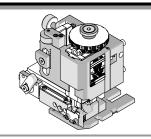




Application Tooling Specification Sheet



Order No. 63900-8400

FEATURES

- Directly adapts to most automatic wire processing machines
- 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

SCOPE

Products: MX150L™ Female Terminal for 18-24 AWG Wire.

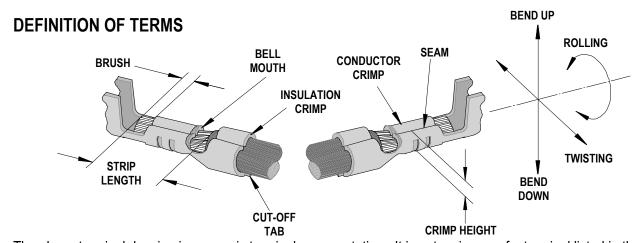
Terminal Series No.	Tormino	l Order No	Wi	re Size	Insulation	Diameter	Strip Length	
Terminal Series No.	Terminal Order No.		AWG	mm²	mm	ln.	mm	ln.
19420	19420-0002	Female (Tin)	18-22	0.83-0.36	2.36-2.74	.093108	4.20-5.00	.165197
	19420-0004	Female (Gold)	18-22	0.83-0.36	2.36-2.74	.093108	4.20-5.00	.165197
	19420-0002	Female (Tin)	24	0.20	1.00 Nom.	.039 Nom.	4.20-5.00	.165197
	19420-0004	Female (Gold)	24	0.20	1.00 Nom.	.039 Nom.	4.20-5.00	.165197

Note: Terminals will accommodate the following wire specification:

- 1. (18-22 AWG) UL1015 wires.
- 2. (24 AWG) UL20251 wire.

For 24 AWG wire, see Tool Qualification Notes, Item 2 on page 2.

For TXL-style insulation, see Tool Qualification Notes, Item 3 on page 2.



The above terminal drawing is a generic terminal representation. It is not an image of a terminal listed in the scope.

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CRIMP SPECIFICATION

Terminal Series No.	Bell n	nouth	Cut-off Tak	Maximum	Conductor Brush		
Terminal Series No.	mm	ln.	mm	ln.	mm	ln.	
19420	0.25-1.25	.010049	0.50	.020	0.15-0.65	.006026	

	Bend up Bend down		Twist	Roll	Punch Width mm (Ref)			Seam Seam shall not be open	
Terminal Series No.			I WIST KOII		Conductor		Insulation		
	Degree		Degree		mm	ln	mm	ln	and no wire allowed out
19420	5	5	4	8	2.00	.079	3.40	.133	of the crimping area

After crimping, the conductor profile should measure the following.

Terminal Series No.	Wire Size		Conductor C	Crimp Height	Insulation Co Maxir	Pull Force Minimum		
	AWG	mm ²	mm In.		Mm (Ref)	In. (Ref)	N	Lb.
19420	18	0.83	1.15-1.25	.045049	3.00	.118	89.0	20.00
	20	0.58	1.10-1.20	.043047	3.00	.118	57.9	13.00
	22	0.36	1.05-1.15	.041045	3.00	.118	35.6	8.00
	24	0.20	1.00-1.10	.039043	3.00	.118	22.2	5.00

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

★Tool Qualification Notes:

