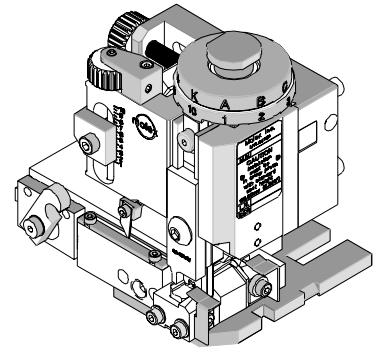




# Mini-Mac Applicator Application Tooling Specification Mechanical Feed Dual Carrier Metal Strip Order No. 63832-1000



## FEATURES

- █ Directly adapts to most crimp presses and automatic wire processors
- █ Applicator designed to industry-standard mounting and shut height of 135.80mm (5.346")
- █ Conductor and insulation rings allow quick adjustment for conductor and insulation crimp height change
- █ Quick set-up time; plus the crimp height, track and feed adjustments can be set without removing the applicator from the crimp press

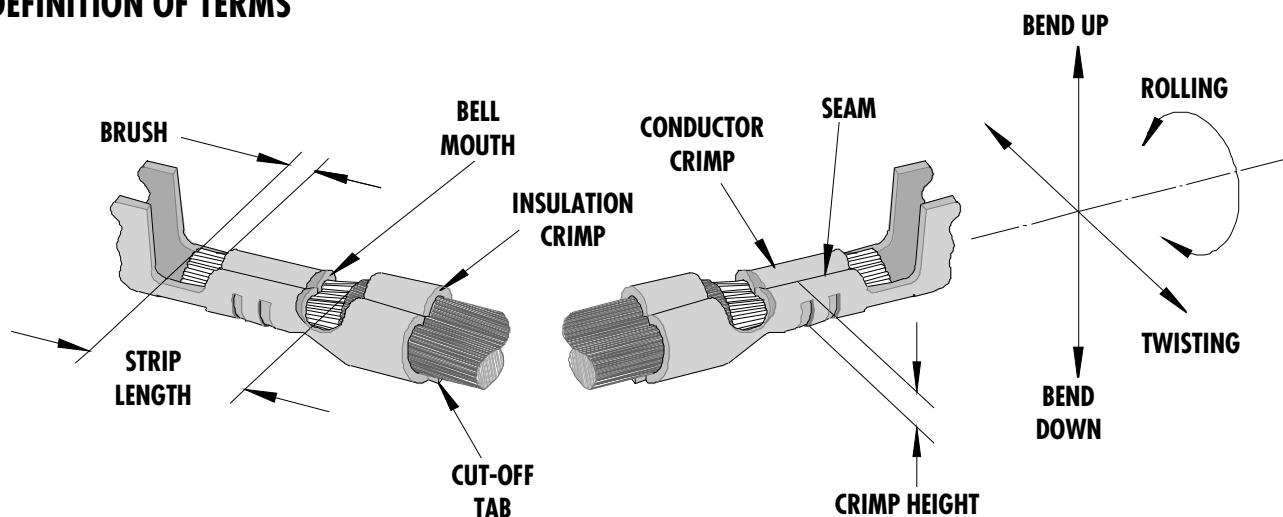
## SCOPE

Terminal Series No.	Wire Size		Insulation Diameter Max.		Strip Length	
	AWG	mm <sup>2</sup>	mm	In.	mm	In.
42824-4002	*	*	4.20	.165	4.34-5.15	.171-.203
42824-4005	*	*	4.20	.165	4.34-5.15	.171-.203
42825-4002	*	*	4.20	.165	4.34-5.15	.171-.203
42825-4005	*	*	4.20	.165	4.34-5.15	.171-.203

**Terminal will accommodate the following wire specification:**  
\* THHN stranded wires and TFN solid bare wires

\* These terminals require two different applicators depending on the wire combinations to be produced.  
Applicator 63832-1000 produces: single wire 12; double wire 12+18.  
Applicator 63832-1100 produces: single wire 10; double wire 12+16, 10+18, and 12+12.

## DEFINITION OF TERMS



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

**CRIMP SPECIFICATION**

Terminal Series No.	Bell mouth		Cut-off Tab Max.				Conductor Brush	
			Front		Rear			
	mm	In.	mm	In.	mm	In.	mm	In.
42824-4002	0.20-0.60	.008-.024	0.60	.024	0.38	.015	1.00-1.50	.039-.059
42824-4005	0.20-0.60	.008-.024	0.60	.024	0.38	.015	1.00-1.50	.039-.059
42825-4002	0.20-0.60	.008-.024	0.60	.024	0.18	.007	1.00-1.50	.039-.059
42825-4005	0.20-0.60	.008-.024	0.60	.024	0.18	.007	1.00-1.50	.039-.059

