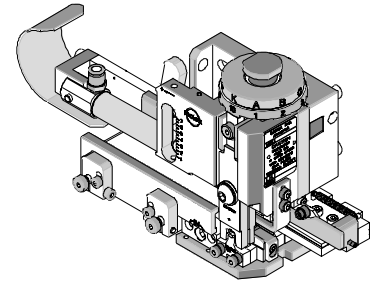




Mini-Mac Applicator Application Tooling Specification Air Feed-Mylar Tape Order No. 63885-1300



FEATURES

- Directly adapts to most crimp presses and automatic wire processors
- Applicator designed to industry standard mounting and shut height of 135.80mm (5.346")
- Conductor and insulation rings allow quick adjustment for conductor and insulation crimp height change
- Quick set-up time; plus the crimp height, track and feed adjustments can be set without removing the applicator from the crimp press

SCOPE

Products: Ring and Spade Terminals 18-22 AWG

Testing

Mechanical

The tensile test, or pull test, is a means of evaluating the mechanical properties of the crimped connections. The following chart shows the UL and government specifications (MIL-T-7928) for various wire sizes. The tensile strength is shown in pounds and indicates the minimum acceptable force to break or separate the terminal from the conductor.

Color Code	Wire Size (AWG)	*UL - 486 A	*UL - 486 C	*UL - 310	*Military Class 2
Yellow	26	3	N/A	N/A	7
Yellow	24	5	N/A	N/A	10
Red	22	8	8	8	15
Red	20	13	10	13	19
Red	18	20	10	20	38
Blue	16	30	15	30	50
Blue	14	50	25	50	70
Yellow	12	70	35	70	110
Yellow	10	80	40	80	150
Red	8	90	45	N/A	225
Blue	6	100	50	N/A	300

*UL - 486 A - Terminals (Copper conductors only)

*UL - 486 C - Butt Splices, Parallel Splices, Closed End Connectors, and Wire Nuts

*UL - 310 - Quick Disconnects, Flag and Couplers

*Military Class 2 - Military Approved Terminals only as listed

Product List

The following is a partial list of the product order numbers and their specifications that this tool is designed to run. Updates to this list are available on www.molex.com.

Terminal No.	Terminal Eng. No.	Wire Size		Insulation Diameter Max		Strip Length	
		AWG	mm ²	mm	In.	mm	In.
	AA-205-06XT	18-22	0.80-0.35	3.56	.144	5.95	.234
	AA-832-08TS	18-22	0.80-0.35				
	BB-2138TS	14-16	2.00-1.30				
	SPL-0045T						
	SPL-0358T						
	SPL-0388T						
	SPL-0389T						
19070-0002	AA-2111-02XT	18-22	0.80-0.35	3.68	.144	5.95	.234
19070-0004	AA-2111-04XT	18-22	0.80-0.35	3.68	.144	5.95	.234
19070-0006	AA-220-02XT	18-22	0.80-0.35	3.68	.144	5.95	.234
19070-0008	AA-220-04XT	18-22	0.80-0.35	3.68	.144	5.95	.234
19070-0010	AA-220-06XT	18-22	0.80-0.35	3.68	.144	5.95	.234
19070-0012	AA-221-06XT	18-22	0.80-0.35	3.68	.144	5.95	.234
