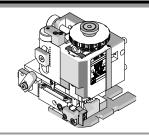




Application Tooling Specification Sheet



Order No. 63901-8700

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 ISO (M3) Receptacle Terminals: 0.35, 0.50 metric, type ISO wire.

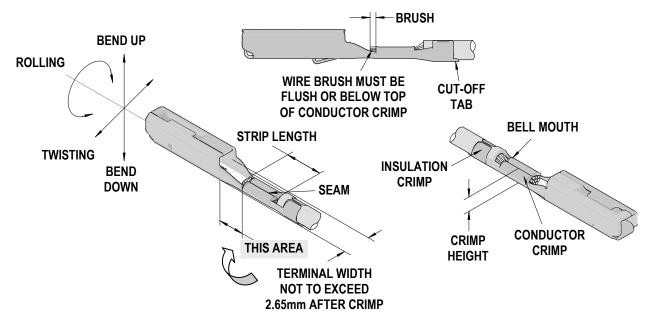
Terminal	Terminal Order No.		Wire Size	and Type	Insulation	Diameter	Strip Length		
Series No.	Terrinia	Order No.	mm²	Type	mm	ln.	In. mm		
33001	33001-3006	33001-5005	0.35	ISO	1.20-1.40	.047055	4.70-5.60	.185220	
33001			0.50	ISO	1.40-1.70	.055067	4.70-5.60	.185220	
33012	33012-3004		0.35	ISO	1.20-1.40	.047055	4.70-5.60	.185220	
33012			0.50	ISO	1.40-1.70	.055067	4.70-5.60	.185220	
34750	24750 1004		0.35	ISO	1.20-1.40	.047055	4.70-5.60	.185220	
34730	34750-1004		0.50	ISO	1.40-1.70	.055067	4.70-5.60	.185220	
34780	24700 4004		0.35	ISO	1.20-1.40	.047055	4.70-5.60	.185220	
	34780-1004		0.50	ISO	1.40-1.70	.055067	4.70-5.60	.185220	

Terminals were validated per USCAR-21 using the ISO 6722 wire specifications. Customers are required to complete validation testing if tooling purchased outside Molex Inc. And/or wire specifications are different than above.

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Revision: C

DEFINITION OF TERMS



CRIMP SPECIFICATION

Terminal Series No.		Bell n	nouth	Cut-off Tab	Maximum	► Conductor Brush (Maximum)		
		mm	ln.	mm	ln.	mm	ln.	
33001	33012	0.30-0.70	.012028	0.50	.020	0.40	.016	
34750	34780	0.30-0.70	.012028	0.50	.020	0.40	.016	

Wire brush must be flush or below top of Conductor Crimp.

▶ 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				idth (Ref)		Seam	
		Bena ap 1	Conductor			Insulation		Seam shall not be			
		Degree		Degree		mm	In	mm In		open and no wire allowed	
33001	33012	1.5	1.5	3	3	1.56	.061	2.00	.079	out of the crimping area	
34750	34780	1.5	1.5	3	3	1.56	.061	2.00	.079	out of the chiliping area	

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After crimping, the crimp profiles should measure the following:

Tamainal	Wire Cire		Cond	uctor			Pull Force					
Terminal Series No.	Wire Size	Crimp	Crimp Height		Crimp Width		Crimp Height		Crimp Width		Minimum	
Series No.	mm²	mm	ln.	mm	ln.	mm	ln.	mm	ln.	N	Lb.	
33001	0.35	1.02-1.08	.040042	1.50-1.70	.059067	1.65-1.85	.065073	1.90-2.10	.075083	50	11.3	
33001	0.50	1.05-1.15	.041045	1.50-1.70	.059067	1.80-2.00	.071079	1.90-2.10	.075083	75	16.9	
33012	0.35	1.02-1.08	.040042	1.50-1.70	.059067	1.65-1.85	.065073	1.90-2.10	.075083	50	11.3	
33012	0.50	1.05-1.15	.041045	1.50-1.70	.059067	1.80-2.00	.071079	1.90-2.10	.075083	75	16.9	
34750	0.35	1.02-1.08	.040042	1.50-1.70	.059067	1.65-1.85	.065073	1.90-2.10	.075083	50	11.3	
	0.50	1.05-1.15	.041045	1.50-1.70	.059067	1.80-2.00	.071079	1.90-2.10	.075083	75	16.9	
34780	0.35	1.02-1.08	.040042	1.50-1.70	.059067	1.65-1.85	.065073	1.90-2.10	.075083	50	11.3	
	0.50	1.05-1.15	.041045	1.50-1.70	.059067	1.80-2.00	.071079	1.90-2.10	.075083	75	16.9	

