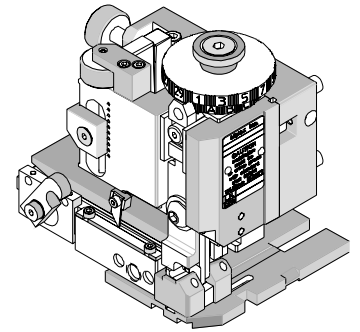




# Mini-Mac Applicator Specification Sheet Order No. 63893-8000



## 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 barrel crimp height and .063mm (.0025") for insulation height. See notes on Page 2.
- Independent adjustment rings allow users to quickly adjust the barrel or insulation crimp height without affecting each other.

## SCOPE

Products: Board-In Crimp Terminal, 22-26 AWG.

Terminal Series No.	Terminal Order No.		Wire Size		Insulation Diameter Max.		Strip Length		PC Board Hole "A" Diameter	
			AWG	mm <sup>2</sup>	mm	In.	mm	In.	mm	In.
42001	40-01-0610	40-08-0605	22-26	0.12-0.35	1.52	.060	4.32-4.83	.170-.190	1.29±.05	.051±.002
	40-02-0601	40-08-0606								

## DEFINITION OF TERMS

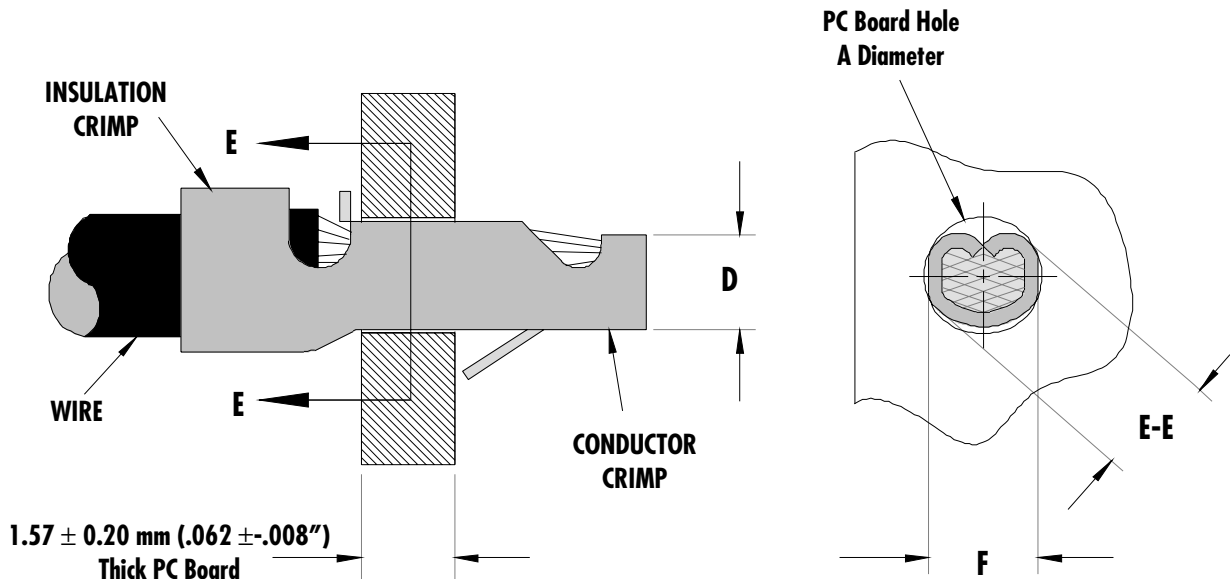


Figure 1

## CRIMP SPECIFICATIONS

After crimping, the conductor profiles should measure the following (See Figure 1).

Terminal Series No.	Wire Size		Dimensions (Figure 1)						Pull Force Min.	
			D Max.		E-E		F (Ref.)			
	AWG	mm <sup>2</sup>	mm	In	mm	In.	mm	In.	N	Lb.
42001	22	0.35	0.97	.038	1.12-1.19	.044-.047	0.97	.038	13.30	3.0
	24	0.20	0.97	.038	1.12-1.19	.044-.047	0.97	.038	13.30	3.0
	26	0.12	0.97	.038	1.12-1.19	.044-.047	0.97	.038	13.30	3.0

- \* The crimp on this terminal is not an electrical crimp; the final soldering operation is the electrical connection. This minimum force is what should be expected when pulling the terminal with both insulation and conductor crimped.

### Notes:

- 1 The Conductor crimp (D dimension on Figure 1) should be set at the maximum height to contain all wire strands, meet minimum pull, and fit into the PCB Hole. The insulation and barrel crimps are adjustable, by the cams (rings) on top of the Mini-Mac ram. The conductor crimp height is not adjustable. Shimming may be required of the conductor punch to optimize this for different wire types.