19070-0014	AA-221-08XT	18-22	0.80-0.35	3.68	.144	5.95	.234
19070-0017	AA-221-10XT	18-22	0.80-0.35	3.68	.144	5.95	.234
19070-0022	AA-222-10XT	18-22	0.80-0.35	3.68	.144	5.95	.234
19070-0024	AA-222-14XT	18-22	0.80-0.35	3.68	.144	5.95	.234
19070-0027	AA-222-56XT	18-22	0.80-0.35	3.68	.144	5.95	.234
19070-0030	AA-226-10XT	18-22	0.80-0.35	3.68	.144	5.95	.234
19070-0032	AA-226-14XT	18-22	0.80-0.35	3.68	.144	5.95	.234
19070-0034	AA-226-38XT	18-22	0.80-0.35	3.68	.144	5.95	.234
19070-0035	AA-226-38XT	18-22	0.80-0.35	3.68	.144	5.95	.234
19070-0037	AA-226-56XT	18-22	0.80-0.35	3.68	.144	5.95	.234
19070-0039	AA-232-04XT	18-22	0.80-0.35	3.68	.144	5.95	.234
19070-0041	AA-232-06XT	18-22	0.80-0.35	3.68	.144	5.95	.234
19070-0042	AA-232-06XT	18-22	0.80-0.35	3.68	.144	5.95	.234
19070-0045	AA-232-08XT	18-22	0.80-0.35	3.68	.144	5.95	.234
19070-0052	AA-233-10XT	18-22	0.80-0.35	3.68	.144	5.95	.234
19070-0282	SPL-0558T	18-22	0.80-0.35	3.68	.144	5.95	.234
19071-0002	AA-6111-02XT	18-22	0.80-0.35	3.68	.144	5.95	.234
19071-0004	AA-6111-04XT	18-22	0.80-0.35	3.68	.144	5.95	.234
19071-0006	AA-620-02XT	18-22	0.80-0.35	3.68	.144	5.95	.234
19071-0008	AA-620-04XT	18-22	0.80-0.35	3.68	.144	5.95	.234
19071-0010	AA-620-06XT	18-22	0.80-0.35	3.68	.144	5.95	.234
19071-0012	AA-621-06XT	18-22	0.80-0.35	3.68	.144	5.95	.234
19071-0014	AA-621-08XT	18-22	0.80-0.35	3.68	.144	5.95	.234
19071-0016	AA-621-10XT	18-22	0.80-0.35	3.68	.144	5.95	.234
19071-0018	AA-622-10XT	18-22	0.80-0.35	3.68	.144	5.95	.234
19071-0020	AA-622-14XT	18-22	0.80-0.35	3.68	.144	5.95	.234
19071-0022	AA-622-56XT	18-22	0.80-0.35	3.68	.144	5.95	.234
19071-0025	AA-626-14XT	18-22	0.80-0.35	3.68	.144	5.95	.234
19071-0027	AA-626-38XT	18-22	0.80-0.35	3.68	.144	5.95	.234
19071-0029	AA-626-56XT	18-22	0.80-0.35	3.68	.144	5.95	.234
19071-0031	AA-632-04XT	18-22	0.80-0.35	3.68	.144	5.95	.234
19071-0033	AA-632-06XT	18-22	0.80-0.35	3.68	.144	5.95	.234
19071-0035	AA-632-08XT	18-22	0.80-0.35	3.68	.144	5.95	.234
19071-0036	AA-632-125XT	18-22	0.80-0.35	3.68	.144	5.95	.234
19071-0041	AA-633-10XT	18-22	0.80-0.35	3.68	.144	5.95	.234
19073-0002	AA-8111-02T	18-22	0.80-0.35	3.63	.143	6.35	.250
19073-0004	AA-8111-04T	18-22	0.80-0.35	3.63	.143	6.35	.250
19073-0006	AA-820-02T	18-22	0.80-0.35	3.63	.143	6.35	.250
19073-0008	AA-820-04T	18-22	0.80-0.35	3.63	.143	6.35	.250
19073-0010	AA-820-06T	18-22	0.80-0.35	3.63	.143	6.35	.250
19073-0012	AA-821-06T	18-22	0.80-0.35	3.63	.143	6.35	.250

