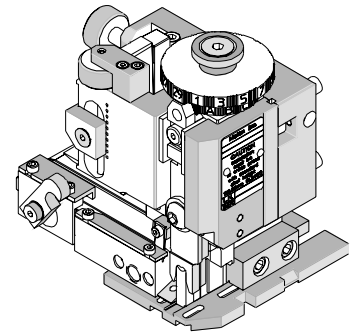




# Mini-Mac Applicator Specification Sheet Order No. 63893-1000



## FEATURES

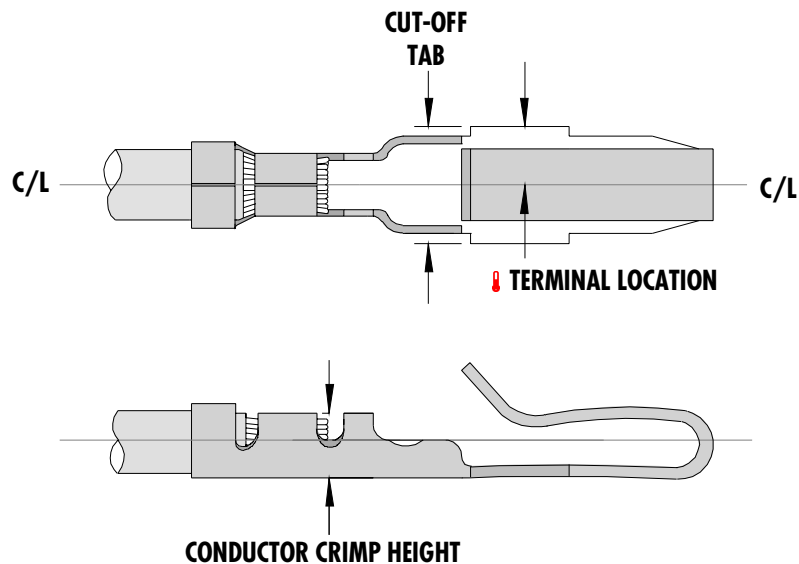
- Directly adapts to most automatic wire processing machines
- Applicator designed to industry standard mounting and shut height 135.80mm (5.346")
- Quick set-up time; plus the crimp height, track and feed adjustments can be set without removing the applicator from the press
- Fine adjustment allows 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: Flat Blade Male Crimp Terminal 12-20 AWG.

Terminal Series No.	Terminal Order No.	Wire Size		Insulation Diameter		Strip Length	
		AWG	mm <sup>2</sup>	mm	In.	mm	In.
2697	05-01-0064	12-20	3.30-0.50	5.80 Max.	.230 Max.	4.20	.165

## DEFINITION OF TERMS



 Terminal is to be centrally located between the two (2) cut-off tab edges by one half of the total cut-off tab tolerance. This illustration is a generic terminal representation and not an exact image of any terminal listed in the scope.

## CRIMP SPECIFICATIONS

Terminal Series No.	Bell mouth		🔪 Cut-off Tab		Conductor Brush	
	mm	In.	mm	In.	mm	In.
2697			6.27-6.43	.247-.253		

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	Degree	Degree	Conductor		Insulation		
					mm	In.	mm	In.	
2697					3.10	.122	6.45	.254	

**NOTE:** Some of the specifications in these charts above are intentionally left blank due to the fact that the information does not currently exist.

After crimping, the conductor profile should measure the following.

