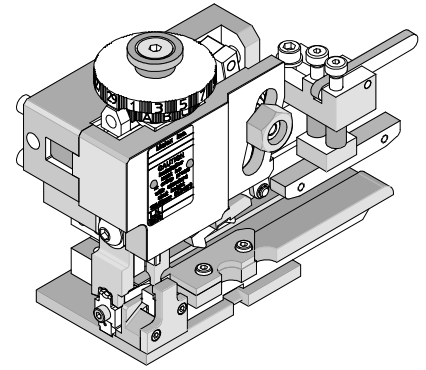




## Rear Feed Mini-Mac Applicator Mechanical Feed Specification Sheet Order No. 63802-6300



### FEATURES

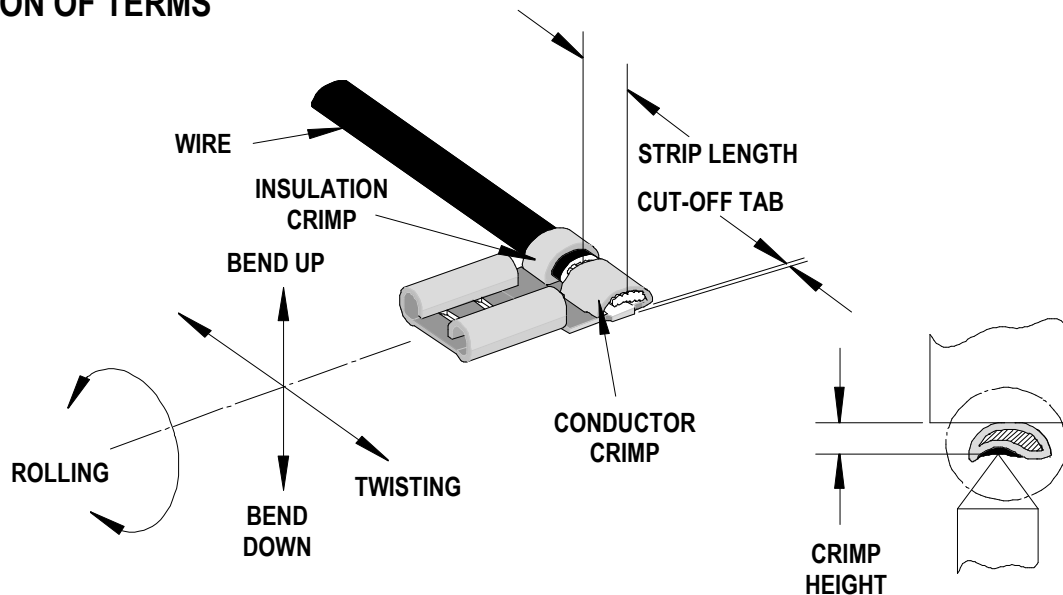
- Directly adapts to most automatic wire processing machines
- Applicator designed to industry standard mounting and shut height 135.80mm (5.346")
- Quick set-up time; plus the crimp height, track and feed adjustments can be set without removing the applicator from the press
- Fine adjustment allows 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: Flag Avikrimp™ Quick Disconnect Female Terminals, 14-16 AWG.

| Terminal<br>Order No. | Terminal<br>Eng. No. | Wire Size |                 | Tab Size     |              | Insulation Diameter<br>Maximum |      | Strip Length |      |
|-----------------------|----------------------|-----------|-----------------|--------------|--------------|--------------------------------|------|--------------|------|
|                       |                      | AWG       | mm <sup>2</sup> | mm           | In.          | mm                             | In.  | mm           | In.  |
| 19006-0014            | BB-5221Z             | 14-16     | 2.00-1.30       | 6.35 by 0.81 | .250 by .032 | 4.32                           | .170 | 8.70         | .344 |
| 19006-0023            | BB-5224Z             | 14-16     | 2.00-1.30       | 4.75 by 0.51 | .187 by .020 | 4.32                           | .170 | 8.70         | .344 |
| 19006-0024            | BB-5225Z             | 14-16     | 2.00-1.30       | 4.75 by 0.81 | .187 by .032 | 4.32                           | .170 | 8.70         | .344 |

### DEFINITION OF TERMS

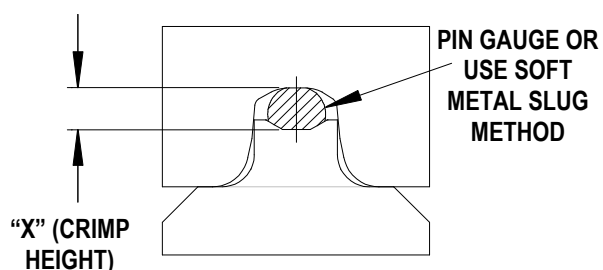


The above terminal drawing is a generic terminal representation. It is not an image of a terminal listed in the scope.