Terminal No.	Terminal Eng. No.	Wire Size		Insulation Diameter Max		Strip Length	
		AWG	mm ²	mm	In.	mm	In.
19073-0015	AA-821-08T	18-22	0.80-0.35	3.63	.143	6.35	.250
19073-0019	AA-821-10T	18-22	0.80-0.35	3.63	.143	6.35	.250
19073-0021	AA-821-209T	18-22	0.80-0.35	3.63	.143	6.35	.250
19073-0023	AA-822-10T	18-22	0.80-0.35	3.63	.143	6.35	.250
19073-0026	AA-822-14T	18-22	0.80-0.35	3.63	.143	6.35	.250
19073-0028	AA-822-56T	18-22	0.80-0.35	3.63	.143	6.35	.250
19073-0031	AA-826-14T	18-22	0.80-0.35	3.63	.143	6.35	.250
19073-0033	AA-826-38T	18-22	0.80-0.35	3.63	.143	6.35	.250
19073-0035	AA-826-56T	18-22	0.80-0.35	3.63	.143	6.35	.250
19073-0037	AA-832-04T	18-22	0.80-0.35	3.63	.143	6.35	.250
19073-0040	AA-832-06T	18-22	0.80-0.35	3.63	.143	6.35	.250
19073-0043	AA-832-08T	18-22	0.80-0.35	3.63	.143	6.35	.250
19073-0050	AA-833-10T	18-22	0.80-0.35	3.63	.143	6.35	.250
19087-0074	AA-205-04XT	18-22	0.80-0.35	3.68	.144	5.95	.234
19090-0008	AA-2110-02XT	18-22	0.80-0.35	3.68	.144	5.95	.234
19090-0010	AA-2110-04XT	18-22	0.80-0.35	3.68	.144	5.95	.234
19090-0012	AA-214-04XT	18-22	0.80-0.35	3.68	.144	5.95	.234
19090-0014	AA-214-06XT	18-22	0.80-0.35	3.68	.144	5.95	.234
19090-0016	AA-214-08XT	18-22	0.80-0.35	3.68	.144	5.95	.234
19090-0025	AA-292-06XT	18-22	0.80-0.35	3.68	.144	5.95	.234
19090-0027	AA-292-08XT	18-22	0.80-0.35	3.68	.144	5.95	.234
19090-0029	AA-292-10XT	18-22	0.80-0.35	3.68	.144	5.95	.234
19090-0031	AA-295-06XT	18-22	0.80-0.35	3.68	.144	5.95	.234
19090-0033	AA-295-08XT	18-22	0.80-0.35	3.68	.144	5.95	.234
19090-0035	AA-295-10XT	18-22	0.80-0.35	3.68	.144	5.95	.234
19090-0037	AA-298-04XT	18-22	0.80-0.35	3.68	.144	5.95	.234
19090-0039	AA-298-06XT	18-22	0.80-0.35	3.68	.144	5.95	.234
19090-0041	AA-298-08XT	18-22	0.80-0.35	3.68	.144	5.95	.234
19090-0043	AA-298-10XT	18-22	0.80-0.35	3.68	.144	5.95	.234
19092-0002	AA-605-04XT	18-22	0.80-0.35	3.68	.144	5.95	.234
19092-0004	AA-605-06XT	18-22	0.80-0.35	3.68	.144	5.95	.234
19092-0010	AA-6110-02XT	18-22	0.80-0.35	3.68	.144	5.95	.234
19092-0012	AA-6110-04XT	18-22	0.80-0.35	3.68	.144	5.95	.234
19092-0014	AA-614-04XT	18-22	0.80-0.35	3.68	.144	5.95	.234
19092-0016	AA-614-06XT	18-22	0.80-0.35	3.68	.144	5.95	.234
19092-0018	AA-614-08XT	18-22	0.80-0.35	3.68	.144	5.95	.234
19092-0020	AA-692-06XT	18-22	0.80-0.35	3.68	.144	5.95	.234
19092-0022	AA-692-08XT	18-22	0.80-0.35	3.68	.144	5.95	.234
19092-0024	AA-692-10XT	18-22	0.80-0.35	3.68	.144	5.95	.234
19092-0026	AA-695-06XT	18-22	0.80-0.35	3.68	.144	5.95	.234
19092-0028	AA-695-08XT	18-22	0.80-0.35	3.68	.144	5.95	.234
19092-0030	AA-695-10XT	18-22	0.80-0.35	3.68	.144	5.95	.234
19092-0032	AA-698-04XT	18-22	0.80-0.35	3.68	.144	5.95	.234
19092-0034	AA-698-06XT	18-22	0.80-0.35	3.68	.144	5.95	.234
19092-0036	AA-698-08XT	18-22	0.80-0.35	3.68	.144	5.95	.234
19092-0038	AA-698-10XT	18-22	0.80-0.35	3.68	.144	5.95	.234
19095-0002	AA-805-04T	18-22	0.80-0.35	3.63	.143	6.35	.250
19095-0004	AA-805-06T	18-22	0.80-0.35	3.63	.143	6.35	.250
19095-0012	AA-8110-02T	18-22	0.80-0.35	3.63	.143	6.35	.250
19095-0015	AA-8110-04T	18-22	0.80-0.35	3.63	.143	6.35	.250
19095-0017	AA-814-04T	18-22	0.80-0.35	3.63	.143	6.35	.250
19095-0019	AA-814-06T	18-22	0.80-0.35	3.63	.143	6.35	.250
19095-0021	AA-814-08T	18-22	0.80-0.35	3.63	.143	6.35	.250
19095-0027	AA-882-1T	18-22	0.80-0.35	3.63	.143	6.35	.250

