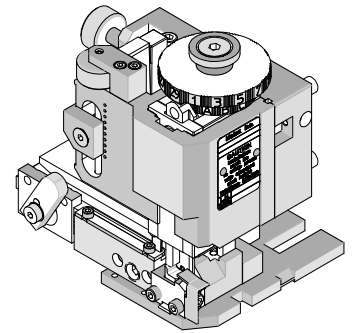




FineAdjust Applicator Applicator Tooling Specification Order No. 63901-7300



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

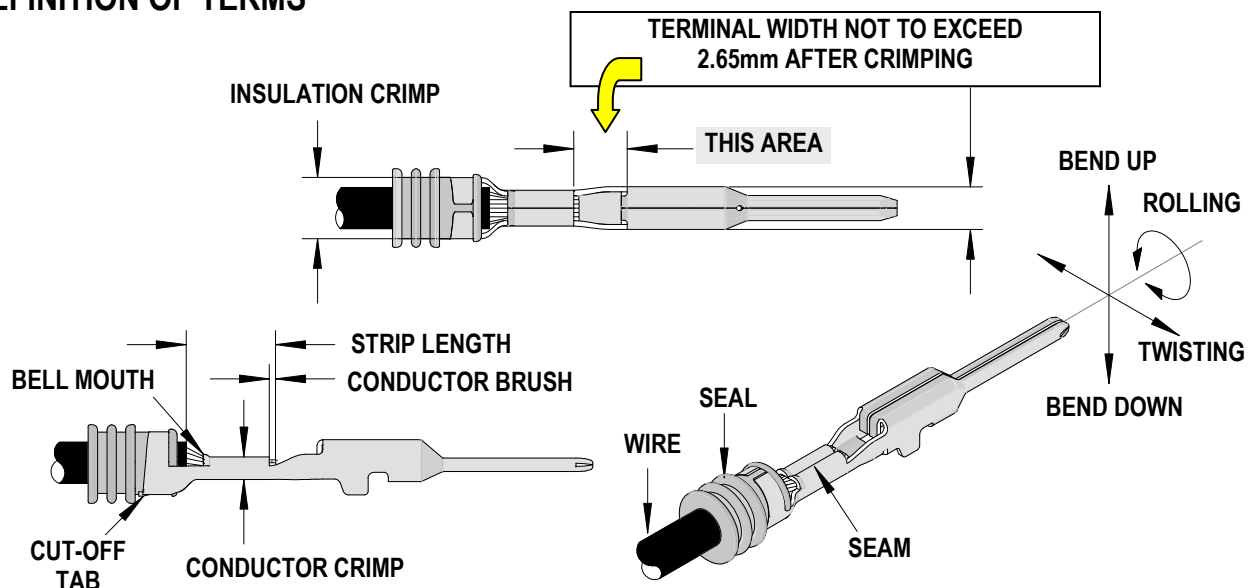
SCOPE

Products: MX150™ Cable Seal Blade Crimp Terminals, 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	mm ²	mm	In.	mm	In.
34080	34080-1002	TXL-18		1.91-2.06	.075-.081	4.70-5.60	.185-.220
	34080-1104	TXL-20		1.70-1.85	.067-.073		
	34080-1204		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.
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	2.073	.082	3.501	.138	

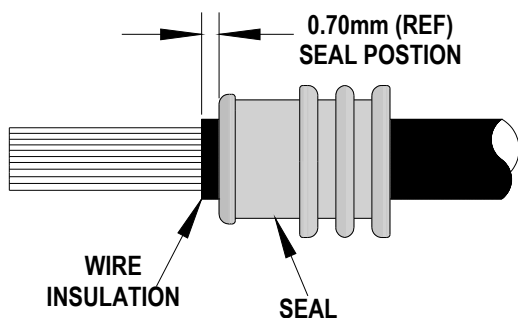
After crimping, the crimp profiles should measure the following:

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-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		Crimp Width	
	AWG	mm ²	mm	In.	mm	In.	mm	In.
34080	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	mm ²	Manufacturer and Part No.		Color
34080	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:

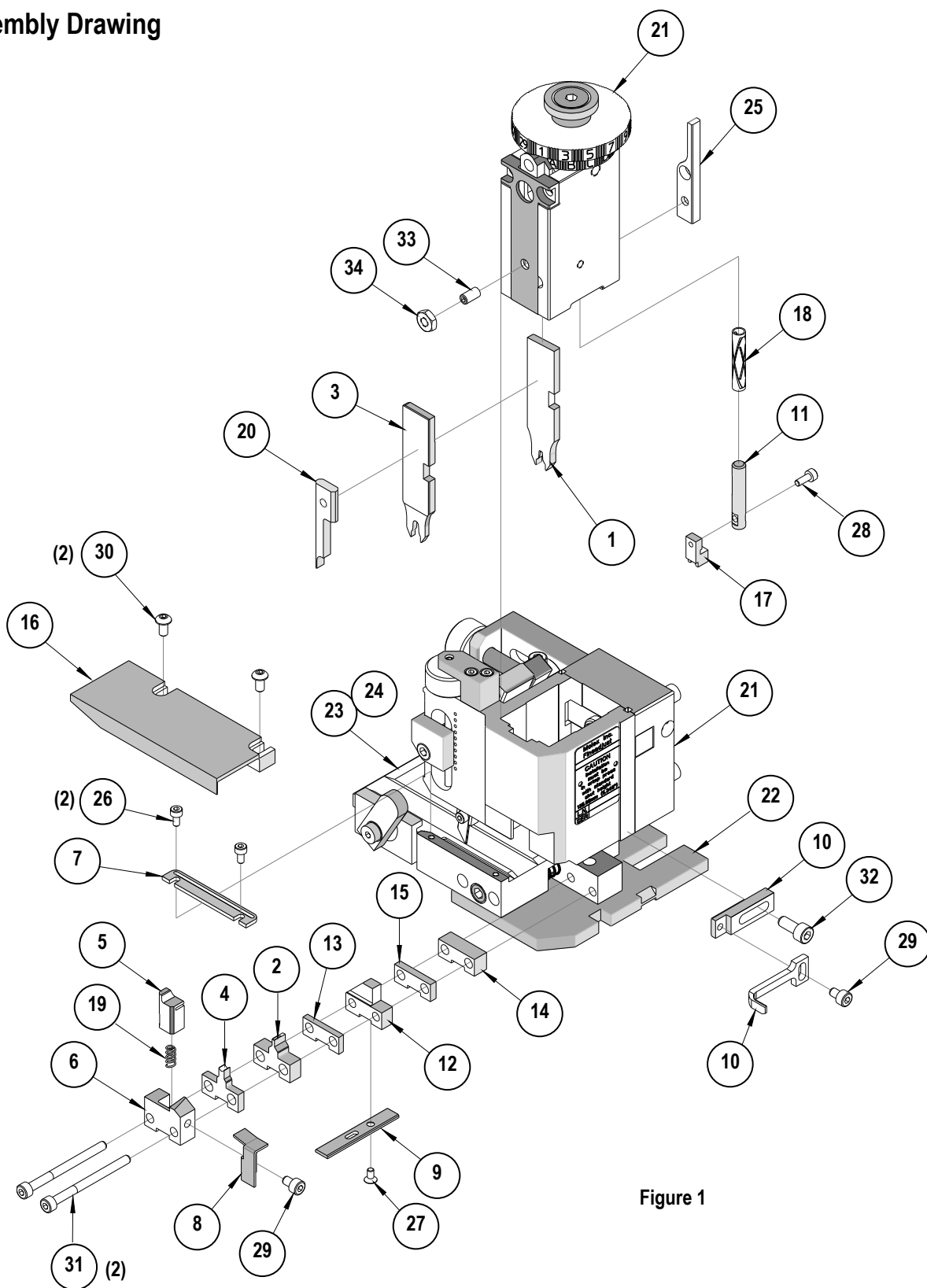
1. Pull Force should be measured with no influence from the insulation crimp.
2. The above specifications are guidelines to an optimum crimp.

PARTS LIST

FineAdjust Applicator 63901-7300				
Item	Order No	Engineering No.	Description	Quantity
Perishable Tooling				
	63901-7370	63901-7370	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	63443-1717	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
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.

Americas Headquarters
Lisle, Illinois 60532 U.S.A.
1-800-78MOLEX
amerinfo@molex.com

Far East North Headquarters
Yamato, Kanagawa, Japan
81-462-65-2324
feninfo@molex.com

Far East South Headquarters
Jurong, Singapore
65-6-268-6868
fesinfo@molex.com

European Headquarters
Munich, Germany
49-89-413092-0
eurinfo@molex.com

Corporate Headquarters
2222 Wellington Ct.
Lisle, IL 60532 U.S.A.
630-969-4550
Fax: 630-969-1352

Visit our Web site at <http://www.molex.com>

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Офис по работе с юридическими лицами:

105318, г.Москва, ул.Щербаковская д.3, офис 1107, 1118, ДЦ «Щербаковский»

Телефон: +7 495 668-12-70 (многоканальный)

Факс: +7 495 668-12-70 (доб.304)

E-mail: info@moschip.ru

Skype отдела продаж:

moschip.ru

moschip.ru_4

moschip.ru_6

moschip.ru_9