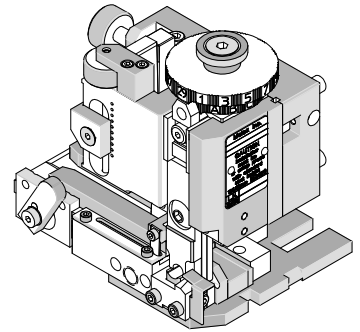




Mini-Mac Applicator Application Tooling Specification Mechanical Feed-Front Metal Strip Order No. 63895-1100



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.

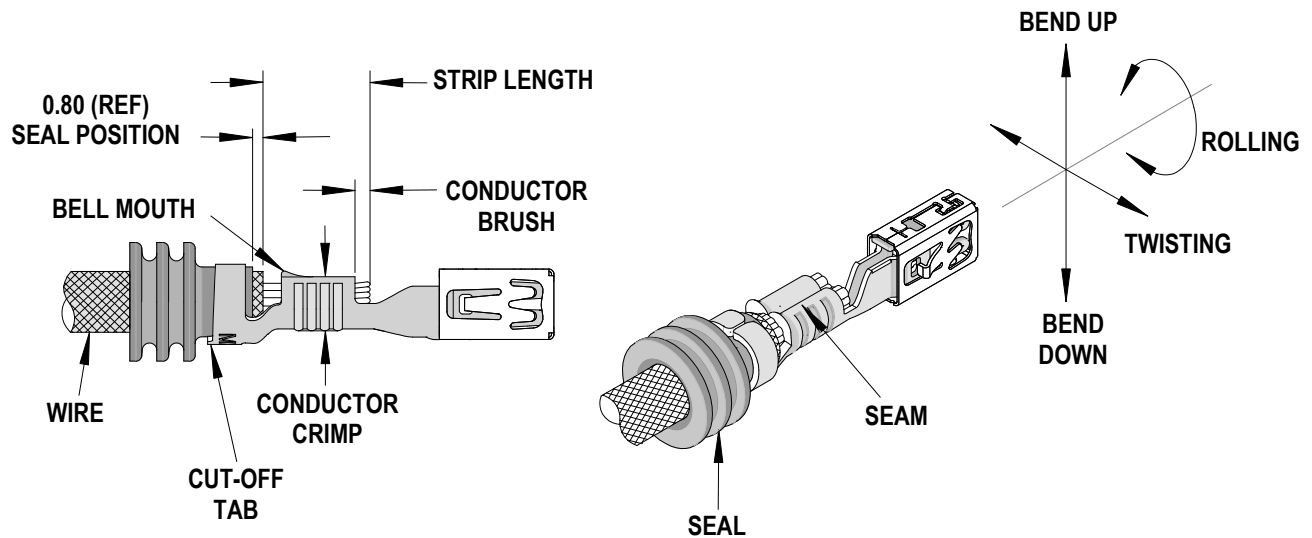
SCOPE

Products: CP2.8 and CPX2.8 Receptacle Crimp Terminals, >1.00-2.00 mm² type ID and IR wire.

| Terminal Series No. | Terminal Order No. | | Wire Size and Type | | ✗ Insulation Diameter | | Strip Length | |
|---------------------|--------------------|------------|--------------------|-----------|-----------------------|-----------|--------------|-----------|
| | | | mm ² | Type | mm | In. | mm | In. |
| 98910 | 98910-1039 | 98910-1139 | >1.00 – 2.00 | ID and IR | 2.10-2.80 | .083-.110 | 4.90-5.10 | .193-.201 |
| | 98910-2039 | 98910-2139 | | | | | | |
| 64324 | 64324-1039 | 64324-1139 | >1.00 – 2.00 | ID and IR | 2.10-2.80 | .083-.110 | 4.90-5.10 | .193-.201 |
| | 64324-2039 | 64324-2139 | | | | | | |

✗ See crimp specification for the individual Insulation Diameter.

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 Maximum | | *Conductor Brush | |
|--|------------|-----------|---------------------|------|------------------|-----------|
| | mm | In. | mm | In. | mm | In. |
| 98910 | 0.40-0.60 | .016-.024 | 0.30 | .012 | 0.20-0.60 | .008-.024 |
| 64324 | 0.40-0.60 | .016-.024 | 0.30 | .012 | 0.20-0.60 | .008-.024 |
| *Not to exceed above the conductor crimp height. | | | | | | |

| 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 | |
| 98910 | 2 | 2 | 2 | 3 | 2.50 | .098 | 4.85 | .191 | |
| 64324 | 2 | 2 | 2 | 3 | 2.50 | .098 | 4.85 | .191 | |