Air Feed Mylar Tape Applicator

Terminal No.	Terminal Eng. No.	Wire Size		Insulation Diameter Max		Strip Length	
		AWG	mm ²	mm	In.	mm	In.
19095-0037	AA-892-06T	18-22	0.80-0.35	3.63	.143	6.35	.250
19095-0039	AA-892-08T	18-22	0.80-0.35	3.63	.143	6.35	.250
19095-0041	AA-892-10T	18-22	0.80-0.35	3.63	.143	6.35	.250
19095-0043	AA-895-06T	18-22	0.80-0.35	3.63	.143	6.35	.250
19095-0045	AA-895-08T	18-22	0.80-0.35	3.63	.143	6.35	.250
19095-0047	AA-895-10T	18-22	0.80-0.35	3.63	.143	6.35	.250
19095-0049	AA-898-04T	18-22	0.80-0.35	3.63	.143	6.35	.250
19095-0051	AA-898-06T	18-22	0.80-0.35	3.63	.143	6.35	.250
19095-0053	AA-898-08T	18-22	0.80-0.35	3.63	.143	6.35	.250
19095-0055	AA-898-10T	18-22	0.80-0.35	3.63	.143	6.35	.250
19099-0002	AA-2190-06XT	18-22	0.80-0.35	3.68	.144	5.95	.234
19099-0004	AA-2191-08XT	18-22	0.80-0.35	3.68	.144	5.95	.234
19099-0006	AA-2192-10XT	18-22	0.80-0.35	3.68	.144	5.95	.234
19099-0008	AA-2704-05XT	18-22	0.80-0.35	3.68	.144	5.95	.234
19099-0010	AA-2704-06XT	18-22	0.80-0.35	3.68	.144	5.95	.234
19099-0014	AA-2714-08XT	18-22	0.80-0.35	3.68	.144	5.95	.234
19099-0016	AA-2715-10XT	18-22	0.80-0.35	3.68	.144	5.95	.234
19099-0052	AA-2704-04XT	18-22	0.80-0.35	3.68	.144	5.95	.234
19099-0053	AA-2705-08XT	18-22	0.80-0.35	3.68	.144	5.95	.234
19099-0054	AA-2706-10XT	18-22	0.80-0.35	3.68	.144	5.95	.234
19115-0002	AA-8190-06T	18-22	0.80-0.35	3.63	.143	6.35	.250
19115-0004	AA-8191-08T	18-22	0.80-0.35	3.63	.143	6.35	.250
19115-0006	AA-8192-10T	18-22	0.80-0.35	3.63	.143	6.35	.250
19115-0008	AA-8704-05T	18-22	0.80-0.35	3.63	.143	6.35	.250
19115-0010	AA-8704-06T	18-22	0.80-0.35	3.63	.143	6.35	.250
19115-0013	AA-8714-08T	18-22	0.80-0.35	3.63	.143	6.35	.250
19115-0015	AA-8715-10T	18-22	0.80-0.35	3.63	.143	6.35	.250
19115-0050	AA-8704-04T	18-22	0.80-0.35	3.63	.143	6.35	.250
19115-0051	AA-8705-08T	18-22	0.80-0.35	3.63	.143	6.35	.250
19115-0053	AA-8706-10T	18-22	0.80-0.35	3.63	.143	6.35	.250
19121-0003	AA-2108-04XT	18-22	0.80-0.35	3.68	.144	5.95	.234
19121-0006	AA-215-06XT	18-22	0.80-0.35	3.68	.144	5.95	.234
19121-0008	AA-215-08XT	18-22	0.80-0.35	3.68	.144	5.95	.234
19121-0010	AA-215-10XT	18-22	0.80-0.35	3.68	.144	5.95	.234
19121-0023	AA-296-06XT	18-22	0.80-0.35	3.68	.144	5.95	.234
19121-0058	AA-2108-02XT	18-22	0.80-0.35	3.68	.144	5.95	.234
19121-0059	AA-215-02XT	18-22	0.80-0.35	3.68	.144	5.95	.234
19121-0060	AA-215-04XT	18-22	0.80-0.35	3.68	.144	5.95	.234
19121-0061	AA-2461-06XT	18-22	0.80-0.35	3.68	.144	5.95	.234
19121-0062	AA-2461-08XT	18-22	0.80-0.35	3.68	.144	5.95	.234
19121-0063	AA-290-06XT	18-22	0.80-0.35	3.68	.144	5.95	.234
19121-0064	AA-290-08XT	18-22	0.80-0.35	3.68	.144	5.95	.234
19121-0065	AA-290-10XT	18-22	0.80-0.35	3.68	.144	5.95	.234
19121-0066	AA-293-06XT	18-22	0.80-0.35	3.68	.144	5.95	.234
19121-0067	AA-293-08XT	18-22	0.80-0.35	3.68	.144	5.95	.234
19121-0068	AA-293-10XT	18-22	0.80-0.35	3.68	.144	5.95	.234
19121-0069	AA-296-04XT	18-22	0.80-0.35	3.68	.144	5.95	.234
19121-0071	AA-296-08XT	18-22	0.80-0.35	3.68	.144	5.95	.234
19122-0002	AA-6108-02XT	18-22	0.80-0.35	3.68	.144	5.95	.234
19122-0004	AA-6108-04XT	18-22	0.80-0.35	3.68	.144	5.95	.234
19122-0006	AA-615-04XT	18-22	0.80-0.35	3.68	.144	5.95	.234
19122-0008	AA-615-06XT	18-22	0.80-0.35	3.68	.144	5.95	.234
19122-0010	AA-615-08XT	18-22	0.80-0.35	3.68	.144	5.95	.234
19122-0012	AA-690-06XT	18-22	0.80-0.35	3.68	.144	5.95	.234
19122-0014	AA-690-08XT	18-22	0.80-0.35	3.68	.144	5.95	.234
19122-0016	AA-690-10XT	18-22	0.80-0.35	3.68	.144	5.95	.234
19122-0018	AA-693-06XT	18-22	0.80-0.35	3.68	.144	5.95	.234
19122-0020	AA-693-08XT	18-22	0.80-0.35	3.68	.144	5.95	.234
19122-0022	AA-693-10XT	18-22	0.80-0.35	3.68	.144	5.95	.234
19122-0024	AA-696-04XT	18-22	0.80-0.35	3.68	.144	5.95	.234
19122-0026	AA-696-06XT	18-22	0.80-0.35	3.68	.144	5.95	.234
19122-0027	AA-696-08XT	18-22	0.80-0.35	3.68	.144	5.95	.234

