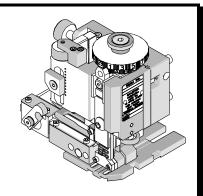


Mini-Mac Applicator **Specification Sheet** Order No. 63893-3300



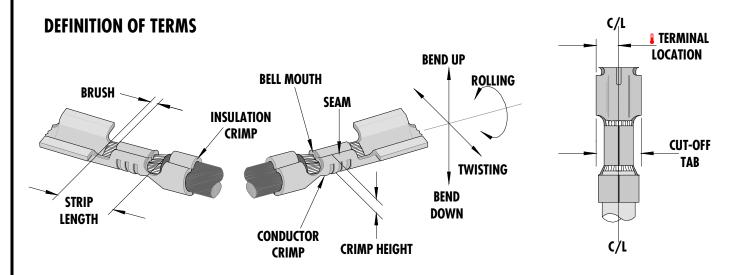
FEATURES

- 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 AWG.

Terminal Series No.	Terminal Order No.	Wi	re Size	Insulation	Diameter	Strip Length		
		AWG	mm²	mm	ln.	mm	ln.	
41483	02-09-1153	14-18	2.00-0.80	2.36-3.56	.093140	4.32-4.95	.170195	
42183	02-09-2170	14-18	2.00-0.80	2.36-3.56	.093140	4.32-4.95	.170195	
For optimum insulation crimp: the following applicators are recommended.								
63893-3100	Applicator should be used for insulation O.D. 2.36-4.57mm (.093180") and 18 AWG SPT-3 wires.							
63893-3300	Applicator should be used for insulation O.D. 2.36-3.56mm (.093140").							



■ 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.

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CRIMP SPECIFICATIONS

Terminal Series No.	Bell mouth		↓ Cut-	off Tab	Conductor Brush		
	mm	ln.	mm	ln.	mm	ln.	
41483			3.53-3.69	.139145			
42138			3.53-3.69	.139145			

	Bend up Bend down		Twist	Roll	Punch Width (Ref)				Seam
Terminal Series No.	Della op D	ciiu uowii	1 W131	KUII	Cond	uctor	Insul	ation	
	Degr	ee	Deg	ree	mm	ln.	mm	ln.	Seam shall not be open
41483					2.75	.108	3.87	.156	and no wire allowed out
42138					2.75	.108	3.87	.156	of the crimping area

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.

	Wire	Ciro		Pull Force				
Terminal Series No.	Wire Size		Crimp	Height	Crimp wi	Minimum		
	AWG	mm²	mm	ln.	mm	ln.	N	Lb.
	14	2.00	1.68-1.78	.066070	2.79	.110	177.9	40.0
41483	16	1.30	1.52-1.63	.060064	2.79	.110	155.6	35.0
	18	0.80	1.45-1.52	.057060	2.79	.110	133.4	30.0
	14	2.00	1.68-1.78	.066070	2.79	.110	177.9	40.0
42138	16	1.30	1.52-1.63	.060064	2.79	.110	155.6	35.0
	18	0.80	1.45-1.52	.057060	2.79	.110	133.4	30.0

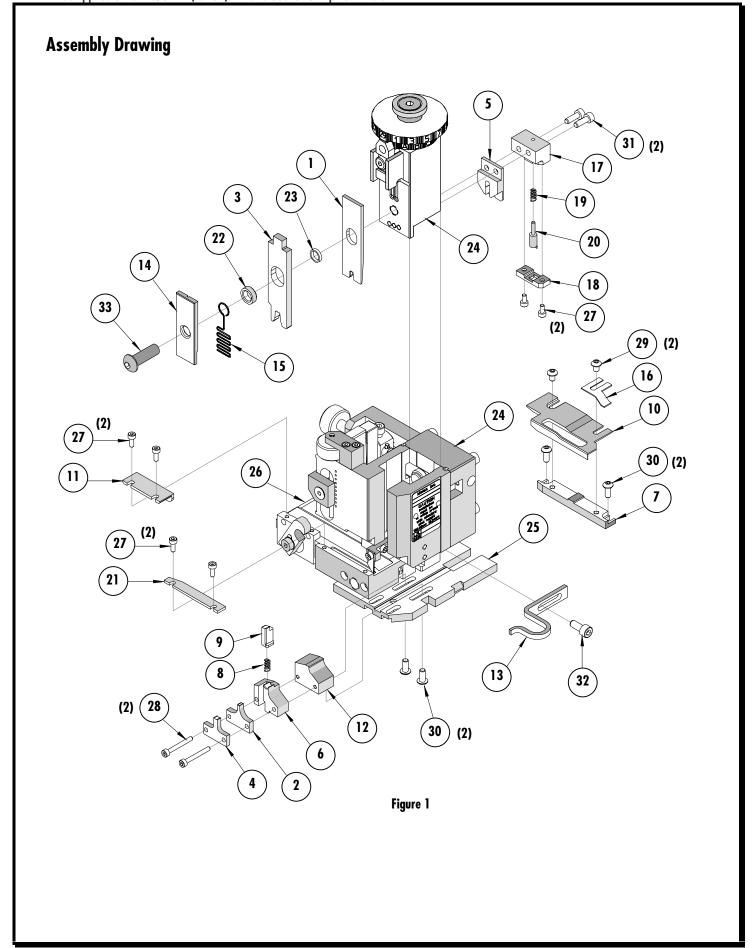
Pull Force should be measured with no influence from the insulation crimp. The above specifications are guidelines to an optimum crimp.

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PARTS LIST

Mini-Mac Applicator 63893-3300								
Item	Order No Engineering No. Description							
Item Order No Engineering No. Description Quantity Perishable Tooling								
	63893-3370	63893-3370	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	11-18-5332	60816E127	Insulation Punch	1 Y				
4	11-18-5331	60816D122	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 Compone	ents (REF 933350)					
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						
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				
		F	rame					
24	63801-3201	63801-3201	Тор	1				
25	63801-3282	63801-3282	Base	1				
26	63801-6550	63801-6550	Track	1				
		Hai	dware					
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]**				
*			company such as MSC (1-800-645-7	7270).				

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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 135.80mm (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.

Americas Headquarters Lisle, Illinois 60532 U.S.A. 1-800-78MOLEX amerinfo@molex.com

Far East North Headquarters Yamato, Kanagawa, Japan 81-462-65-2324 feninfo@molex.com

Far East South Headquarters Jurong, Singapore 65-6-268-6868 fesinfo@molex.com

European Headquarters Munich, Germany 49-89-413092-0 eurinfo@molex.com

Corporate Headquarters 2222 Wellington Ct. Lisle, IL 60532 U.S.A. 630-969-4550

Fax: 630-969-1352

Visit our Web site at http://www.molex.com

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