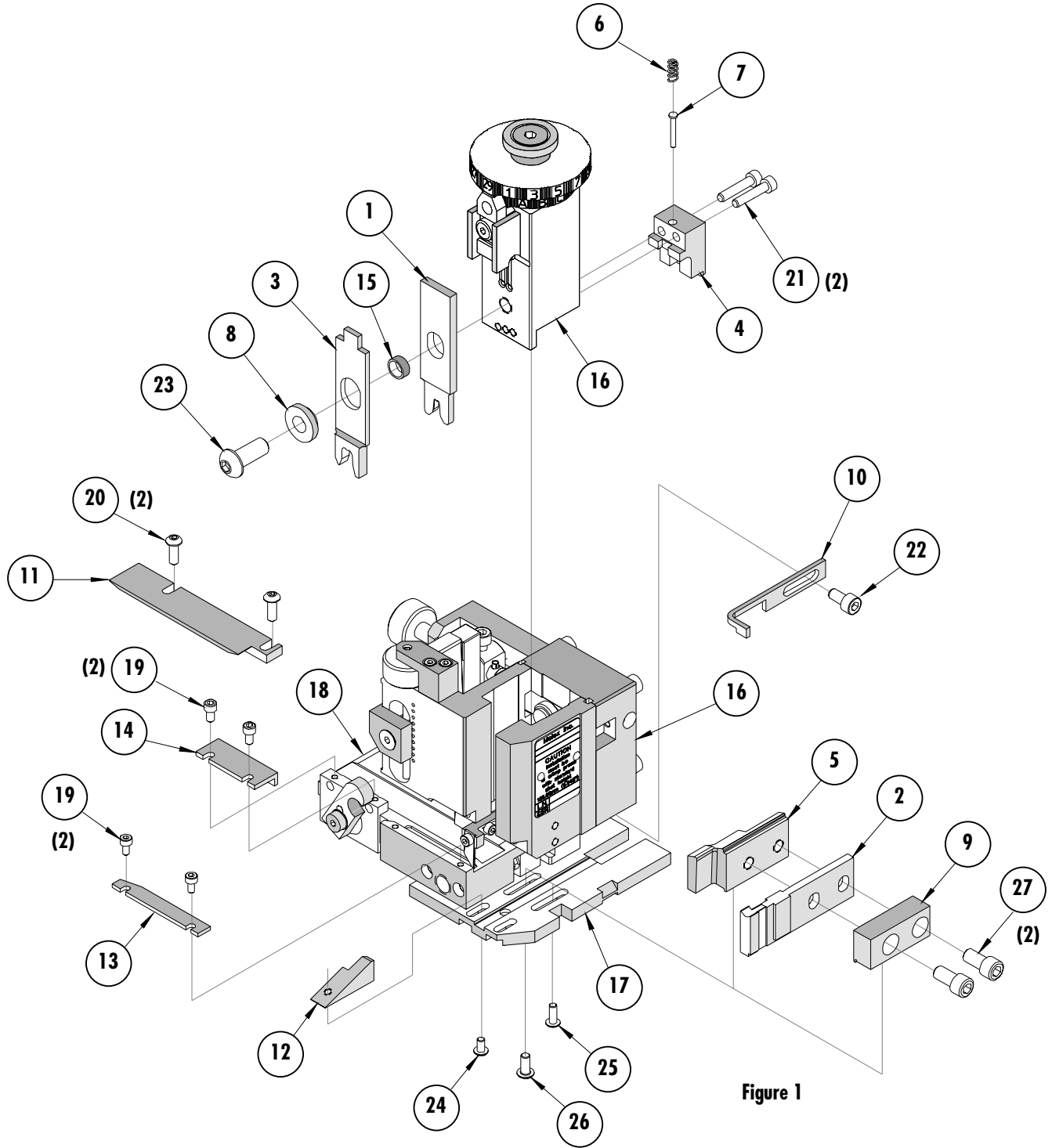
Terminal Series No.	Wire Size		Conductor				Pull Force Minimum	
	AWG	mm <sup>2</sup>	Crimp Height		Crimp Width (REF)		N	Lb.
			mm	In.	mm	In.		
2697	12	3.30	1.83-1.88	.072-.074			311.4	70.0
	14	2.00	1.73-1.78	.068-.070			258.0	58.0
	16	1.30	1.63-1.68	.064-.066			200.2	45.0
	18	0.80	1.52-1.57	.060-.062			155.7	35.0

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

**PARTS LIST**

<b>Mini-Mac Applicator 63893-1000</b>				
<b>Item</b>	<b>Order No</b>	<b>Engineering No.</b>	<b>Description</b>	<b>Quantity</b>
<b>Perishable Tooling</b>				
	63893-1070	63893-1070	Tool Kit (All "Y" Items)	REF
1	11-18-4565	60742A106	Conductor Punch	1 Y
2	11-18-4579	60742A115	Combination Anvil	1 Y
3	11-18-4578	60742A109	Insulation Punch	1 Y
4	11-18-4577	60742A122	Cut-Off Punch	1 Y
5	11-18-4781	60742A140	Cut-off Die Plate	1 Y
<b>Other Components (REF 931050)</b>				
6	11-17-0094	1739-37	Compression Spring	1
7	11-18-4422	60706-28	Hold Down Plunger	1
8	11-18-4573	60742A117	Insulation Punch Spacer	1
9	11-18-4574	60742A118	Strip and Wire Stop Holder	1
10	11-18-4575	60742A119	Wire Stop and Stripper	1
11	11-18-4598	60742A126	Rear Cover	1
12	11-18-4599	60742A127	Slug Ramp	1
13	11-18-5015	60805A122	Front Cover	1
14	63801-6561	63801-6561	Terminal Drag Plate	1
15	63803-5104	63803-5104	Conductor Bushing	1
<b>Frame</b>				
16	63801-3201	63801-3201	Top	1
17	63801-3282	63801-3282	Base	1
18	63801-6550	63801-6550	Track	1
<b>Hardware</b>				
19	N/A	N/A	M3 by 6 Long SHCS	4**
20	N/A	N/A	M4 by 12 Long BHCS	2**
21	N/A	N/A	M4 by 16 Long SHCS	2**
22	N/A	N/A	M5 by 10 Long SHCS	1**
23	N/A	N/A	M8 by 20 Long BHCS	1**
24	N/A	N/A	#6-32 by 1/4" Long BHCS	1**
25	N/A	N/A	#6-32 by 3/8" Long BHCS	1**
26	N/A	N/A	#8-32 by 3/8" Long BHCS	1**
27	N/A	N/A	#1/4-28 by 1/2" Long SHCS	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 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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