Terminal No.	Terminal Eng. No.	Wire Size		Insulation Diameter Max		Strip Length	
		AWG	mm ²	mm	In.	mm	In.
19127-0002	AA-8108-02T	18-22	0.80-0.35	3.56	.140	6.35	.250
19127-0004	AA-8108-04T	18-22	0.80-0.35	3.56	.140	6.35	.250
19127-0006	AA-815-04T	18-22	0.80-0.35	3.56	.140	6.35	.250
19127-0009	AA-815-06T	18-22	0.80-0.35	3.56	.140	6.35	.250
19127-0011	AA-815-08T	18-22	0.80-0.35	3.56	.140	6.35	.250
19127-0013	AA-815-10T	18-22	0.80-0.35	3.56	.140	6.35	.250
19127-0018	AA-8461-10T	18-22	0.80-0.35	3.56	.140	6.35	.250
19127-0020	AA-890-06T	18-22	0.80-0.35	3.63	.143	6.35	.250
19127-0022	AA-890-08T	18-22	0.80-0.35	3.63	.143	6.35	.250
19127-0024	AA-890-10T	18-22	0.80-0.35	3.63	.143	6.35	.250
19127-0026	AA-893-06T	18-22	0.80-0.35	3.63	.143	6.35	.250
19127-0028	AA-893-08T	18-22	0.80-0.35	3.63	.143	6.35	.250
19127-0030	AA-893-10T	18-22	0.80-0.35	3.63	.143	6.35	.250
19127-0032	AA-896-04T	18-22	0.80-0.35	3.63	.143	6.35	.250
19127-0034	AA-896-06T	18-22	0.80-0.35	3.63	.143	6.35	.250
19127-0036	AA-896-08T	18-22	0.80-0.35	3.63	.143	6.35	.250
19131-0026	AA-294-10XT	18-22	0.80-0.35	3.68	.144	5.95	.234
19131-0030	AA-238-06XT	18-22	0.80-0.35	3.68	.144	5.95	.234
19131-0032	AA-238-04XT	18-22	0.80-0.35	3.68	.144	5.95	.234
19131-0035	AA-234-08XT	18-22	0.80-0.35	3.68	.144	5.95	.234
19131-0037	AA-234-06XT	18-22	0.80-0.35	3.68	.144	5.95	.234
19131-0041	AA-2118-06XT	18-22	0.80-0.35	3.68	.144	5.95	.234
19131-0044	AA-2109-04XT	18-22	0.80-0.35	3.68	.144	5.95	.234
19131-0046	AA-2109-02XT	18-22	0.80-0.35	3.68	.144	5.95	.234
19131-0049	AA-234-04XT	18-22	0.80-0.35	3.68	.144	5.95	.234
19131-0050	AA-234-10XT	18-22	0.80-0.35	3.68	.144	5.95	.234
19131-0051	AA-294-06XT	18-22	0.80-0.35	3.63	.143	5.95	.234
19131-0052	AA-294-08XT	18-22	0.80-0.35	3.63	.143	5.95	.234
19139-0002	AA-8109-02T	18-22	0.80-0.35	3.63	.143	6.35	.250
19139-0004	AA-8109-04T	18-22	0.80-0.35	3.63	.143	6.35	.250
19139-0007	AA-8118-06T	18-22	0.80-0.35	3.63	.143	6.35	.250
19139-0010	AA-834-04T	18-22	0.80-0.35	3.63	.143	6.35	.250
19139-0012	AA-834-06T	18-22	0.80-0.35	3.63	.143	6.35	.250
19139-0014	AA-834-08T	18-22	0.80-0.35	3.63	.143	6.35	.250
19139-0017	AA-838-04T	18-22	0.80-0.35	3.63	.143	6.35	.250
19139-0019	AA-838-06T	18-22	0.80-0.35	3.63	.143	6.35	.250
19139-0021	AA-891-06T	18-22	0.80-0.35	3.63	.143	6.35	.250
19139-0023	AA-891-08T	18-22	0.80-0.35	3.63	.143	6.35	.250
19139-0025	AA-891-10T	18-22	0.80-0.35	3.63	.143	6.35	.250
19139-0027	AA-894-06T	18-22	0.80-0.35	3.63	.143	6.35	.250
19139-0029	AA-894-08T	18-22	0.80-0.35	3.63	.143	6.35	.250
19139-0031	AA-894-10T	18-22	0.80-0.35	3.63	.143	6.35	.250
19139-0033	AA-897-04T	18-22	0.80-0.35	3.63	.143	6.35	.250
19139-0035	AA-897-06T	18-22	0.80-0.35	3.63	.143	6.35	.250
19139-0037	AA-897-08T	18-22	0.80-0.35	3.63	.143	6.35	.250
19144-0002	AA-235-06XT	18-22	0.80-0.35	3.68	.144	5.95	.234
19144-0004	AA-235-08XT	18-22	0.80-0.35	3.68	.144	5.95	.234
19144-0006	AA-235-10XT	18-22	0.80-0.35	3.68	.144	5.95	.234
19144-0056	AA-238-08XT	18-22	0.80-0.35	3.68	.144	5.95	.234
19144-0057	AA-291-06XT	18-22	0.80-0.35	3.68	.144	5.95	.234
19144-0058	AA-291-08XT	18-22	0.80-0.35	3.68	.144	5.95	.234
19144-0059	AA-291-10XT	18-22	0.80-0.35	3.68	.144	5.95	.234
19144-0060	AA-297-04XT	18-22	0.80-0.35	3.68	.144	5.95	.234
19144-0061	AA-297-06XT	18-22	0.80-0.35	3.68	.144	5.95	.234
19144-0062	AA-297-08XT	18-22	0.80-0.35	3.68	.144	5.95	.234
19145-0002	AA-6109-02XT	18-22	0.80-0.35	3.68	.144	5.95	.234
19145-0004	AA-6109-04XT	18-22	0.80-0.35	3.68	.144	5.95	.234
19145-0008	AA-634-04XT	18-22	0.80-0.35	3.68	.144	5.95	.234
19145-0009	AA-634-06XT	18-22	0.80-0.35	3.68	.144	5.95	.234
19145-0010	AA-634-08XT	18-22	0.80-0.35	3.68	.144	5.95	.234
19145-0012	AA-635-06XT	18-22	0.80-0.35	3.68	.144	5.95	.234
19145-0014	AA-635-08XT	18-22	0.80-0.35	3.68	.144	5.95	.234