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		Insulation		
	mm	In	mm	In	mm	In	mm	In	
42824-4002	3	3	4	8	3.80	.150	4.80	.189	
42824-4005	3	3	4	8	3.80	.150	4.80	.189	
42825-4002	3	3	4	8	3.80	.150	4.80	.189	
42825-4005	3	3	4	8	3.80	.150	4.80	.189	

After crimping, the crimp profiles should measure the following:

Terminal Series No.	Wire Size		Conductor				Insulation				Pull Force Min.	
			Crimp Height		Crimp Width (Ref)		Crimp Height (Ref)		Crimp Width (Ref)			
	AWG	mm <sup>2</sup>	mm	In.	mm	In.	mm	In.	mm	In.	N	Lb.
42824-4002	12	3.31	2.01-2.11	.079-.083	3.80-4.00	.150-.158	4.20 max	.165 max	5.00 max	.197 max	311.5	70.0
42824-4002	12+18	3.31+0.82	2.01-2.11	.079-.083	3.80-4.00	.150-.158	4.20 max	.165 max	5.00 max	.197 max	89.0	20.0
42824-4005	12	3.31	2.01-2.11	.079-.083	3.80-4.00	.150-.158	4.20 max	.165 max	5.00 max	.197 max	311.5	70.0
42824-4005	12+18	3.31+0.82	2.01-2.11	.079-.083	3.80-4.00	.150-.158	4.20 max	.165 max	5.00 max	.197 max	89.0	20.0
42825-4002	12	3.31	2.01-2.11	.079-.083	3.80-4.00	.150-.158	4.20 max	.165 max	5.00 max	.197 max	311.5	70.0
42825-4002	12+18	3.31+0.82	2.01-2.11	.079-.083	3.80-4.00	.150-.158	4.20 max	.165 max	5.00 max	.197 max	89.0	20.0
42825-4005	12	3.31	2.01-2.11	.079-.083	3.80-4.00	.150-.158	4.20 max	.165 max	5.00 max	.197 max	311.5	70.0
42825-4005	12+18	3.31+0.82	2.01-2.11	.079-.083	3.80-4.00	.150-.158	4.20 max	.165 max	5.00 max	.197 max	89.0	20.0

Pull Force should be measured with no influence from the insulation crimp.

The above specifications are guidelines to an optimum crimp.

\* This applicator was qualified to the above specifications with THHN stranded wires and TFN solid bare wires.

\* All Applications exceeding 12 AWG singles, consult Molex Product Engineering.

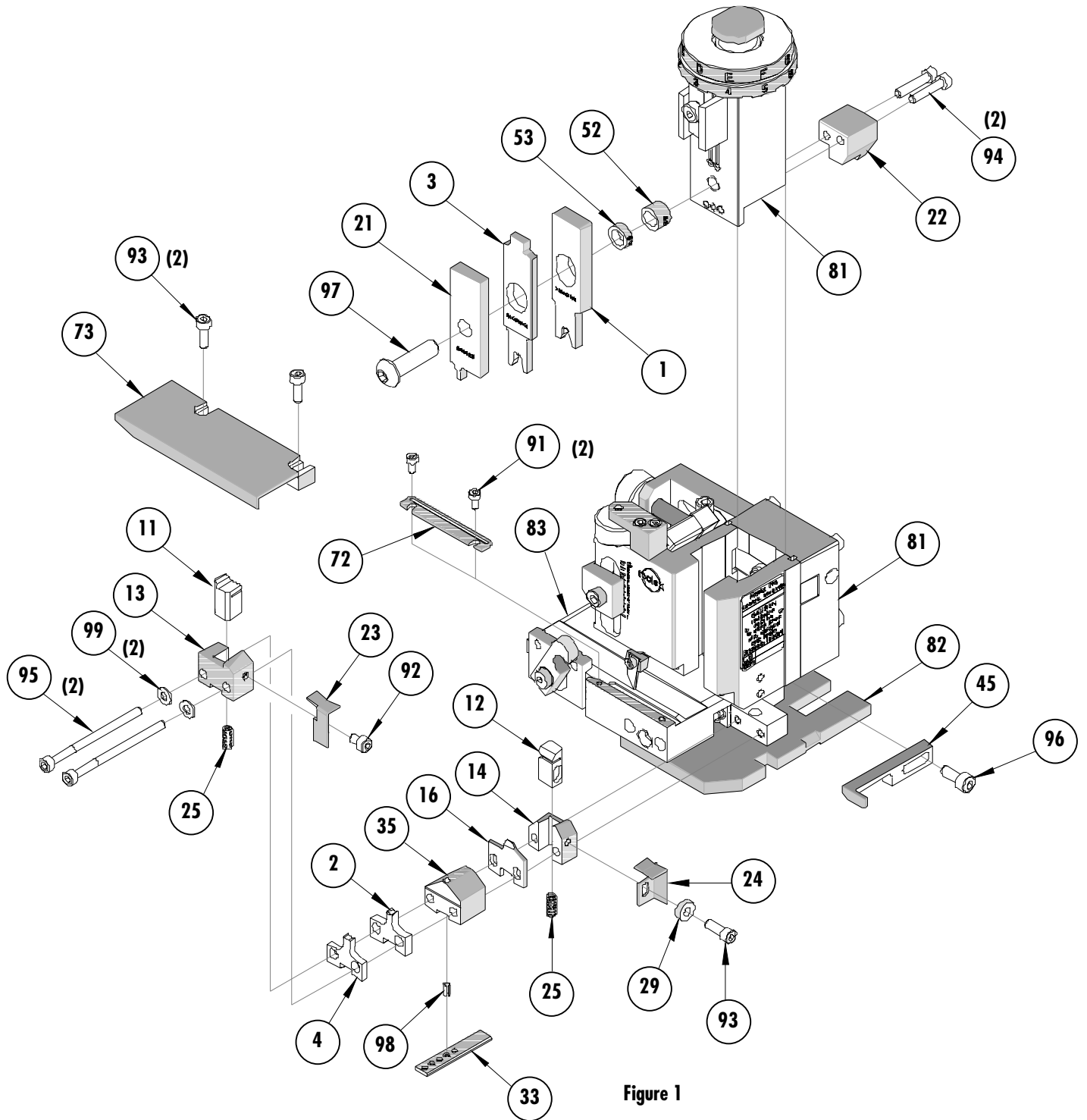
\* Crimping double wires or exceeding maximum insulation diameter specifications may cause terminal insulation grips to score or pierce thru wire insulation.

