Chipsmall

Chipsmall Limited consists of a professional team with an average of over 10 year of expertise in the distribution of electronic components. Based in Hongkong, we have already established firm and mutual-benefit business relationships with customers from,Europe,America and south Asia,supplying obsolete and hard-to-find components to meet their specific needs.

With the principle of "Quality Parts,Customers Priority,Honest Operation,and Considerate Service",our business mainly focus on the distribution of electronic components. Line cards we deal with include Microchip,ALPS,ROHM,Xilinx,Pulse,ON,Everlight and Freescale. Main products comprise IC,Modules,Potentiometer,IC Socket,Relay,Connector.Our parts cover such applications as commercial,industrial, and automotives areas.

We are looking forward to setting up business relationship with you and hope to provide you with the best service and solution. Let us make a better world for our industry!

Contact us

FineAdjust Applicator	**molex** ® **Application Tooling Specification Sheet**		
		Order No. 63903-9300	
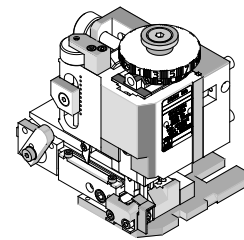
FEATURES THIS APPLICATOR IS FOR AUTOMATIC WIRE PROCESSOR USE ONLY.

- 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, 22 AWG and 0.50mm² wires.

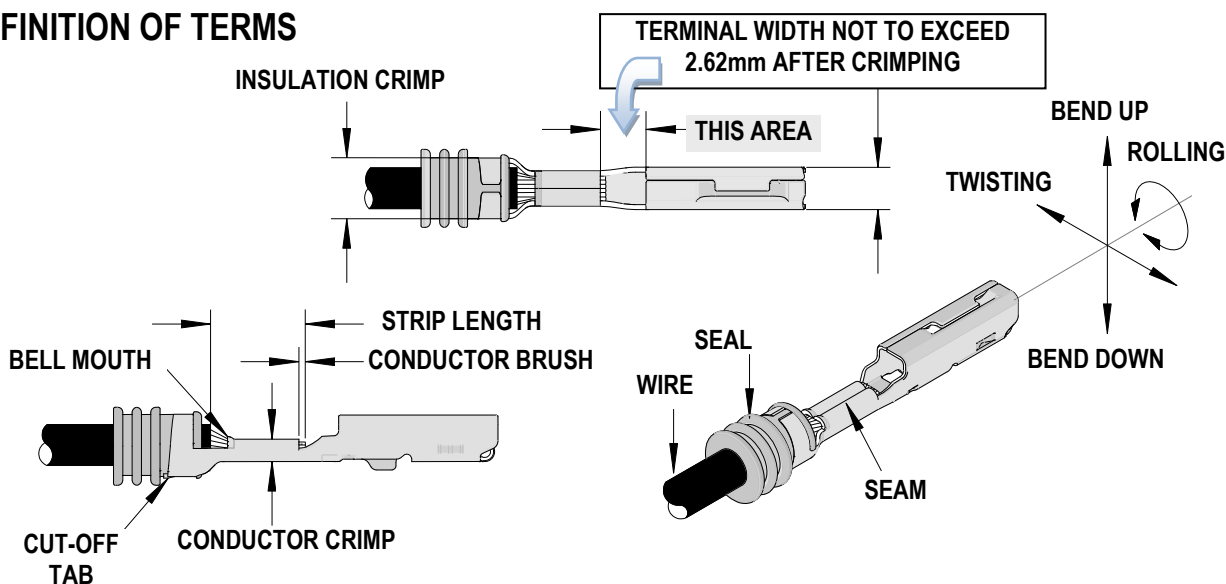| Terminal Series No.	Terminal Order No.		Wire Size and Type		✖ Insulation Diameter		Strip Length	
			AWG	mm²	mm	In.	mm	In.
34081 34083	34081-3005 34081-5003	34083-3003	TXL-22		1.50-1.65	.059-.065	4.70-5.60	.185-.220
				FLR91X 0.50	1.40-1.60	.055-.063		
				AVSS 0.50	1.60-1.70	.063-.067		
✖ See crimp specification for the individual Insulation Diameter. Terminals were validated per USCAR-21 using the following wire specifications: M1L-123A4 (TXL), M1L-126A1(metric) and JASO D 611(AVSS) Customers are required to complete validation testing based on their own tooling practices.								