Air Feed Mylar Tape Applicator

Terminal No.	Terminal Eng. No.	Wire Size		Insulation Diameter Max		Strip Length	
		AWG	mm ²	mm	In.	mm	In.
19145-0016	AA-635-10XT	18-22	0.80-0.35	3.68	.144	5.95	.234
19145-0018	AA-638-04XT	18-22	0.80-0.35	3.68	.144	5.95	.234
19145-0020	AA-638-06XT	18-22	0.80-0.35	3.68	.144	5.95	.234
19145-0021	AA-638-08XT	18-22	0.80-0.35	3.68	.144	5.95	.234
19145-0023	AA-691-06XT	18-22	0.80-0.35	3.68	.144	5.95	.234
19145-0025	AA-691-08XT	18-22	0.80-0.35	3.68	.144	5.95	.234
19145-0027	AA-691-10XT	18-22	0.80-0.35	3.68	.144	5.95	.234
19145-0029	AA-694-06XT	18-22	0.80-0.35	3.68	.144	5.95	.234
19145-0031	AA-694-08XT	18-22	0.80-0.35	3.68	.144	5.95	.234
19145-0033	AA-694-10XT	18-22	0.80-0.35	3.68	.144	5.95	.234
19145-0035	AA-697-04XT	18-22	0.80-0.35	3.68	.144	5.95	.234
19145-0037	AA-697-06XT	18-22	0.80-0.35	3.68	.144	5.95	.234
19145-0039	AA-697-08XT	18-22	0.80-0.35	3.68	.144	5.95	.234
19179-0001	AA-210-04XT	18-22	0.80-0.35	3.68	.144	5.95	.234
19179-0003	AA-210-06XT	18-22	0.80-0.35	3.68	.144	5.95	.234

Terminal No.	Terminal Eng. No.	Wire Size		Insulation Diameter Max		Strip Length	
		AWG	mm ²	mm	In.	mm	In.
19179-0005	AA-210-08XT	18-22	0.80-0.35	3.68	.144	5.95	.234
19179-0007	AA-210-10XT	18-22	0.80-0.35	3.68	.144	5.95	.234
19182-0002	AA-610-06XT	18-22	0.80-0.35	3.68	.144	5.95	.234
19182-0004	AA-610-08XT	18-22	0.80-0.35	3.68	.144	5.95	.234
19182-0006	AA-610-10XT	18-22	0.80-0.35	3.68	.144	5.95	.234
19183-0002	AA-810-06T	18-22	0.80-0.35	3.63	.143	6.35	.250
19183-0004	AA-810-08T	18-22	0.80-0.35	3.63	.143	6.35	.250
19183-0006	AA-810-10T	18-22	0.80-0.35	3.63	.143	6.35	.250
19198-0005	AA-835-08T	18-22	0.80-0.35	3.63	.143	6.35	.250
19198-0007	AA-835-10T	18-22	0.80-0.35	3.63	.143	6.35	.250
19198-0009	AA-838-08T	18-22	0.80-0.35	3.63	.143	6.35	.250
19198-0071	AA-835-06T	18-22	0.80-0.35	3.63	.143	6.35	.250
19212-0004	WP-2218XT	18-22	0.80-0.35	3.68	.144	5.95	.234
19213-0004	WP-5218T	18-22	0.80-0.35				
19213-0010	WP-8218T	18-22	0.80-0.35	3.56	.140	5.95	.234

DEFINITION OF TERMS

The following illustrations are a generic terminal representation and not an exact image of any terminal listed in the scope.

