm ²	Manufacturer and Part No.		Color
34081 34083	UTX-14		QSR	E-1644-02	Yellow
	TXL-14		YAZAKI	7158-3033-40	Gray
	TXL-16		QSR	E-1644-02	Yellow
		AVSS 2.00	YAZAKI	7158-3033-40	Gray
		ISO 1.50	QSR	E-1644-02	Yellow

★ **Cable Seal Position On a Wire**
(Before crimping)



▶ **Tool Qualification Notes:**

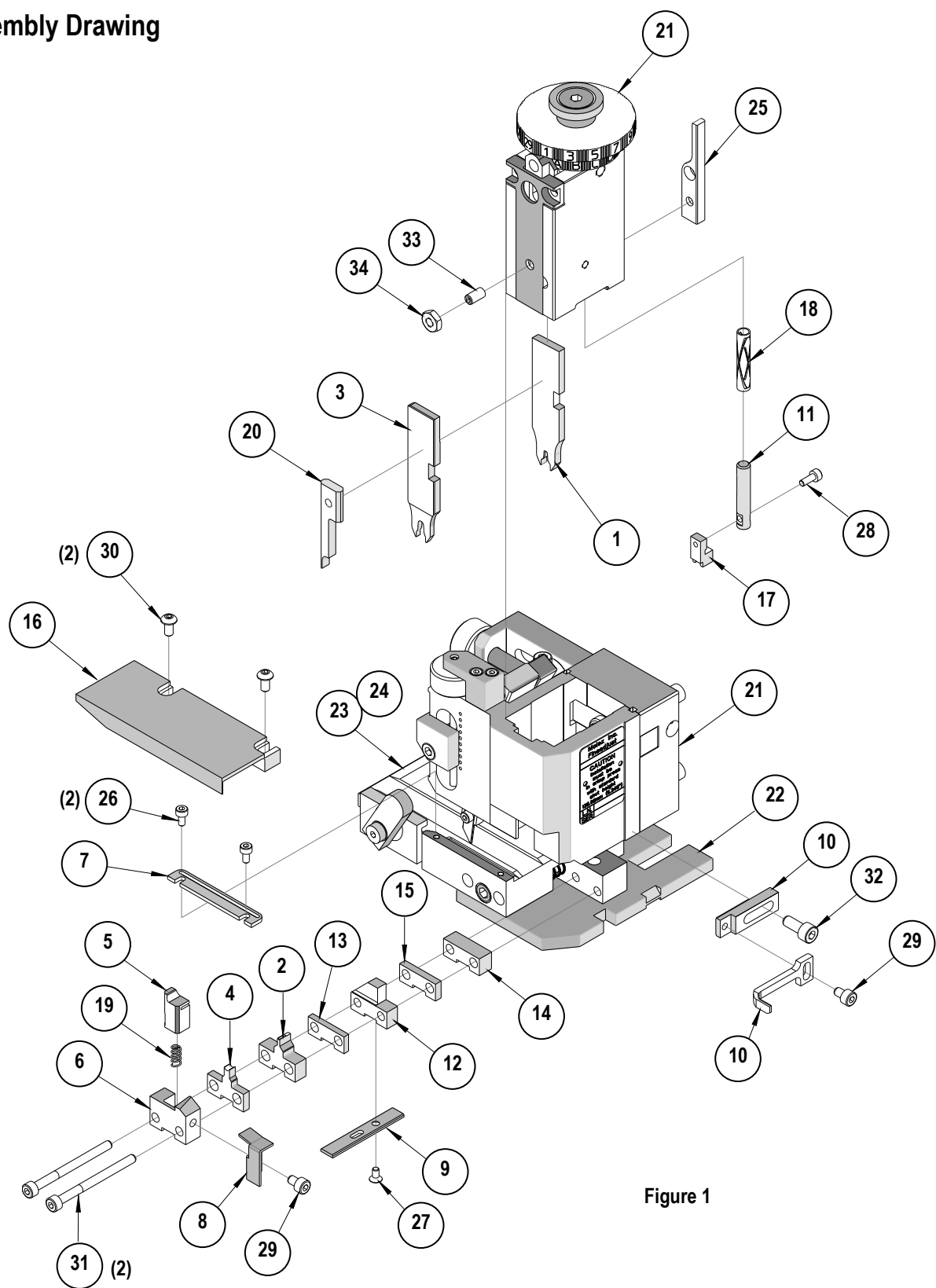
1. Pull Force should be measured with no influence from the insulation crimp.
2. The above specifications are guidelines to an optimum crimp.

PARTS LIST

FineAdjust Applicator 63901-8000				
Item	Order No	Engineering No.	Description	Quantity
Perishable Tooling				
	63901-8070	63901-8070	Tool Kit (All "Y" Items)	REF
1	63457-0058	63457-0058	Conductor Punch	1 Y
2	63455-0064	63455-0064	Conductor Anvil	1 Y
3	63454-0102	63454-0102	Insulation Punch	1 Y
4	63456-0058	63456-0058	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



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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