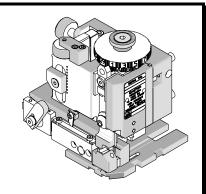


Mini-Mac Applicator **Specification Sheet** Order No. 63894-2000



FEATURES

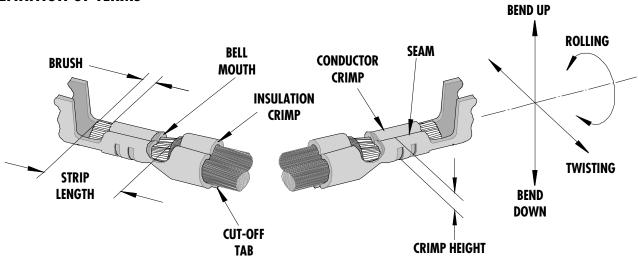
- Directly adapts to most automatic wire processing machines
- Applicator designed to industry standard mounting and shut height 135.80mm (5.346")
- Quick set-up time; plus the crimp height, track and feed adjustments can be set without removing the applicator from the press
- Fine adjustment allows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

Terminal Series No.	Terminal Order No.	Wire Size		Insulation Max	Strip Length		
		AWG	mm²	mm	ln.	mm	ln.
	02-12-6401						
1220	02-12-6402	12	3.30	3.68	.145	4.57	.180
	02-12-6403						

DEFINITION OF TERMS



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

Doc No. ATS-638942000 Release Date: 03-13-07 **UNCONTROLLED COPY** Page 1 of 5 Revision Date: 03-13-07

CRIMP SPECIFICATIONS

Terminal Series No.	Bell mouth		Cut-off Tal	Maximum	Conductor Brush		
	mm	ln.	mm	ln.	mm	In.	
1220			0.18	.007			

	Bend up Bend down	Twist R	Roll	Pall P	Punch Width (Ref)			Seam		
Terminal Series No.	Delia op Delia aowii		I WISI KOII		Conductor		Insulation		Seam shall not be open	
	De	gree	Deg	ree	mm	ln.	mm	ln.	and no wire allowed out	
1220					3.80	.150	4.89	.192	of the crimping area	

After crimping, the conductor profile should measure the following.

	Wire	Ciza	Conductor				Pull Force Minimum		
Terminal Series No.	wire	SIZE	Crimp	Crimp Width		ruii rui ce Millilliulii			
	AWG	mm²	mm	ln.	mm	ln.	N	Lb.	
1220	12	3.30	2.26-2.41	.093095			311.38	70.0	

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

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

The above specifications are guidelines to an optimum crimp.

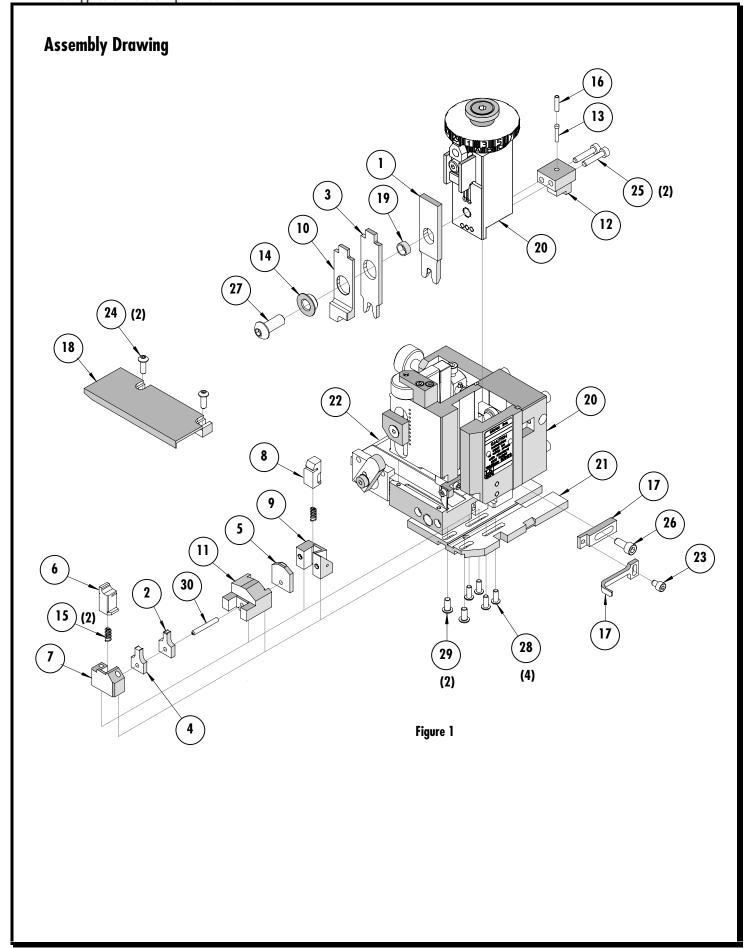
Doc No. ATS-638942000 Revision: A Release Date: 03-13-07 Revision Date: 03-13-07