**PARTS LIST**

<b>Mini-Mac Applicator 63893-8000</b>				
<b>Item</b>	<b>Order No</b>	<b>Engineering No.</b>	<b>Description</b>	<b>Quantity</b>
<b>Perishable Tooling</b>				
	63893-8070	63893-8070	Tool Kit (All "Y" Items)	REF
1	11-18-4664	60757A104	Conductor Punch	1 Y
2	11-18-4662	60757A102	Combination Anvil	1 Y
3	11-18-4663	60757A103	Insulation Punch	1 Y
4	11-18-4661	60757A101	Barrel Form Punch	1 Y
5	11-18-4665	60757A105	Cut-Off Plunger and Wire Stop	1 Y
6	11-18-4666	60757A106	Rear Plunger Retainer	1 Y
7	11-18-4652	60758A107	Front Cut-Off Plunger	1 Y
8	11-18-4653	60758A108	Front Plunger Retainer	1 Y
<b>Other Components (REF 938050)</b>				
9	11-18-4034	60705A108	Front Plunger Striker	1
10	11-18-4083	60707-8	Feed Guide	1
11	11-18-4643	60755A108	Gathering Bar Spring	1
12	11-18-4654	60758A109	Tooling Washer	1
13	11-18-4667	60757A107	Rear Plunger Striker	1
14	11-18-4721	60757A114	Gathering Bar	1
15	11-24-1067	4996-4	Cut-off Plunger Spring	2
16	63443-6111	63443-6111	Rear Cover	1
17	63803-5116	63803-5116	Conductor Bushing	1
<b>Frame</b>				
18	63801-3201	63801-3201	Top	1
19	63801-3282	63801-3282	Base	1
20	63801-6550	63801-6550	Track	1
<b>Hardware</b>				
21	N/A	N/A	M3 by 8 Long SHCS	2**
22	N/A	N/A	M4 by 10 Long BHCS	2**
23	N/A	N/A	M4 by 16 Long SHCS	2**
24	N/A	N/A	M8 by 20 Long BHCS	1**
25	N/A	N/A	#6-32 by 3/8" Long BHCS	1**
26	N/A	N/A	#6-32 by 5/8" Long SHCS	2**
27	N/A	N/A	#8-32 by 3/8" Long BHCS	4**
** Available from an industrial supply company such as MSC (1-800-645-7270).				

# Assembly Drawing

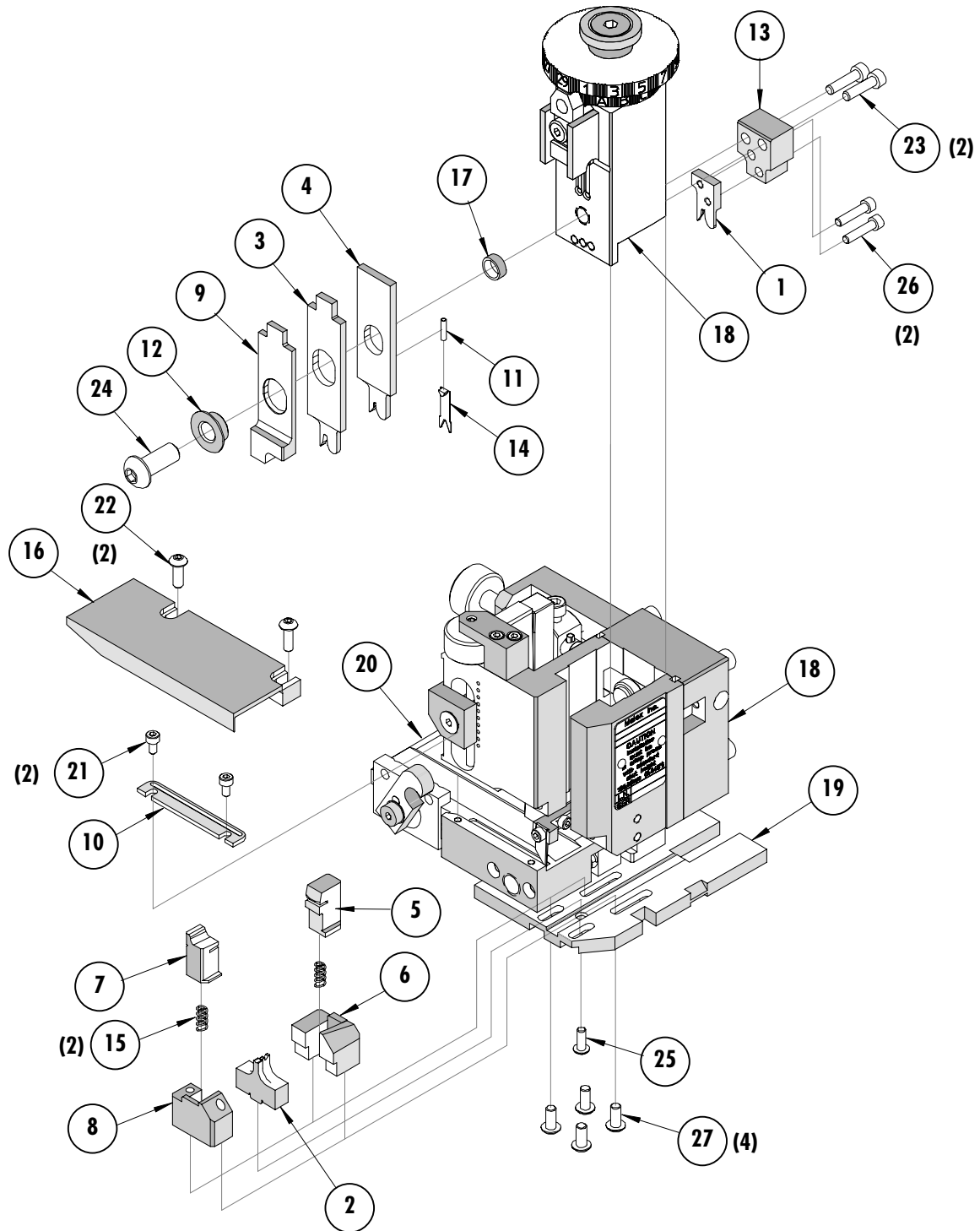


Figure 1

## 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 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.

## Contact Information

For more information on Molex application tooling please contact Molex at 1-800-786-6539.

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