After crimping, the crimp profiles should measure the following:

| Terminal Series No. | Wire Size mm ² | Conductor | | | | Pull Force Minimum | |
|---------------------|------------------------------|--------------|-----------|--------------------|------|--------------------|------|
| | | Crimp Height | | Crimp Width (Ref.) | | N | Lb. |
| | | mm | In. | mm | In. | | |
| 98910 | 1.50 | 1.40-1.50 | .055-.059 | 2.57 | .101 | 155.0 | 34.8 |
| | 2.00 | 1.50-1.60 | .059-.063 | 2.58 | .102 | 195.0 | 43.8 |
| 64324 | 1.50 | 1.40-1.50 | .055-.059 | 2.57 | .101 | 155.0 | 34.8 |
| | 2.00 | 1.50-1.60 | .059-.063 | 2.58 | .102 | 195.0 | 43.8 |

| Terminal Series No. | Wire Size mm ² | *Insulation Diameter | | Single Wire Seal | | Insulation | | | |
|---------------------|------------------------------|----------------------|-----------|------------------|-------|--------------|-----------|--------------------|------|
| | | mm | In. | Order No. | Color | Crimp Height | | Crimp Width (Ref.) | |
| | | | | | | mm | In. | mm | In. |
| 98910 | 1.50 | 2.10-2.40 | .083-.094 | 0643251175 | Green | 4.25-4.45 | .167-.175 | 4.96 | .195 |
| | 2.00 | 2.50-2.80 | .098-.110 | | | 4.65-4.85 | .183-.191 | 5.00 | .197 |
| 64324 | 1.50 | 2.10-2.40 | .083-.094 | 0643251175 | Green | 4.25-4.45 | .167-.175 | 4.96 | .195 |
| | 2.00 | 2.50-2.80 | .098-.110 | | | 4.65-4.85 | .183-.191 | 5.00 | .197 |

*** Tool Qualification Notes:**

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

PARTS LIST

| Mini-Mac Applicator 63895-1100 | | | | |
|---------------------------------------|-----------------|------------------------|------------------------------|-----------------|
| Item | Order No | Engineering No. | Description | Quantity |
| Perishable Tooling | | | | |
| | 63895-1170 | 63895-1170 | Tool Kit (All "Y" Items) | REF |
| 1 | 63465-0059 | 63465-0059 | Conductor Punch | 1 Y |
| 2 | 63455-0062 | 63455-0062 | Conductor Anvil | 1 Y |
| 3 | 63463-0038 | 63463-0038 | Insulation Punch | 1 Y |
| 4 | 63456-0055 | 63456-0055 | Insulation Anvil | 1 Y |
| 5 | 63443-0037 | 63443-0037 | Cut-off Plunger Front | 1 Y |
| 6 | 63443-0038 | 63443-0038 | Plunger Retainer Front | 1 Y |
| Other Components | | | | |
| 7 | 11-18-4094 | 60709A111 | Feed Guide | 1 |
| 8 | 63443-0009 | 63443-0009 | Scrap Chute Front | 1 |
| 9 | 63443-0024 | 63443-0024 | Key | 1 |
| 10 | 63443-0090 | 63443-0090 | Wire Stop | 1 |
| 11 | 63443-1712 | 63443-1712 | 18.20mm Height Spacer | 1 |
| 12 | 63443-2201 | 63443-2201 | 1.00mm Course Spacer | 1 |
| 13 | 63443-2214 | 63443-2214 | 14.00mm Course Spacer | 1 |
| 14 | 63443-2312 | 63443-2312 | 3.60mm Fine Spacer | 1 |
| 15 | 63443-6121 | 63443-6121 | Rear Cover | 1 |
| 16 | 63443-3701 | 63443-3701 | Striker Screw | 1 |
| 17 | 63443-3801 | 63443-3801 | Front Plunger Striker | 1 |
| 18 | 63700-0225 | 63700-0225 | Compression Spring | 1 |
| 19 | 63700-0539 | 63700-0539 | Cut-Off Plunger Spring | 1 |
| 20 | 63890-0063 | 63890-0063 | Terminal Hold Down-For CP2.8 | 1 |
| 21 | 63890-0067 | 63890-0067 | Holder Front | 1 |
| 22 | 63890-0068 | 63890-0068 | Holder Rear | 1 |
| 23 | 63890-0866 | 63890-0866 | Collar-6.40 Long | 2 |
| Frame | | | | |
| 24 | 63801-3201 | 63801-3201 | Top | 1 |
| 25 | 63801-3281 | 63801-3281 | Base | 1 |
| 26 | 63801-4650 | 63801-4650 | Track | 1 |
| Hardware | | | | |
| 27 | N/A | N/A | M3 by 5 Long Flat Point SSS | 2** |
| 28 | N/A | N/A | M3 by 6 Long FHCS | 1** |
| 29 | N/A | N/A | M3 by 6 Long SHCS | 2** |
| 30 | N/A | N/A | M3 by 10 Long SHCS | 1** |
| 31 | N/A | N/A | M4 by 6 Long SHCS | 2** |
| 32 | N/A | N/A | M4 by 12 Long BHCS | 2** |
| 33 | N/A | N/A | M4 by 16 Long SHCS | 2** |
| 34 | N/A | N/A | M4 by 55 Long SHCS | 2** |
| 35 | N/A | N/A | M5 by 12 Long SHCS | 1** |
| 36 | N/A | N/A | M8 by 30 Long BHCS | 1** |
| 37 | N/A | N/A | 2mm by 8 Long Dowel Pin | 1** |