\* To achieve optimum performance on double wire applications, smallest wire AWG and solid wire should be positioned in the bottom of the terminal.

**PARTS LIST**

<b>Mini-Mac Applicator 63832-1000</b>				
<b>Item</b>	<b>Order No</b>	<b>Engineering No.</b>	<b>Description</b>	<b>Quantity</b>
<b>Perishable Tooling</b>				
	63832-1070	63832-1070	Tool Kit (All "Y" Items)	REF
1	63473-0001	63473-0001	Conductor Punch	1 Y
2	63445-3862	63445-3862	Conductor Anvil	1 Y
3	63471-0011	63471-0011	Insulation Punch	1 Y
4	63445-4809	63445-4809	Insulation Anvil	1 Y
11	63443-0035	63443-0035	Cut-off Plunger Front	1 Y
12	63466-0201	63466-0201	Cut-off Plunger Rear	1 Y
13	63443-0036	63443-0036	Plunger Retainer Front	1 Y
14	63466-0301	63466-0301	Plunger Retainer Rear	1 Y
16	63443-1401	63443-1401	Cut-off Blade Rear	1 Y
<b>Other Components (REF 21050)</b>				
21	63466-0504	63466-0504	Cut-off Plunger Striker Front	1
22	63466-0405	63466-0405	Cut-off Plunger Striker Rear	1
23	63443-0009	63443-0009	Scrap Chute Front	1
24	63466-0101	63466-0101	Scrap Chute Rear	1
25	63700-0539	63700-0539	Cut-Off Plunger Spring	2
29	63600-0110	63600-0110	M4 Washer, 3 mm Thick	1
33	63443-0023	63443-0023	Lower Tooling Key	1
35	63443-2127	63443-2127	Spacer Front	1
45	63443-0061	63443-0061	Wire Stop	1
52	63443-0062	63443-0062	Collar-8.00 Lg.	1
53	63890-0995	63890-0995	Collar-4.05 Lg.	1
72	11-18-4083	60707-8	Feed Guide	1
73	63443-6130	63443-6130	Rear Cover	1
<b>Frame</b>				
81	63801-3201	63801-3201	Mechanical Feed Applicator Frame Head	REF
82	63801-3281	63801-3281	Base	REF
83	63801-4650	63801-4650	Track Assembly	REF
<b>Hardware</b>				
91	N/A	N/A	M3 by 6 Lg. SHCS	2**
92	N/A	N/A	M4 by 6 Lg SHCS	1**
93	N/A	N/A	M4 by 12 Lg SHCS	3**
94	N/A	N/A	M4 by 20 Lg SHCS	2**
95	N/A	N/A	M4 by 60 Lg. SHCS	2**
96	N/A	N/A	M5 by 12 Lg. SHCS	1**
97	N/A	N/A	M8 by 30 Lg. BHCS	1**
98	N/A	N/A	3mm by 6 Lg. Roll Pin	1**
99	N/A	N/A	M4 Flat Washer	2**
** 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 with 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 Applicator Manual (Document no. 63880-0000).

**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.

### Molex Application Tooling Group

1150 E. Diehl Road  
Naperville, IL 60563  
Tel: (630) 969-4550  
Fax: (630) 505-0049

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