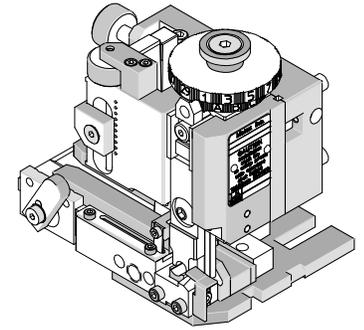




# Mini-Mac Applicator Specification Sheet Order No. 63893-2000



## FEATURES

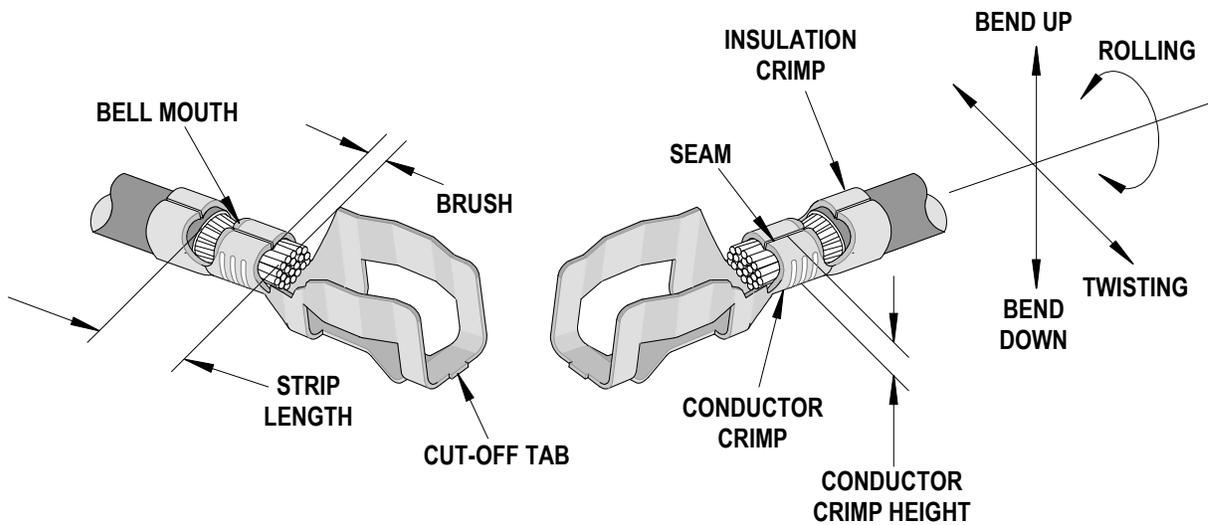
- Directly adapts to most automatic wire processing machines
- Applicator designed to industry standard mounting and shut height 135.80mm (5.346")
- Quick set-up time; plus the crimp height, track and feed adjustments can be set without removing the applicator from the press
- Fine adjustment allows 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: Commoning Connector Crimp Terminal, 18-22 AWG

Terminal Series No.	Terminal Order No.		Wire Size		Insulation Diameter		Strip Length	
			AWG	mm <sup>2</sup>	mm	In.	mm	In.
1457	05-02-0047	05-02-0058	18-22	0.80-0.35	1.55-2.59	.061-.102	3.96-5.54	.156-.218
	05-02-0056							

## DEFINITION OF TERMS



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 Maximum		Conductor Brush	
	mm	In.	mm	In.	mm	In.
1457			.180	.007		

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
					Conductor		Insulation		
	Degree		Degree		mm	In.	mm	In.	
1457					1.925	.076	3.125	.123	

**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		N	Lb.
			mm	In.	mm	In.		
1457	18	0.80	1.37-1.42	.054-.056			133.44	30.0
	20	0.50	1.32-1.37	.052-.054			80.07	18.0
	22	0.35	1.29-1.35	.051-.053			62.28	14.0

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 63893-2000</b>				
<b>Item</b>	<b>Order No</b>	<b>Engineering No.</b>	<b>Description</b>	<b>Quantity</b>
<b>Perishable Tooling</b>				
	63893-2070	63893-2070	Tool Kit (All "Y" Items)	REF
1	11-18-4291	60719-1	Conductor Punch	1 Y
2	11-18-4284	60719-4	Combination Anvil	1 Y
3	11-18-4292	60719-2	Insulation Punch	1 Y
4	11-17-2136	7163-4	Cut-off Blade Rear	1 Y
5	11-17-3076	7163-30	Front Cut-off Plunger	1 Y
6	11-17-3079	7163-33	Rear Cut-off Plunger	1 Y
<b>Other Components</b>				
7	11-18-4081	60707-6	Front Plunger Striker	1
8	11-18-4082	60707-7	Back Plunger Striker	1
9	11-18-4094	60709A11	Front Cover	1
10	11-18-4246	60707-18	Front Plunger Guide Block	1
11	11-18-4247	60707-19	Rear Plunger Guide Block	1
12	11-18-4285	60719-5	Cover Plate	1
13	11-18-4293	6070719-3	Insulation Punch Spacer	1
14	11-18-4298	60719-12	Hold Down Pad	1
15	19229-0132	23649-26	Cut-off Plunger Spring	2
16	63443-0090	63443-0090	Wire Stop	1
17	63803-5111	63803-5111	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
21	63860-2015	63860-2015	Drag Frame-Modified	1
<b>Hardware</b>				
22	N/A	N/A	M3 by 8 Long SHCS	2**
23	N/A	N/A	M4 by 6 Long SHCS	1**
24	N/A	N/A	M4 by 12 Long BHCS	2**
25	N/A	N/A	M4 by 20 Long SHCS	2**
26	N/A	N/A	M5 by 14 Long SHCS	1**
27	N/A	N/A	M8 by 20 Long BHCS	1**
28	N/A	N/A	#6-32 by 3/8" Long BHCS	4**
29	N/A	N/A	#6-32 by 1/2" Long FHCS	1**
30	N/A	N/A	#6-32 Hex Jam Nut	1**
31	N/A	N/A	#8-32 by 3/8" Long BHCS	1**
32	N/A	N/A	#8-32 by 3/8" Long SHCS	2**
** Available from an industrial supply company such as MSC (1-800-645-7270).				



## 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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