## CRIMP SPECIFICATIONS

| Terminal Order No.                                             | Terminal Eng. No. | Wire Size |                 | Conductor Crimp Height |      |      |      |       |      | Pull Force Minimum |      |
|----------------------------------------------------------------|-------------------|-----------|-----------------|------------------------|------|------|------|-------|------|--------------------|------|
|                                                                |                   |           |                 | Mean                   |      | Go   |      | No Go |      |                    |      |
|                                                                |                   | AWG       | mm <sup>2</sup> | mm                     | In.  | mm   | In.  | mm    | In.  | N                  | Lb.  |
| 19006-0014                                                     | BB-5221Z          | 14        | 2.00            | 2.23                   | .088 | 2.15 | .085 | 2.31  | .091 | 222.6              | 50.0 |
|                                                                |                   | 16        | 1.30            |                        |      |      |      |       |      | 133.5              | 30.0 |
| 19006-0023                                                     | BB-5224Z          | 14        | 2.00            | 2.23                   | .088 | 2.15 | .085 | 2.31  | .091 | 222.6              | 50.0 |
|                                                                |                   | 16        | 1.30            |                        |      |      |      |       |      | 133.5              | 30.0 |
| 19006-0024                                                     | BB-5225Z          | 14        | 2.00            | 2.23                   | .088 | 2.15 | .085 | 2.31  | .091 | 222.6              | 50.0 |
|                                                                |                   | 16        | 1.30            |                        |      |      |      |       |      | 133.5              | 30.0 |
| Seam                                                           |                   |           |                 |                        |      |      |      |       |      |                    |      |
| Seam shall not be open and no wire allowed out of the crimping |                   |           |                 |                        |      |      |      |       |      |                    |      |

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



**CRIMP PROFILE**

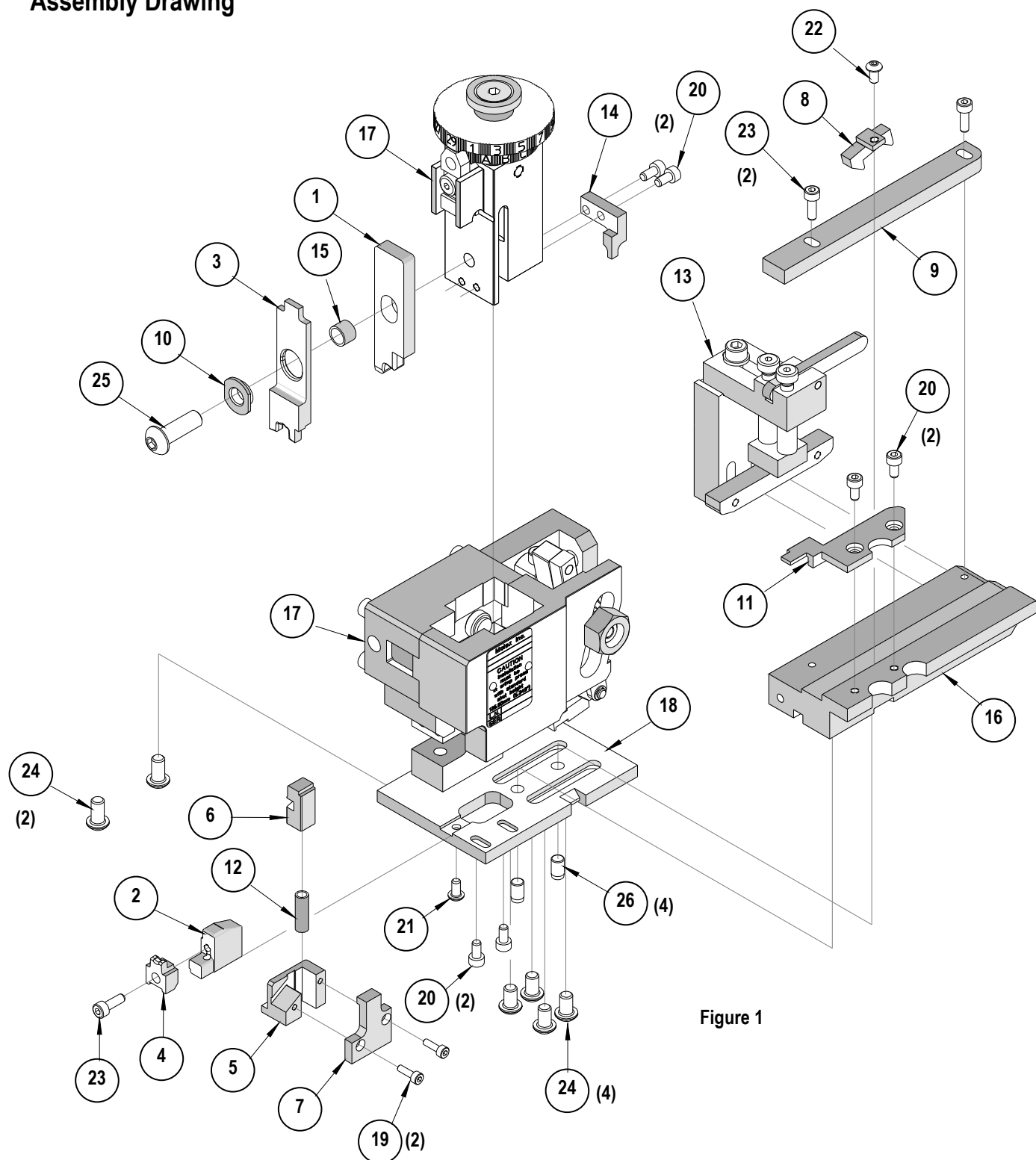
Use gauge pins or soft metal slug (solder) method to measure the "X" dimension. Verify tooling crimp height calibration by referring to the Go/No Go dimensions shown in the chart below.