PARTS LIST

Mini-Mac Applicator 63894-2000								
ltem	Order No Engineering No. Description							
Perishable Tooling								
	63894-2070	3894-2070 63894-2070 Tool Kit (All "Y" Items)		REF				
1	11-18-4378	60723A101	Conductor Punch	1 Y				
2	11-18-4379	60723A102	Conductor Anvil	1 Y				
3	11-18-4380	60723A103	Insulation Punch	1 Y				
4	11-18-4381	60723A104	Insulation Anvil	1 Y				
5	11-18-4383	60723A106	Cut-Off Blade	1 Y				
6	11-18-4509	60723A113	Cut-Off Plunger	1 Y				
7	11-18-4033	60705A107	Cut-Off Plunger Retainer	1 Y				
8	11-18-4242	60710-19	Rear Cut-Off Plunger	1 Y				
9	11-18-4241	60710-18	Cut-off Plunger Retainer	1 Y				
		Other Compo	nents (REF 942050)					
10	11-18-4034	60705A108	Front Plunger Striker	1				
11	11-18-4382	60723A105	Anvil and Cut-Off Block	1				
12	11-18-4388	60723A111	Rear Cut-Off Punch	1				
13	11-18-4510	60723A114	Terminal Hold Down					
14	11-18-4654	60758A109	Tooling Washer	1				
15	11-18-4944	60710-21	Compression Spring	2				
16	11-40-4670	8365-2	Terminal Hold Down Spring	1				
17	63443-0090	63443-0090						
18	63443-6140	63443-6140						
19	63803-5102	63803-5102	Conductor Bushing	1				
			Frame					
20	63801-3201	63801-3201	Тор	1				
21	63801-3282	63801-3282						
22	63801-6550	63801-6550	Track	1				
		H	lardware					
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						
27	N/A	N/A	M8 by 20 Long BHCS					
28	N/A	N/A #6-32 by 3/8" Long BHCS		4**				
29	N/A	N/A	#8-32 by 3/8" Long BHCS	1**				
30	N/A	N/A	1/8 Diameter by 1.0" Long Dowel Pin	2**				
	** Available fr	om an industrial supp	ly company such as MSC (1-800-645-72)	70).				

Doc No. ATS-638942000 Release Date: 03-13-07 Revision: A Revision Date: 03-13-07

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Doc No. ATS-638942000 Revision: A Release Date: 03-13-07 Revision Date: 03-13-07

NOTES

- Molex recommends an extra perishable tooling kit be maintained at your facility.
- Verify tooling alignment by manually cycling the press and applicator before crimping under power. Check that all screws are tight.
- 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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Doc No. ATS-638942000 Release Date: 03-13-07 **UNCONTROLLED COPY** Page 5 of 5 Revision Date: 03-13-07

Revision: A