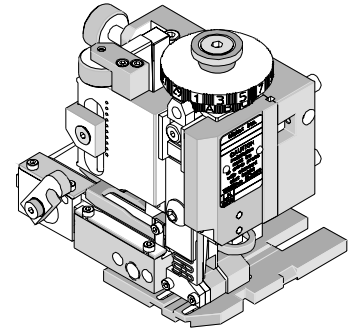




Mini-Mac Applicator Specification Sheet Order No. 63893-3000



FEATURES

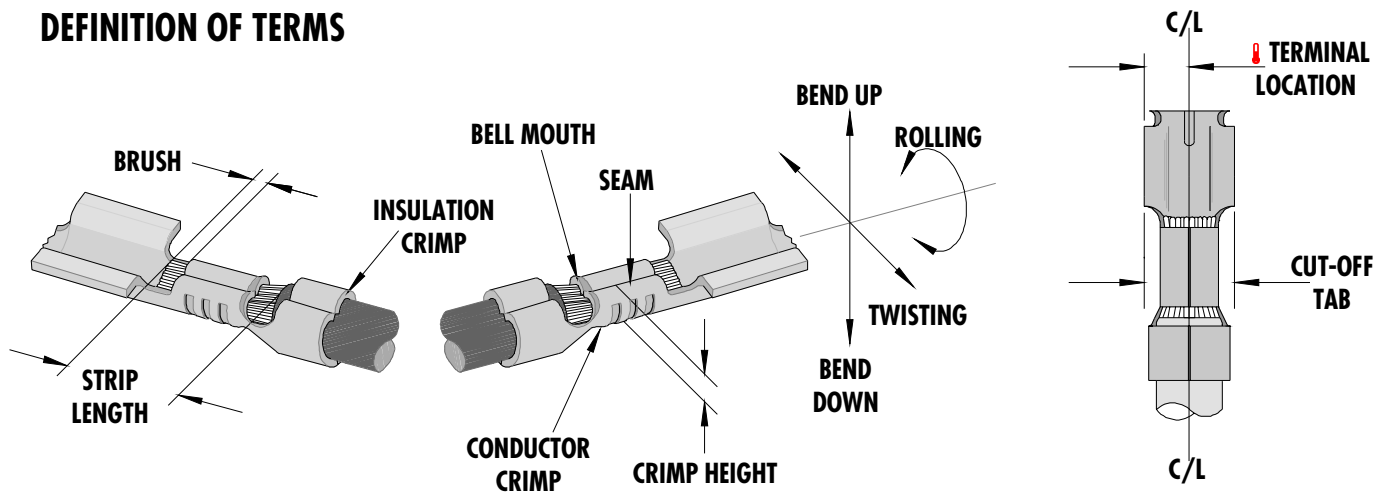
- Directly adapts to most automatic wire processing machines
- Applicator designed to industry standard mounting and shut height 135.80mm (5.346")
- Quick set-up time; plus the crimp height, track and feed adjustments can be set without removing the applicator from the press
- Fine adjustment allows 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: 2.36mm (.093") Pin and Socket Crimp Terminal Male and Female Crimp Terminal, 14-18 and 18 Doubles AWG.

Terminal Series No.	Terminal Order No.		Wire Size		Insulation Diameter Maximum		Strip Length	
			AWG	mm ²	mm	In.	mm	In.
41483	Ⓟ02-09-1153	02-09-1155	14-18	2.00-0.80	4.57	.180	4.32-4.95	.170-.195
			18 (2)	0.80 (2)	See Note Below		4.32-4.95	.170-.195
42183	Ⓟ02-09-2170	02-09-2172	14-18	2.00-0.80	4.57	.180	4.32-4.95	.170-.195
			18 (2)	0.80 (2)	See Note Below		4.32-4.95	.170-.195
Ⓟ For optimum insulation crimp: the following applicators are recommended.								
63893-3000	Applicator is recommended for double crimping two 18 AWG wires, one having a maximum insulation diameter of 4.32mm (.170"), and one having a maximum insulation diameter of 2.79mm (.110"). Single wire crimping may produce a loose insulation crimp.							
Ⓟ63893-3100	Applicator should be used for insulation O.D. 2.36-4.57mm (.093-.180") and 18 AWG SPT-3 wires.							
63893-3200	Applicator is recommended for double crimping two 18 AWG wires, with an insulation diameter of 2.36-3.56mm (.096-.140") each. Single wire crimping may produce a loose insulation crimp.							
Ⓟ63893-3300	Applicator should be used for insulation O.D. 2.36-3.56mm (.093-.140").							

