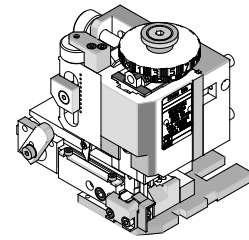




**FineAdjust  
Applicator**

**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 0.50mm<sup>2</sup> wires.

Terminal Series No.	Terminal Order No.		Wire Size and Type		✗ Insulation Diameter		Strip Length	
			AWG	mm <sup>2</sup>	mm	In.	mm	In.
34081	34081-3005	34083-3003	TXL-22		1.50-1.65	.059-.065	4.70-5.60	.185-.220
34083	34081-5003			FLR91X 0.50	1.40-1.60	.055-.063		
				AVSS 0.50	1.60-1.70	.063-.067		

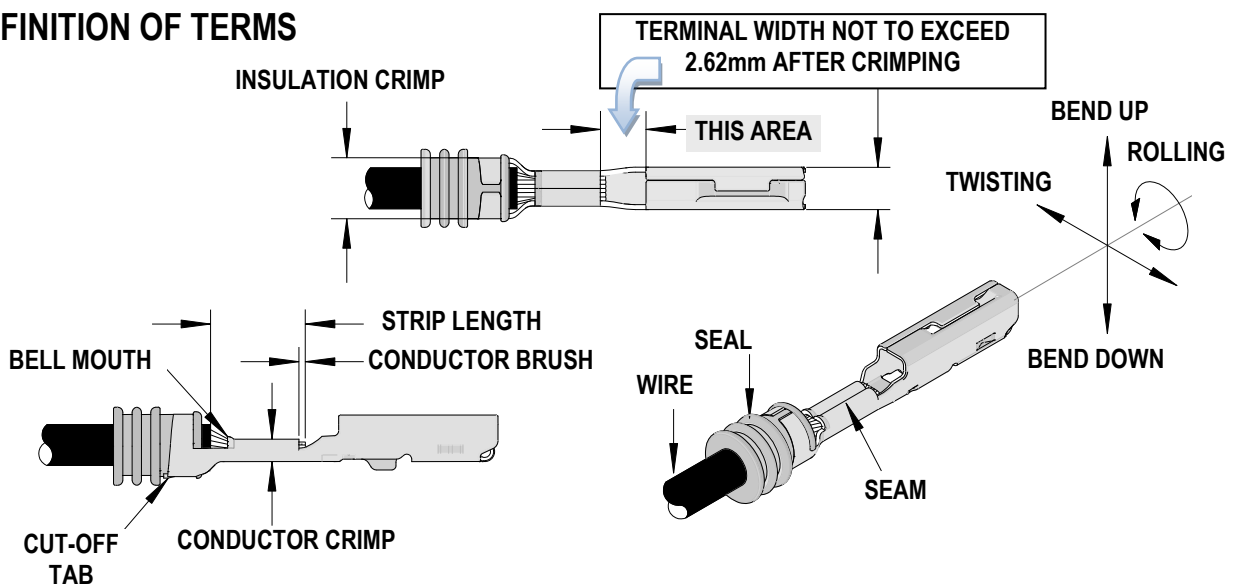
✗ See crimp specification for the individual Insulation Diameter.

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**



## 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 Seam shall not be open and no wire allowed out of the crimping area
		Degree				Degree		Conductor		
		mm	In	mm	In					
34081	34083	3	3	3	3	1.541	.061	3.469	.137	

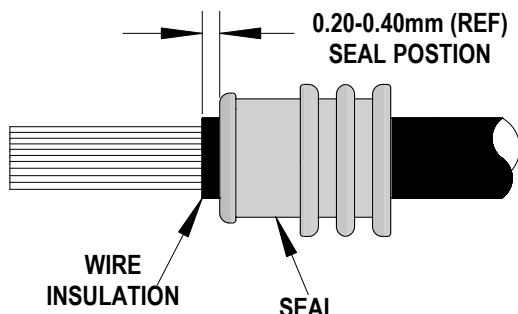
After crimping, the crimp profiles should measure the following:

Terminal Series No.	Wire Size and Type		Conductor				Pull Force Minimum	
			Crimp Height		Crimp Width			
	AWG	mm <sup>2</sup>	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			
			mm	In.	Crimp Height		Crimp Width	
	AWG	mm <sup>2</sup>	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			
	AWG	mm <sup>2</sup>	Manufacturer and Part No.		Color	
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)