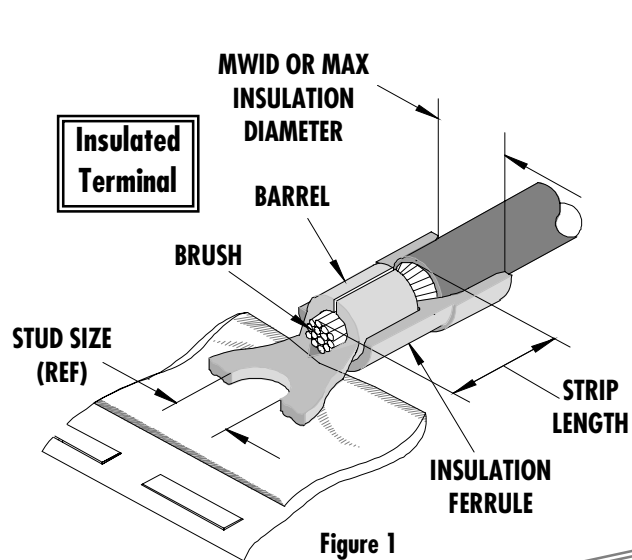


Figure 1

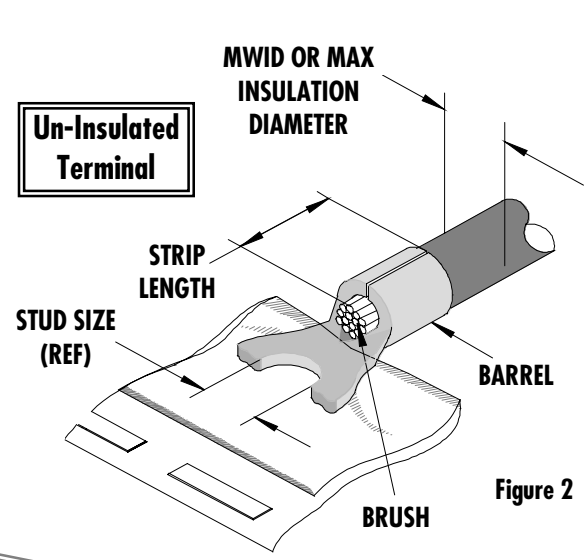


Figure 2

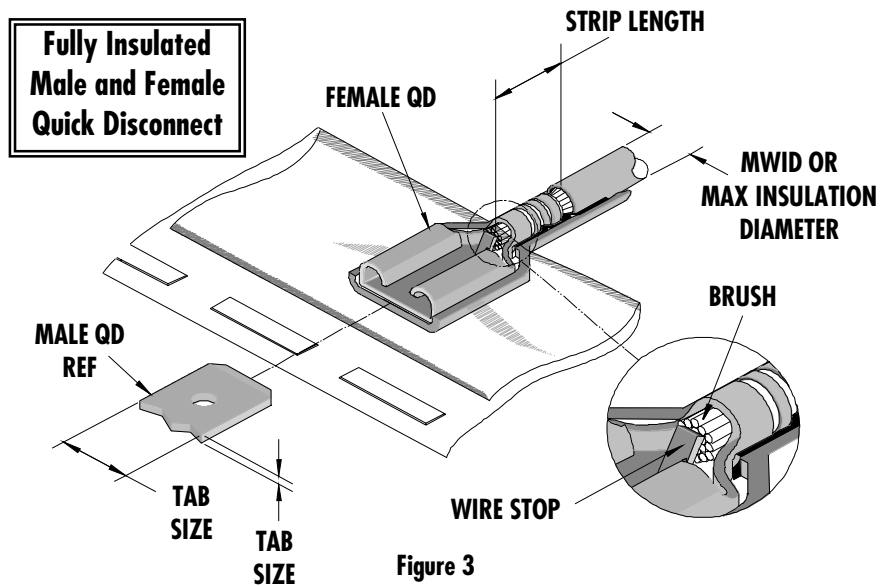
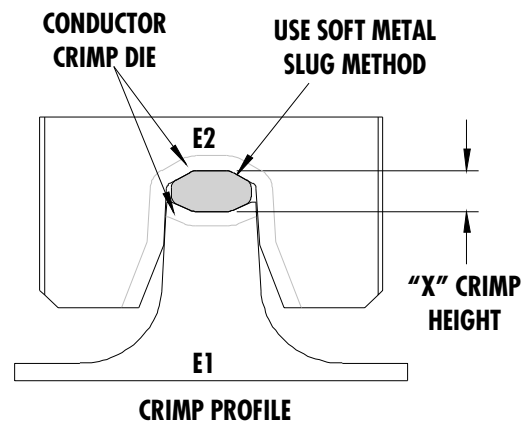


Figure 3

Tool Calibration

To recalibrate this applicator, make sure the power is completely shut off on the press.

1. The Mini-Mac applicator must be properly installed in the press.
2. Crimping dies must be properly installed in the Mini-Mac applicator.
3. The recommended method of measuring the crimp height of the conductor dies is the soft metal slug method, (See Figure 4).
4. The slug must have a diameter 0.51mm (.020") larger than the "X" No Go dimension before crimping.
5. Place the soft metal slug (solder) into the nest of the bottom die and crimp (by hand cycling the press) similar to a terminal. The crimp height can be measured with a blade type micrometer or dial caliper, (Dimension "X").
6. Adjustment of the crimp height can be accomplished by indexing the conductor cam. The letter "A" gives the loosest position and "K" gives the tightest position. A total adjustment of 0.50mm (.020") can be achieved by adjusting the conductor cam.



Use soft metal slug (solder) method to measure the "X" dimension. Verify tooling crimp height calibration by referring to the Go/No Go dimensions shown in the chart below.

Figure 4

Note: If the crimp height is too tight on the setting "A", check the shut height of the press. See the Industrial Mini-Mac Applicator Manual Section 2.1 for adjustments.

CRIMP SPECIFICATIONS

Wire Size		"X" Dimension Conductor Crimp						Pull Force Min.	
AWG	mm ²	Mean		Go		No Go		Lbs	N
		In	mm	In	mm	In	mm		
22	0.35	.108	2.74	.105	2.67	.115	2.92	8.0	35.6
20	0.50	.108	2.74	.105	2.67	.115	2.92	13.0	57.8
18	0.80	.108	2.74	.105	2.67	.115	2.92	20.0	90.0
16	1.30	.108	2.74	.105	2.67	.115	2.92	30.0	133.5
14	2.00	.108	2.74	.105	2.67	.115	2.92	50.0	222.6