Molex does not sell gauge pins contact your local industrial supplier.

**PARTS LIST**

| <b>Rear Feed Mini-Mac Applicator 63802-6300</b>                              |                  |                        |                           |                 |
|------------------------------------------------------------------------------|------------------|------------------------|---------------------------|-----------------|
| <b>Item No.</b>                                                              | <b>Order No.</b> | <b>Engineering No.</b> | <b>Description</b>        | <b>Quantity</b> |
| <b>Perishable Tooling</b>                                                    |                  |                        |                           |                 |
|                                                                              | 63802-6370       | 63802-6370             | Tool Kit (All "Y" Items)  | REF             |
| 1                                                                            | 63801-5512       | 63801-5512             | Conductor Punch (E2 Die)  | 1 Y             |
| 2                                                                            | 19803-5281       | 19803-5281             | Conductor Anvil (E1 Die)  | 1 Y             |
| 3                                                                            | 63801-5611       | 63801-5611             | Insulation Punch (I2 Die) | 1 Y             |
| 4                                                                            | 19803-5291       | 19803-5291             | Insulation Anvil (I1 Die) | 1 Y             |
| 5                                                                            | 19229-0120       | 23650-43               | Cutter Housing            | 1 Y             |
| 6                                                                            | 19229-0121       | 23650-44               | Cutter Plunger            | 1 Y             |
| <b>Other Components (REF 26350)</b>                                          |                  |                        |                           |                 |
| 7                                                                            | 19229-0095       | 23650-45               | Cutter Back Plate         | 1               |
| 8                                                                            | 19230-0038       | 24854-08               | Feed Finger               | 1               |
| 9                                                                            | 19230-0040       | 24854-18               | Guide Rail                | 1               |
| 10                                                                           | 19230-0063       | 24853                  | Shoulder Bushing          | 1               |
| 11                                                                           | 19250-0004       | 24854-25               | Guide and Hold Down       | 1               |
| 12                                                                           | 19250-0038       | 24855-23               | Compression Spring        | 1               |
| 13                                                                           | 63801-2690       | 63801-2690             | Terminal Drag Assembly    | 1               |
| 14                                                                           | 63801-7701       | 63801-7701             | Cutter Striker            | 1               |
| 15                                                                           | 63803-5133       | 63803-5133             | Conductor Bushing         | 1               |
| <b>Frame</b>                                                                 |                  |                        |                           |                 |
| 16                                                                           | 19230-0084       | 24854-05               | Slide (Terminal Track)    | 1               |
| 17                                                                           | 63801-2600       | 63801-2600             | Rear Feed Frame           | 1               |
| 18                                                                           | 63801-2603       | 63801-2603             | Base                      | 1               |
| <b>Hardware</b>                                                              |                  |                        |                           |                 |
| 19                                                                           | N/A              | N/A                    | M3 by 10 Long SHCS        | 2**             |
| 20                                                                           | N/A              | N/A                    | M4 by 8 Long SHCS         | 6**             |
| 21                                                                           | N/A              | N/A                    | M4 by 8 Long BHCS         | 1**             |
| 22                                                                           | N/A              | N/A                    | M4 by 10 Long BHCS        | 1**             |
| 23                                                                           | N/A              | N/A                    | M4 by 12 Long SHCS        | 3**             |
| 24                                                                           | N/A              | N/A                    | M6 by 10 Long BHCS        | 6**             |
| 25                                                                           | N/A              | N/A                    | M8 by 20 Long BHCS        | 1**             |
| 26                                                                           | N/A              | N/A                    | 6mm by 10 Long Dowel Pin  | 4**             |
| ** 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 Mini-Mac 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.

**Wear Safety Glasses At All Times.**

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