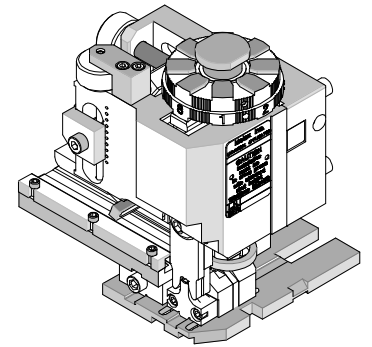




Mini-Mac Applicator Specification Sheet Part No. 63803-1000



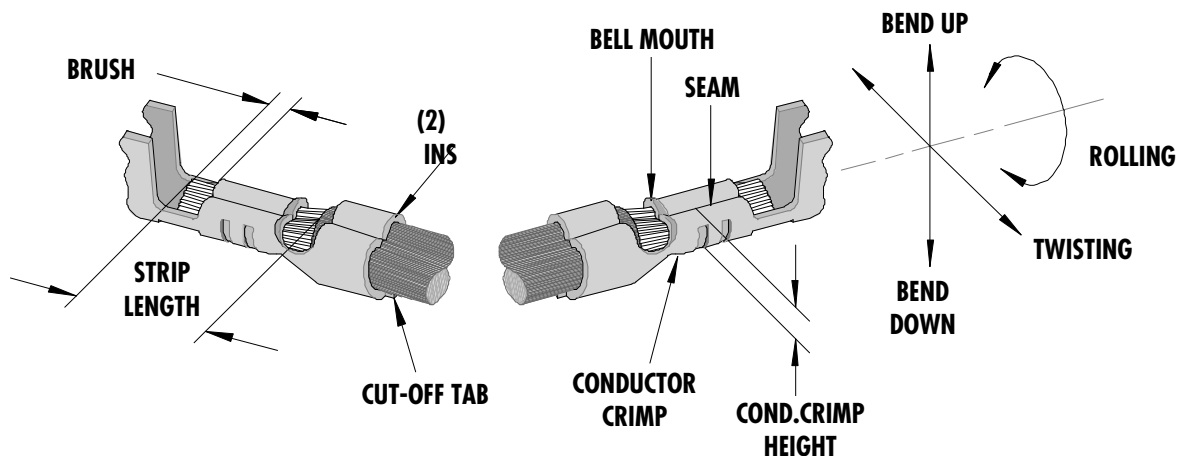
FEATURES

- Quick set-up time; plus the crimp height, track and feed adjustments can be preset in applicator
- Conductor and insulation rings allow quick adjustment for conductor and insulation diameter change
- Applicator designed to industry standard mounting and shut height 135.80mm (5.346")
- Directly adapts to most automatic wire processing machines

SCOPE

Terminal Series No.	Terminal Order No	Wire Size		Insulation Diameter		Strip Length	
		AWG	mm ²	mm	In.	mm	In.
41422-3A2N5A1	40-02-1601	10-13	5.00-2.50	4.52	.178	5.08-5.84	.200-.230
41422-4001	41422-4001	10-13	5.00-2.50	4.52	.178	5.08-5.84	.200-.230

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 Series No.	Bell mouth		Cut-off Tab Max.		Conductor Brush	
	mm	In.	mm	In.	mm	In.
41422-3A2N5A1	N/A	N/A	3.30 Max.	.13 Max.	N/A	N/A
41422-4001	N/A	N/A	3.30 Max.	.13 Max.	N/A	N/A

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	
41422-3A2N5A1	N/A	N/A	N/A	N/A	3.80	.150	5.10.	.200	
41422-4001	N/A	N/A	N/A	N/A	3.80	.150	5.10.	.200	

After crimping, the conductor profile should measure the following.

Terminal Series No.	Wire Size		Crimp Height		Pull Force Min.	
	AWG	mm ²	mm	In.	N	Lb.
41422-3A2N5A1	10	5.00	2.59-2.64	.102-.104	355.9	80.0
41422-3A2N5A1	12	3.00	2.36-2.41	.093-.095	311.4	70
41422-3A2N5A1	13	2.50	2.23-2.33	.088-.092	266.9	60.0
41422-4001	10	5.00	2.59-2.64	.102-.104	355.9	80.0
41422-4001	12	3.00	2.36-2.41	.093-.095	311.4	70
41422-4001	13	2.50	2.23-2.33	.088-.092	266.9	60.0

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

The above specifications are guidelines to an optimum crimp.