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 63885-1300				
Item	Order No	Engineering No.	Description	Quantity
Perishable Tooling				
	63885-1370	63885-1370	Tool Kit (All "Y" Items)	REF
1	63465-0014	63465-0014	Conductor Punch	1 Y
2	63464-0014	63464-0014	Conductor Anvil	1 Y
3	63463-0011	63463-0011	Insulation Punch	1 Y
4	63462-0015	63462-0015	Insulation Anvil	1 Y
Other Components (Ref. 50050)				
31	63466-0912	63466-0912	Anvil Mount	1
32	63466-0913	63466-0913	Terminal Support	1
33	63443-0021	63443-0021	Lower Tooling Key	1
42	63466-0921	63466-0921	Terminal Stripping Blade	1
51	63600-1290	63600-1290	Washer	1
52	63890-0866	63890-0866	Collar-6.4mm Lg.	1
53	63890-0867	63890-0867	Collar-7.7mm Lg.	1
Frame				
81	63801-3301	63801-3301	Air Feed Applicator Frame Head	REF
82	63801-3281	63801-3281	Base	REF
83	63801-5850	63801-5850	Track Assembly	REF
84	63801-3390	63801-3390	Air Kit	REF
Hardware				
91	N/A	N/A	M3 by 12 Lg SHCS	1**
92	N/A	N/A	M4 by 10 Lg SHCS	2**
93	N/A	N/A	M4 by 16 Lg. SHCS	1**
94	N/A	N/A	M4 by 45 Lg. SHCS	1**
95	N/A	N/A	M8 by 30 Lg. BHCS	1**
96	N/A	N/A	3mm by 6 Lg. Roll Pin	1**
** Available from an industrial supply company such as MSC (1-800-645-7270).				

Note: Crimp profiles used in 63885-1300 are equivalent to 19032-0035/MMT-AA-510, 19032-0033, and 19288-0023/ATP-AA-510 (UL file number E32244).

Assembly Drawing

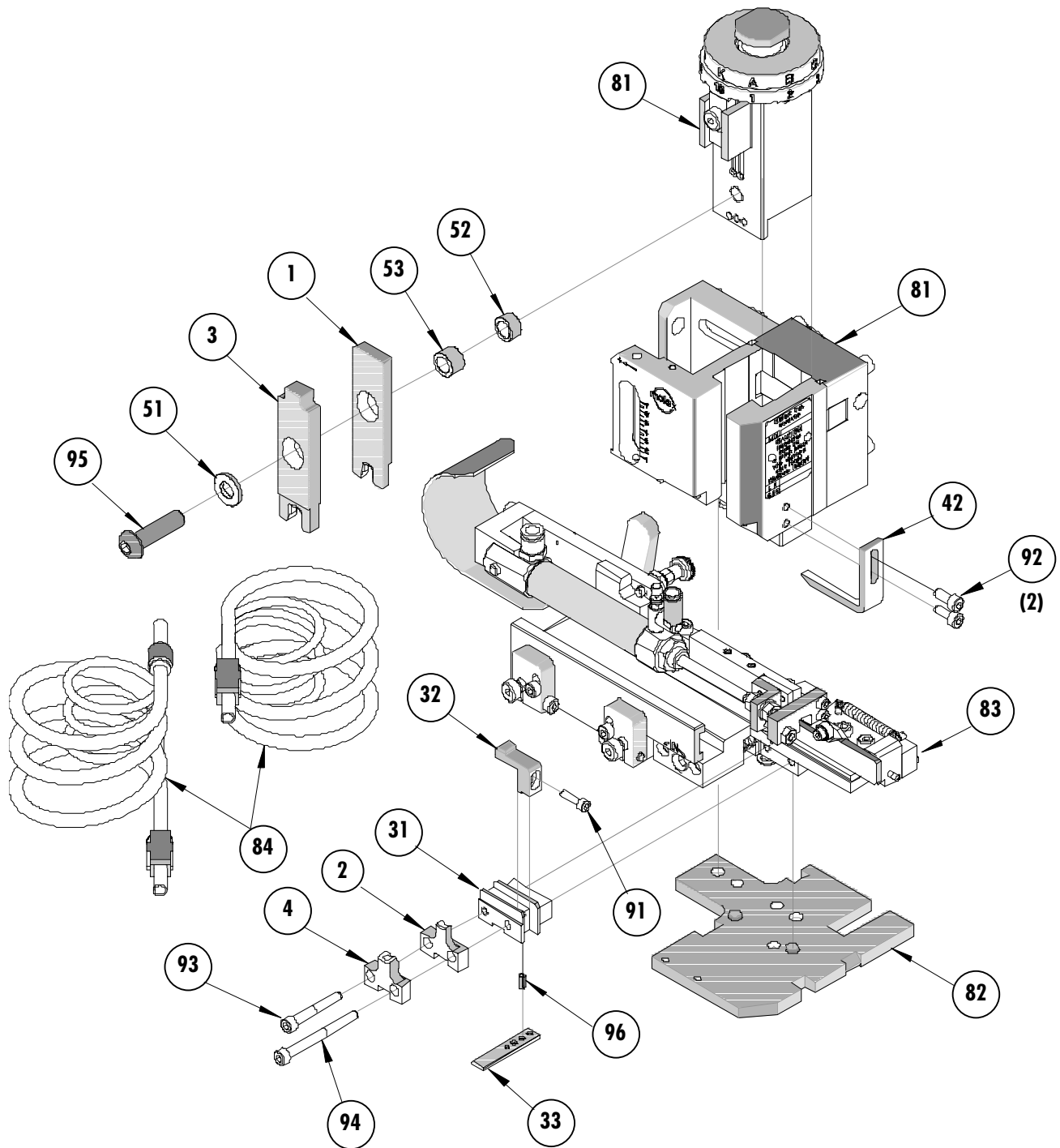


Figure 5

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

For more information on Molex application tooling please contact Molex at 1-800-786-6539.

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