** Available from an industrial supply company such as MSC (1-800-645-7270).

Assembly Drawing

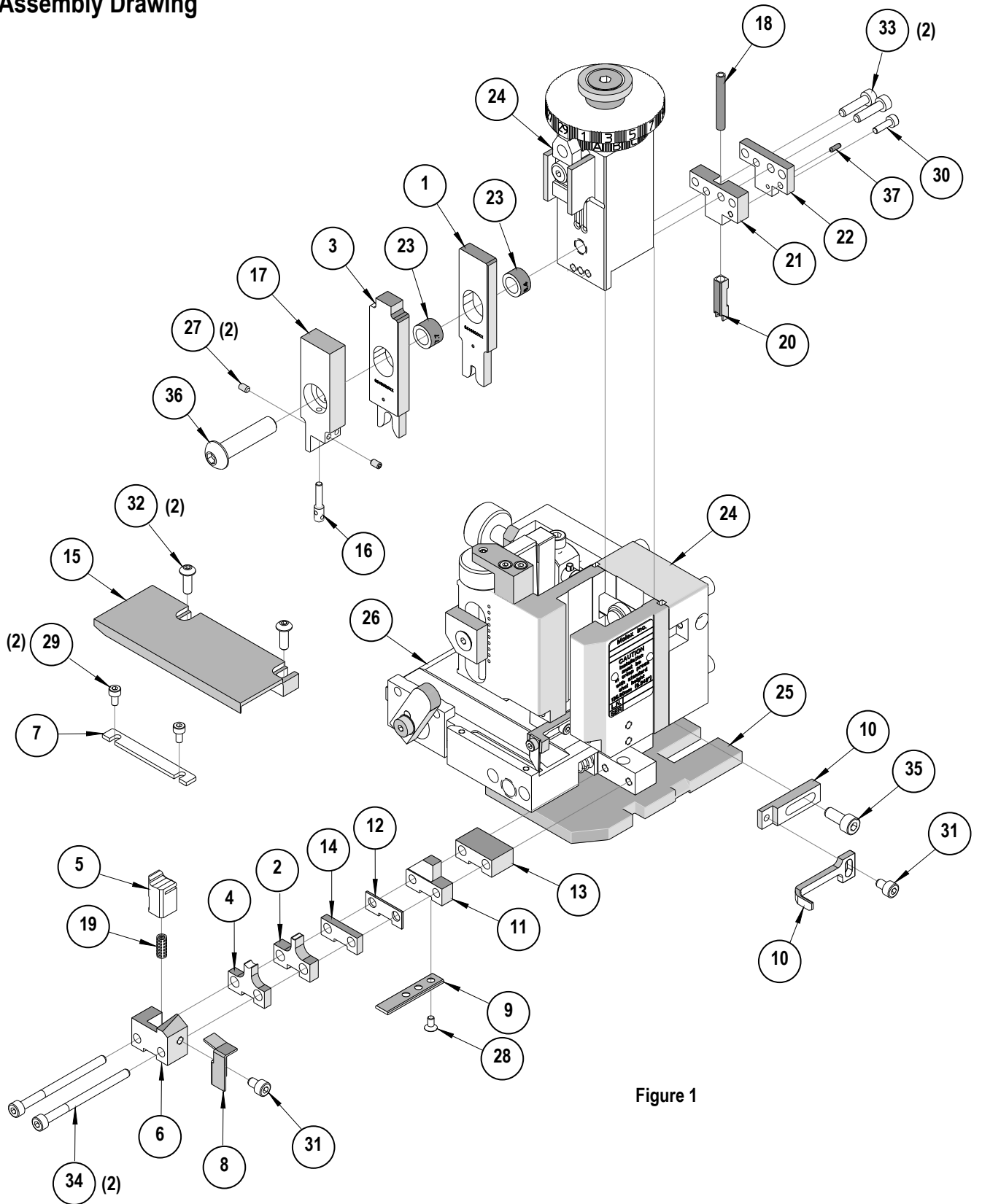


Figure 1

NOTES

1. Molex recommends an extra perishable tooling kit be maintained at your facility.
2. Verify tooling alignment by manually cycling the press 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

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