PARTS LIST

Mini-Mac Applicator 63803-1000				
Item	Order No	Engineering No.	Description	Quantity
Perishable Tooling				
	63803-1070	63803-1070	Tool Kit (All "Y" Items)	REF.
1	11-18-4448	60739A101	Conductor Punch	1 Y
2	11-18-4449	60739A102	Combination Anvil	1 Y
3	11-18-4450	60739A103	Insulation Punch	1 Y
4	11-18-4451	60739A104	Cut-Off Plunger	1 Y
5	11-18-4452	60739A105	Plunger Retainer	1 Y
6	11-18-4454	60739A107	Pilot Pin	1 Y
7	11-18-4457	60739A110	Cut-off Die Blade	1 Y
Other Components				
8	11-24-1067	4996-4	Cut-Off Plunger Spring	1
9	11-18-4453	60739A106	Rear Plunger Striker	1
10	11-18-4455	60739A108	Terminal Hold Down	1
11	11-18-4456	60739A109	Hold Down Spring	1
12	11-18-4458	60739A111	Spacer	1
13	11-18-4459	60739A112	Rear Cover	1
14	11-18-4462	60739A115	Front Cover	1
15	11-18-4467	60739A117	Tooling Washer	1
16	11-18-4472	60739A118	Terminal Hold Down Assembly	REF
17	11-18-4816	60800A112	Drag Frame Cover	1
18	11-18-5012	60804A123	Wire Stop	1
19	11-18-0132	60700-33	Terminal Drag Spring	2
Frame				
20	63800-0100	63800-0100	Mini-Mac Frame Assembly	1
21	11-18-4460	60739A113	Terminal Track	1
22	11-18-4461	60739A114	Track Base	1
23	11-18-4680	60756A113	Drag Frame	1
24	63800-0115	63800-0115	Spacer Tube	1
25	63800-0313	63800-0313	Drag Cam	1
26	69028-0806	69028-0806	Conductor Adjustment Cam	1
Hardware				
27	N/A	N/A	#4-40 by 1/2 Lg. SHCS	3**
28	N/A	N/A	#6-32 by 3/8 Lg. BHCS	1**
29	N/A	N/A	#6-32 by 1/4 Lg. SHCS	2**
30	N/A	N/A	#6-32 by 3/4 Lg. SHCS	2**
31	N/A	N/A	#8-32 by 3/8 Lg. BHCS	4**
32	N/A	N/A	#8-32 by 1/4 Lg. SSS (Flat Pt.)	1**
33	N/A	N/A	#10-32 by 3/8 Lg. SHCS	2**
34	N/A	N/A	#10-32 by 1/4 Lg. BHCS	1**
35	N/A	N/A	3/64" by 5/8" Lg. Spirol Pin	2**
36	N/A	N/A	5/64" by 3/8" Roll Pin	1**
37	N/A	N/A	M4 by 22 Lg. SHCS	2**
38	N/A	N/A	M5 by 8 Lg. SHCS	1**
39	N/A	N/A	M8 by 25 Lg. BHCS	1**

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

Assembly Drawing

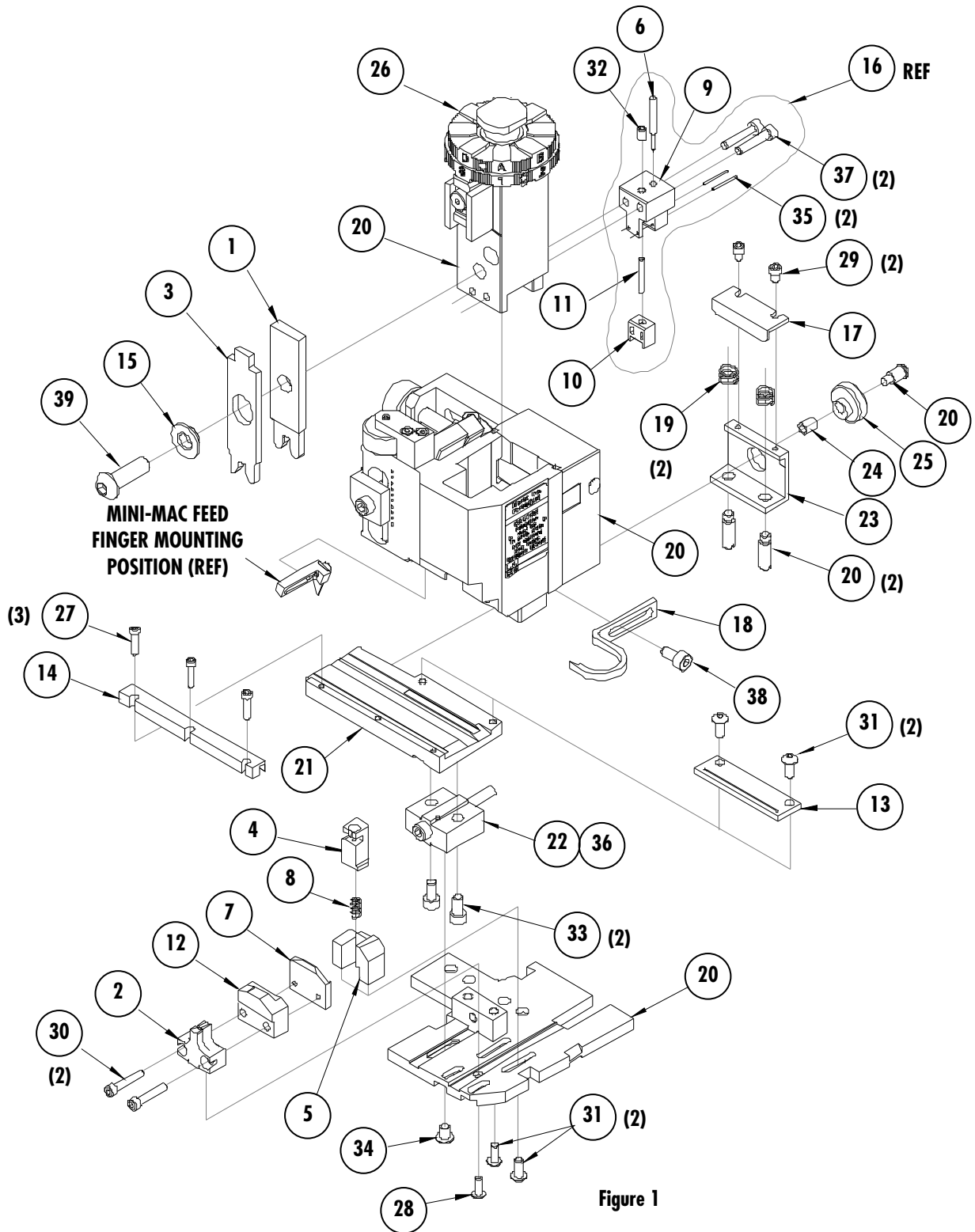


Figure 1

NOTES

1. Molex recommends an extra perishable tooling kit be maintained at your facility.
2. Verify tooling alignment by manually cycling the press 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 135.8 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.

Molex Application Tooling Group

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