DEFINITION OF TERMS

TERMINAL WIDTH NOT TO EXCEED 2.62mm AFTER CRIMPING

INSULATION CRIMP

THIS AREA

BEND UP

ROLLING

TWISTING

BEND DOWN

STRIP LENGTH

CONDUCTOR BRUSH

BELL MOUTH

SEAL

WIRE

CUT-OFF TAB

CONDUCTOR CRIMP

SEAM

Doc No: ATS-639039300
Revision: B
Release Date: 03-20-15
Revision Date: 03-23-15
UNCONTROLLED COPY
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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

▶ Max. 0.40mm (.016") above the conductor crimp height allowable.
▶ **THIS APPLICATOR IS INTENDED FOR AUTOMATIC WIRE PROCESSOR USE ONLY.**
It is very important that the brush length is consistently within specification for this sealed connector system to work properly.
This applicator should only be run in a properly setup automatic wire processor in order to consistently achieve the brush length.
Any attempt to use this applicator outside a properly setup automatic wire processor will likely not meet the brush specification
and cause this sealed connector system to not work properly.

| Terminal Series No.		Bend up	Bend down	Twist	Roll	Punch Width (Ref)				Seam
		Degree		Degree		Conductor		Insulation		Seam shall not be open and no wire allowed out of the crimping area
						mm	In	mm	In	
34081	34083	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.
34081 34083	TXL-22		0.95-1.05	.037-.041	1.50-1.70	.059-.067	50	11.2
	FLR91X 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	mm²	mm	In.	mm	In.	mm	In.
34081 34083	TXL-22		1.50-1.65	.059-.065	3.40-3.60	.134-.142	3.35-3.55	.132-.140
	FLR91X 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		Color
	AWG	mm²	Manufacturer and Part No.		
34081 34083	TXL-22		QSR	E-1644-01	Pink
	FLR91X 0.50	QSR	E-1644-01	Pink
	AVSS 0.50	QSR	E-1644-01	Pink

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

0.20-0.40mm (REF)
SEAL POSTION

WIRE
INSULATION

SEAL
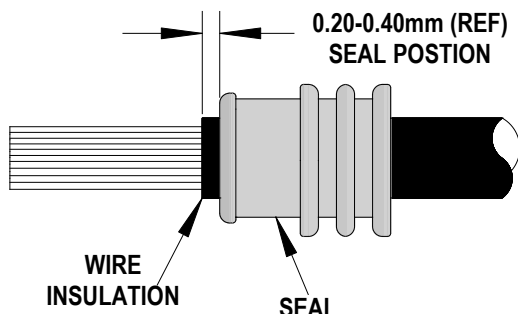
▶ Tool Qualification Notes:

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 63903-9300		
Item	Order No	Engineering No.	Description	Quantity
			Perishable Tooling	
	63903-9370	63903-9370	Tool Kit (All "Y" Items)	REF
1	63457-0110	63457-0110	Conductor Punch	1 Y
2	63455-0137	63455-0137	Conductor Anvil	1 Y
3	63454-0161	63454-0161	Insulation Punch	1 Y
4	63456-0109	63456-0109	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	63443-1714	63443-1714	Height Spacer	1
12	63443-2203	63443-2203	Coarse Spacer (3.00mm)	1
13	63443-2208	63443-2208	Coarse Spacer (8.00mm)	1
14	63443-2310	63443-2310	Fine Spacer (3.50mm)	1
15	63443-3203	63443-3203	Wire Pusher	1
16	63443-6122	63443-6122	Rear Cover	1
17	63600-5016	63600-5016	Wire Pusher spring	1
18	63700-0539	63700-0539	Cut-off Plunger Spring	1
19	63867-3007	63867-3007	Bottom Cap	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
			Hardware	
25	N/A	N/A	M3 by 6 Long SHCS	2**
26	N/A	N/A	M3 by 6 Long FHCS	1**
27	N/A	N/A	M4 by 6 Long SHCS	2**
28	N/A	N/A	M4 by 8 Long Flat Point SSS	1**
29	N/A	N/A	M4 by 12 Long SHCS	2**
30	N/A	N/A	M4 by 12 Long BHCS	2**
31	N/A	N/A	M4 by 16 Long SHCS	1**
32	N/A	N/A	M4 by 50 Long SHCS	2**
33	N/A	N/A	M5 by 12 Long SHCS	1**
34	N/A	N/A	#10-32 by 3/8"Long Flat Point SSS	1**
35	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
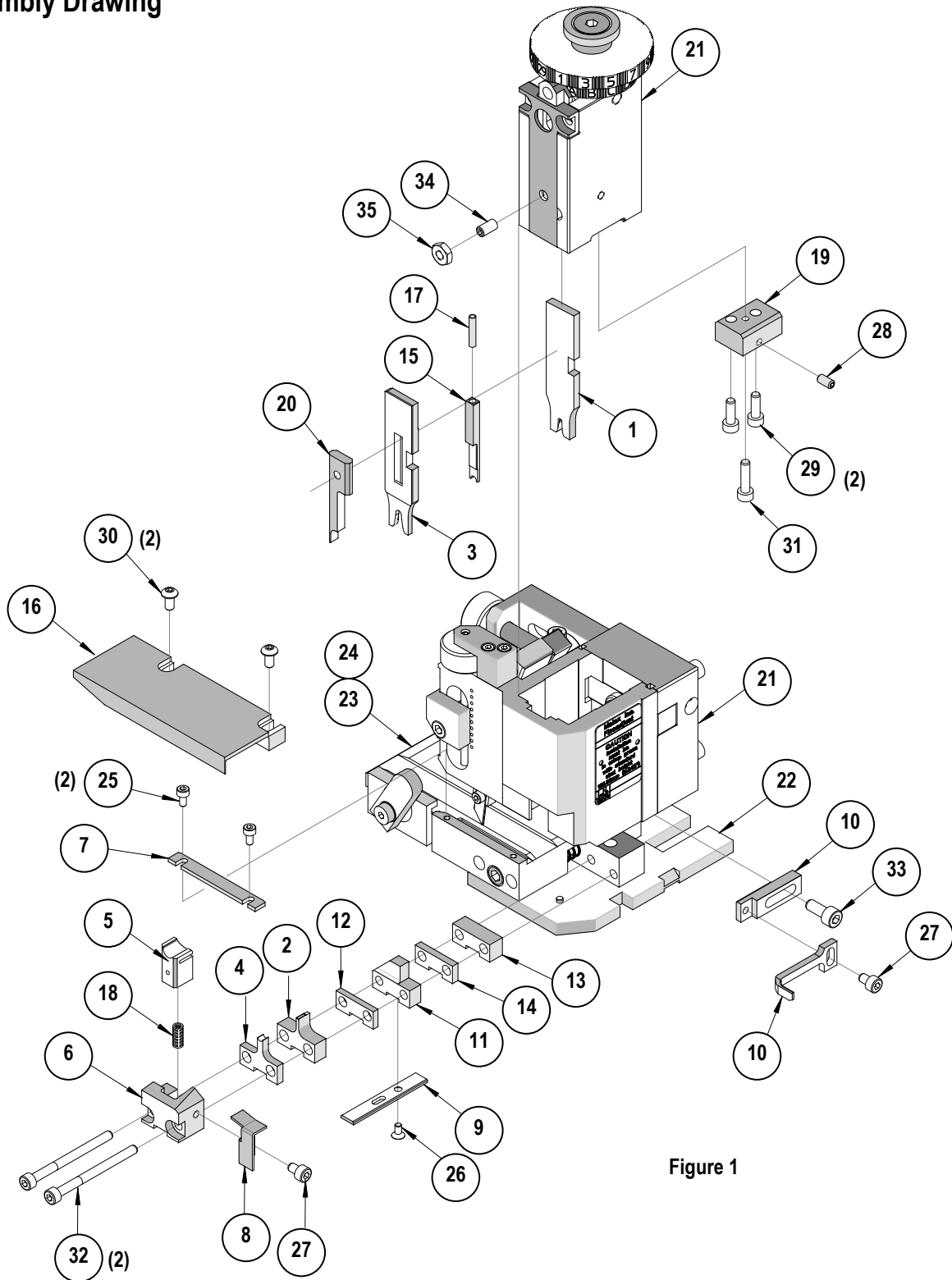
Figure 1

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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