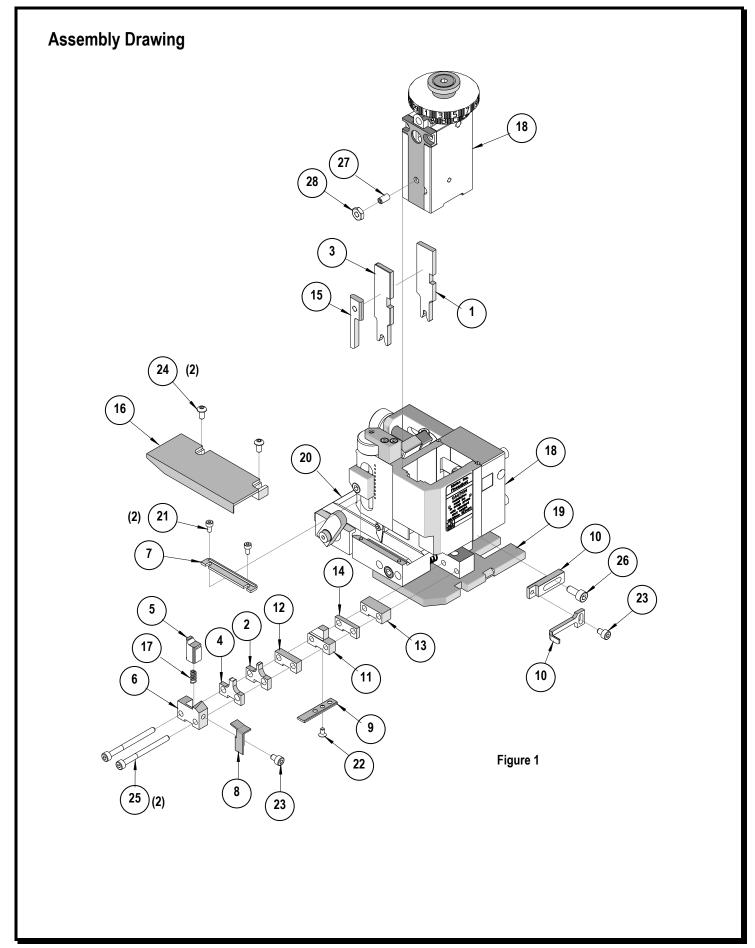
- 1. This Applicator was qualified to the above specifications with UL1015 wires for 18-22 AWG and UL20251 wire for 24 AWG.
- 2. For the 24 AWG wire, the insulation crimp has clearance around the wire and does not provide strain relief, even at the nominal reference crimp height of 2.11mm (.083").
- 3. TXL-style automotive wire can be crimped but the insulation crimp will not fully contact the wire insulation.

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PARTS LIST

FineAdjust Applicator 63900-8400									
Item	Order No								
Item Order No Engineering No. Description Quantity Perishable Tooling									
	63900-8470	63900-8470	Tool Kit (All "Y" Items)	REF					
1	63444-2037	63444-2037	Conductor Punch	1 Y					
2	63445-2068	63445-2068	Conductor Anvil	1 Y					
3	63454-0022	63454-0022	Insulation Punch	1 Y					
4	63445-3440	63445-3440	Insulation Anvil	1 Y					
5	63443-0035	63443-0035	Front Cut-Off Plunger	1 Y					
6	63443-0036	63443-0036	Front Plunger Retainer	1 Y					
		Other	Components						
7	11-18-4083	60707-8	Feed Guide	1					
8	63443-0009	63443-0009	Front Scrap Chute	1					
9	63443-0024	63443-0024	Key	1					
10	63443-0090	63443-0090	Wire Stop	1					
11	63443-1712	63443-1712	Height Spacer	1					
12	63443-2206	63443-2206	Coarse Spacer (6.00mm)	1					
13	63443-2208	63443-2208	Coarse Spacer (8.00mm)	1					
14	63443-2312	63443-2312	Fine Spacer (3.60mm)	1					
15	63443-3160	63443-3160	Front Plunger Striker	1					
16	63443-6121	63443-6121	Rear Cover	1					
17	63700-0539	63700-0539	Cut-Off Plunger Spring	1					
	Frame								
18	63800-4901	63800-4901	Тор	1					
19	63801-3281	63801-3281	Base	1					
20	63801-4650	63801-4650	Track	1					
	,	Н	ardware						
21	N/A	N/A	M3 by 6 Long SHCS	2**					
22	N/A	N/A	M3 by 6 Long FHCS	1**					
23	N/A	N/A	M4 by 6 Long SHCS	2**					
24	N/A	N/A	M4 by 12 Long BHCS	2**					
25	N/A	N/A	M4 by 50 Long SHCS	2**					
26	N/A	N/A	M5 by 12 Long SHCS	1**					
27	N/A	N/A	#10-32 by 3/8"Long Flat Point SSS	1**					
28	N/A	N/A	#10-32 Hex Jam Nut	1**					
*	** Available from an industrial supply company such as MSC (1-800-645-7270).								

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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 135.8mm (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.

http://www.molex.com

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