Tool Qualification Notes:

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

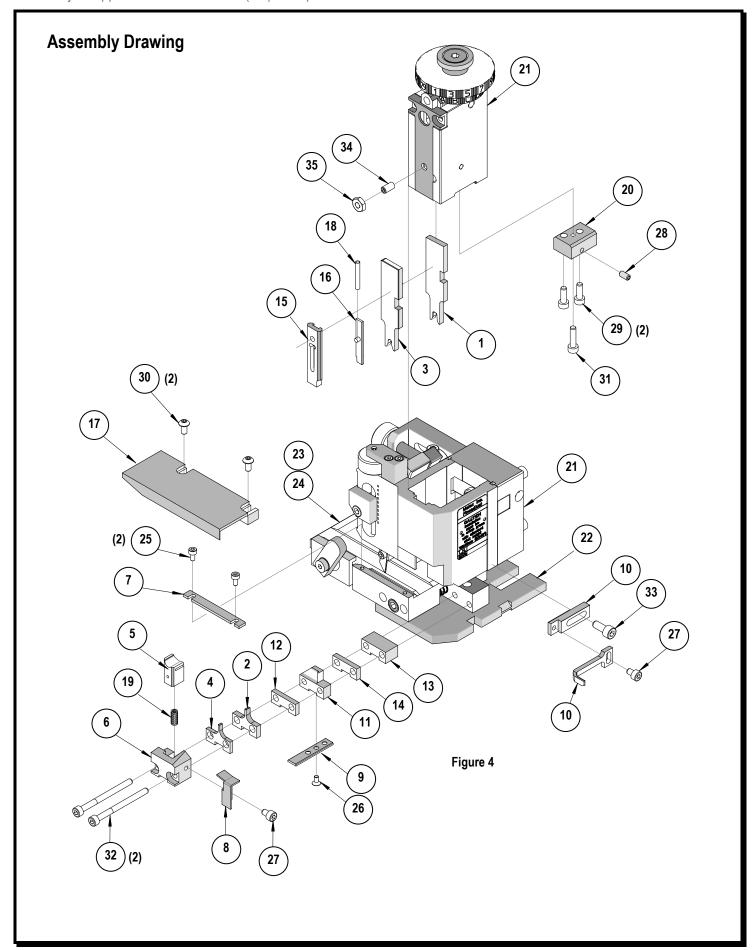
UNCONTROLLED COPY Doc No: ATS-639018700 Release Date: 03-11-11 Page 3 of 6 Revision: C Revision Date: 06-25-15