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.
41483			3.53-3.69	.139-.145		
42138			3.53-3.69	.139-.145		

Terminal Series No.	Bend up	Bend down	Twist	Roll	Punch Width (Ref)				Seam
					Conductor		Insulation		
	Degree	Degree	mm	In.	mm	In.			
41483					2.75	.108	4.75	.187	Seam shall not be open and no wire allowed out of the crimping area
42138					2.75	.108	4.75	.187	

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	
			Crimp Height		Crimp width (REF)			
	AWG	mm ²	mm	In.	mm	In.	N	Lb.
41483	14	2.00	1.68-1.78	.066-.070	2.79	.110	177.9	40.0
	16	1.30	1.52-1.63	.060-.064	2.79	.110	155.6	35.0
	18	0.80	1.45-1.52	.057-.060	2.79	.110	133.4	30.0
	18 (2)	0.80 (2)	1.52-1.63	.060-.064	2.79	.110	133.4	30.0
42138	14	2.00	1.68-1.78	.066-.070	2.79	.110	177.9	40.0
	16	1.30	1.52-1.63	.060-.064	2.79	.110	155.6	35.0
	18	0.80	1.45-1.52	.057-.060	2.79	.110	133.4	30.0
	18 (2)	0.80 (2)	1.52-1.63	.060-.064	2.79	.110	133.4	30.0

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 63893-3000				
Item	Order No	Engineering No.	Description	Quantity
Perishable Tooling				
	63893-3070	63893-3070	Tool Kit (All "Y" Items)	REF
1	11-18-5077	60816A106	Conductor Punch	1 Y
2	11-18-4997	60816A107	Conductor Anvil	1 Y
3	11-18-5327	60816B124	Insulation Punch	1 Y
4	11-18-5328	60816B125	Insulation Anvil	1 Y
5	11-18-4817	60800A113	Cut-Off Punch	1 Y
6	11-18-4808	60800A104	Rear Cut-off Die Blade	1 Y
Other Components (REF 933050)				
7	11-18-4810	60800A106	Rear Block	1
8	11-18-4811	60800A107	Compression Spring	1
9	11-18-4814	60800A110	Plunger	1
10	11-18-4815	60800A111	Guide Plate	1
11	11-18-4816	60800A112	Terminal Drag Plate	1
12	11-18-4818	60800A114	Mounting Block	1
13	11-18-4829	60800A125	Wire Stop	1
14	11-18-4848	60800A123	Spring Retainer	1
15	11-18-4849	60800A124	Wire Hold Down Spring	1
16	11-18-4894	60800A129	Knockout Spring	1
17	11-18-5005	60800D112	Hold Down Block	1
18	11-18-5006	60800D113	Spring Retainer	1
19	11-18-5007	60800D114	Compression Spring (Hold Down)	1
20	11-18-5008	60800A115	Hold Down Plunger	1
21	11-18-5015	60805A122	Front Cover	1
22	11-18-5117	60816A115	Tooling Washer	1
23	63803-5121	63803-5121	Conductor Bushing	1
Frame				
24	63801-3201	63801-3201	Top	1
25	63801-3282	63801-3282	Base	1
26	63801-6550	63801-6550	Track	1
Hardware				
27	N/A	N/A	M3 by 6 Long SHCS	6**
28	N/A	N/A	M3 by 25 Long SHCS	2**
29	N/A	N/A	M4 by 6 Long BHCS	2**
30	N/A	N/A	M4 by 8 Long BHCS	4**
31	N/A	N/A	M4 by 20 Long SHCS	2**
32	N/A	N/A	M5 by 10 Long SHCS	1**
33	N/A	N/A	M8 by 20 Long BHCS	1**
** Available from an industrial supply company such as MSC (1-800-645-7270).				