### ▶ 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
<b>Perishable Tooling</b>				
	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
<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	63443-1714	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
<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
<b>Hardware</b>				
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

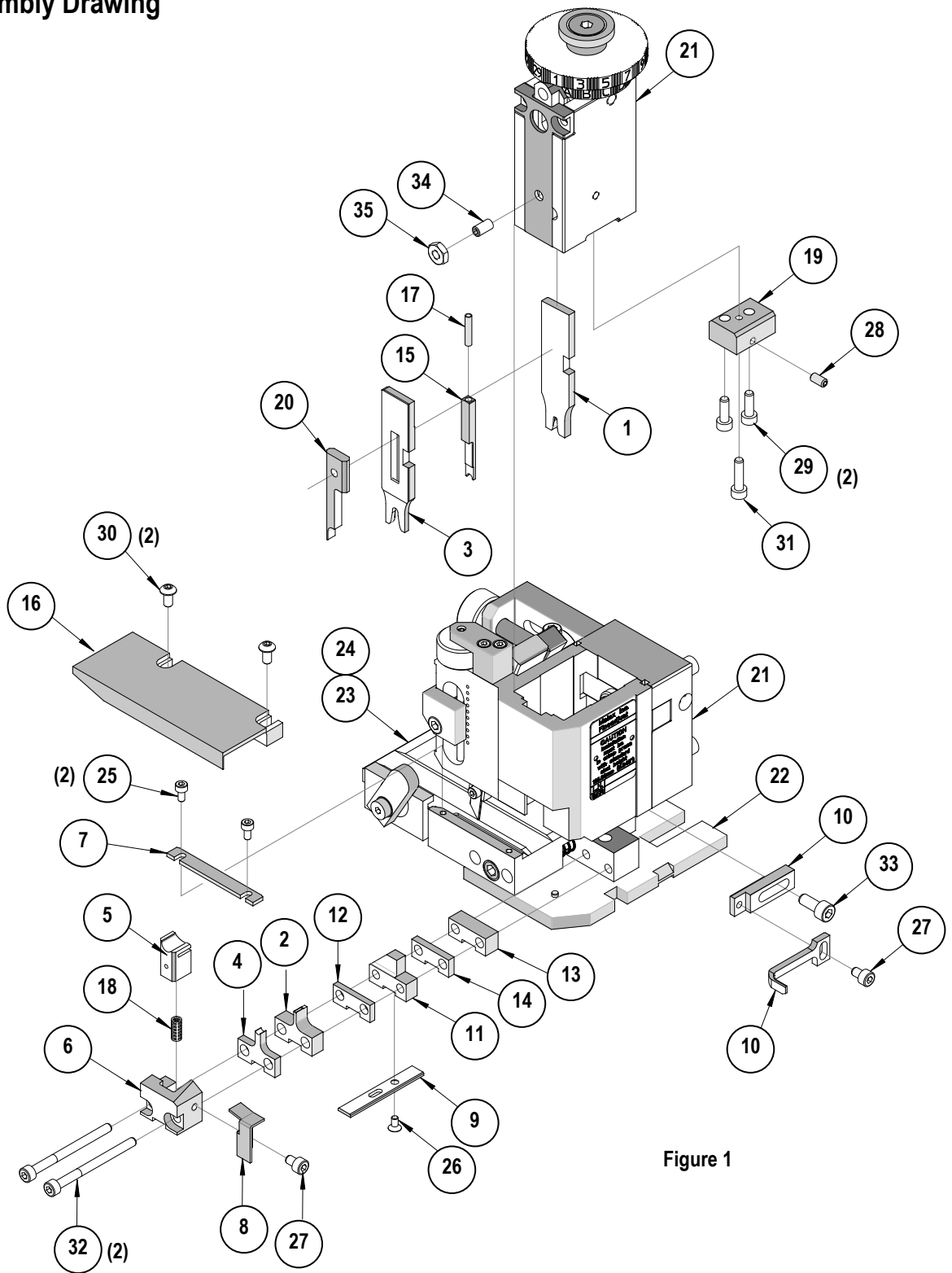


Figure 1

## 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.

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