PARTS LIST

Item	FineAdjust Applicator 63901-8700										
G3901-8770 G3901-8770 Tool Kit (All "Y" Items) REF	Item	Order No Engineering No. Description									
1 63457-0070 63457-0070 Conductor Punch 1 Y 2 63455-0098 63455-0098 Conductor Anvil 1 Y 3 63455-0098 Conductor Anvil 1 Y 4 63456-0078 Galante Anvil 1 Y 5 63443-0037 Cut-Off Plunger 1 Y 6 63443-0038 Front Plunger Retainer 1 Y Other Components 7 11-18-4094 60709A111 Feed Guide 1 8 63443-0009 Scrap Chute 1 9 63443-0090 Key 1 10 63443-0090 Wire Stop 1 11 63443-0090 Wire Stop 1 12 63443-2002 Coarse Spacer (2.00mm) 1 13 63443-2009 Gases Spacer (2.00mm) 1 14 63443-2009 Coarse Spacer (3.05mm) 1 14 63443-2001 Fine Spacer (3.05mm) 1 15 63443-2915 Striker Plunger Striker 1	•										
1 63457-0070 63457-0070 Conductor Punch 1 Y 2 63455-0098 63455-0098 Conductor Anvil 1 Y 3 63455-0014 63456-0078 Insulation Anvil 1 Y 4 63456-0078 63456-0078 Insulation Anvil 1 Y 5 63443-0038 63443-0037 Cut-Off Plunger 1 Y 6 63443-0038 63443-0038 Front Plunger Retainer 1 Y Other Components 7 11-18-4094 60709A111 Feed Guide 1 8 63443-0009 Scrap Chute 1 9 63443-0009 Key 1 10 63443-0090 Wire Stop 1 11 63443-2090 63443-2002 Coarse Spacer (3.00mm) 1 12 63443-2202 Coarse Spacer (9.00mm) 1 13 63443-2203 Coarse Spacer (9.00mm) 1 14 63443-2301 Fine Spacer (3.05mm) 1 15 63443-2915 Striker Pl		63901-8770	63901-8770	Tool Kit (All "Y" Items)	REF						
3 63454-0114 63456-0078 63456-0078 Insulation Punch 1 Y 4 63456-0078 63456-0078 Insulation Anvil 1 Y 5 63443-0037 63443-0038 Front Plunger Retainer 1 Y 6 63443-0038 63443-0038 Front Plunger Retainer 1 Y Other Components 7 11-18-4094 60709A111 Feed Guide 1 8 63443-0009 63443-0024 Key 1 9 63443-0090 63443-0090 Wire Stop 1 11 63443-0090 63443-2002 Key 1 12 63443-2009 63443-2002 Coarse Spacer (2.00mm) 1 12 63443-2209 63443-2209 Coarse Spacer (9.00mm) 1 13 63443-2201 63443-2301 Fine Spacer (3.05mm) 1 14 63443-2301 63443-2301 Fine Spacer (3.05mm) 1 15 63443-2915 Striker Plunger Striker 1 16 63443-2915 <td>1</td> <td>63457-0070</td> <td>63457-0070</td> <td>i ·</td> <td>1 Y</td>	1	63457-0070	63457-0070	i ·	1 Y						
4 63456-0078 63443-0037 63443-0037 Cut-Off Plunger 1 Y 5 63443-0038 63443-0038 Front Plunger Retainer 1 Y Other Components 7 11-18-4094 60709A111 Feed Guide 1 8 63443-0009 63443-0009 Scrap Chute 1 9 63443-0024 Key 1 10 63443-0090 G3443-0090 Wire Stop 1 11 63443-2020 63443-2002 Coarse Spacer (18.40mm) 1 12 63443-2020 63443-200 Coarse Spacer (18.40mm) 1 13 63443-2202 63443-200 Coarse Spacer (18.40mm) 1 14 63443-2202 Coarse Spacer (19.00mm) 1 13 63443-2203 63443-200 Coarse Spacer (2.00mm) 1 14 63443-2209 63443-200 Fine Spacer (3.05mm) 1 15 63443-2301 Fine Spacer (3.05mm) 1 16 63443-2915 63443-2915 Stri	2	63455-0098	63455-0098	Conductor Anvil	1 Y						
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6 63443-0038 Front Plunger Retainer 1 Y Other Components 7 11-18-4094 60709A111 Feed Guide 1 8 63443-0009 63443-0009 Scrap Chute 1 9 63443-0024 Key 1 10 63443-0090 Wire Stop 1 11 63443-1714 Height Spacer (18.40mm) 1 12 63443-2202 63443-2209 Coarse Spacer (2.00mm) 1 13 63443-2209 63443-2209 Coarse Spacer (9.00mm) 1 14 63443-2301 Fine Spacer (3.05mm) 1 15 63443-2301 63443-2804 Front Plunger Striker 1 16 63443-2915 Striker Plunger 1 1 17 63443-2915 63443-2915 Striker Plunger Spring 1 1 18 63600-0021 Striker Plunger Spring 1 1 1 63600-0021 Striker Plunger Spring 1 1 1 1 1 <td< td=""><td>4</td><td>63456-0078</td><td>63456-0078</td><td>Insulation Anvil</td><td>1 Y</td></td<>	4	63456-0078	63456-0078	Insulation Anvil	1 Y						
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18 63600-0021 Striker Plunger Spring 1 19 63700-0539 63700-0539 Cut-off Plunger Spring 1 20 63867-3007 63867-3007 Bottom Cap 1 Frame 21 63800-4901 63800-4901 Top 1 22 63801-3281 63801-3281 Base 1 23 63801-4650 63801-4650 Track 1 24 63459-0001 63459-0001 Terminal Track 1 Hardware 25 N/A N/A M3 by 6 Long SHCS 2** 26 N/A N/A M4 by 6 Long SHCS 2** 27 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 15 Long SHCS 2** 31 N/A N/A M4 by 50 Long SHCS 2** 31 N/A N/A M4 by 50 Long SHCS 2**											
19 63700-0539 63700-0539 Cut-off Plunger Spring 1 20 63867-3007 Bottom Cap 1 Frame 21 63800-4901 Top 1 22 63801-3281 Base 1 23 63801-4650 63801-4650 Track 1 24 63459-0001 63459-0001 Terminal Track 1 Hardware 25 N/A N/A M3 by 6 Long SHCS 2** 26 N/A N/A M4 by 6 Long SHCS 2** 27 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 SHCS 2** 31 N/A N/A M4 by 16 Long SHCS 2** 31 N/A N/A M4 by 10 Long SHCS 2** 31 N/A N/A M4 by 50 Long SHCS 2** 33 N/A											
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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 wireprocessing 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

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