Assembly Drawing

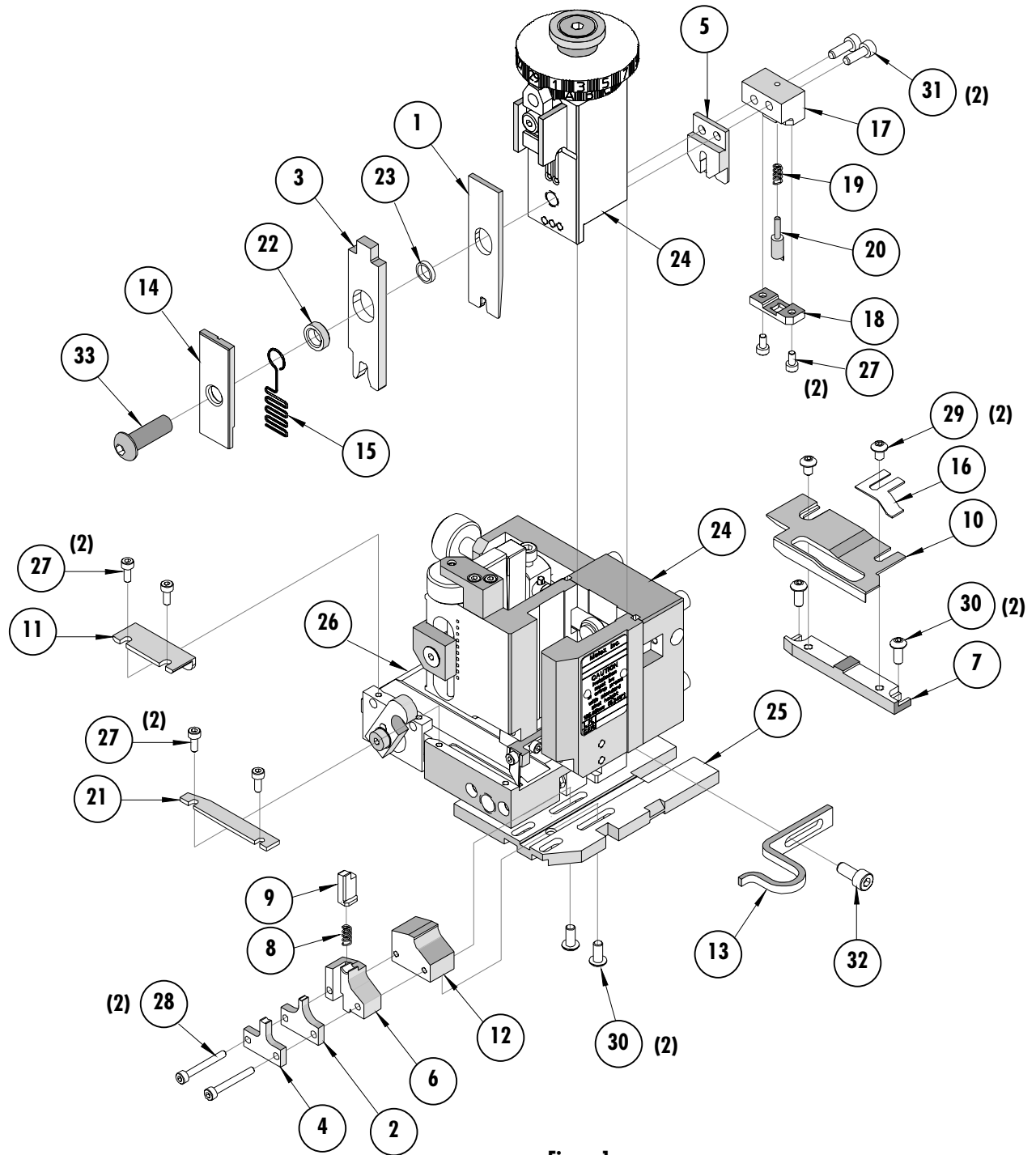


Figure 1

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 135.80mm (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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