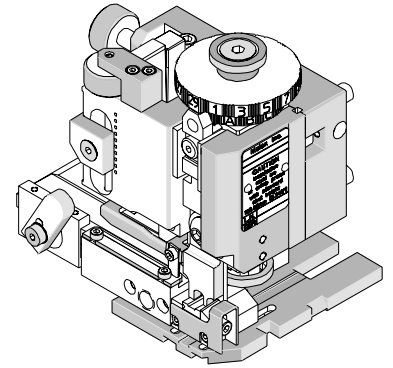




# Mini-Mac Applicator Specification Sheet Order No. 63894-4000



## FEATURES

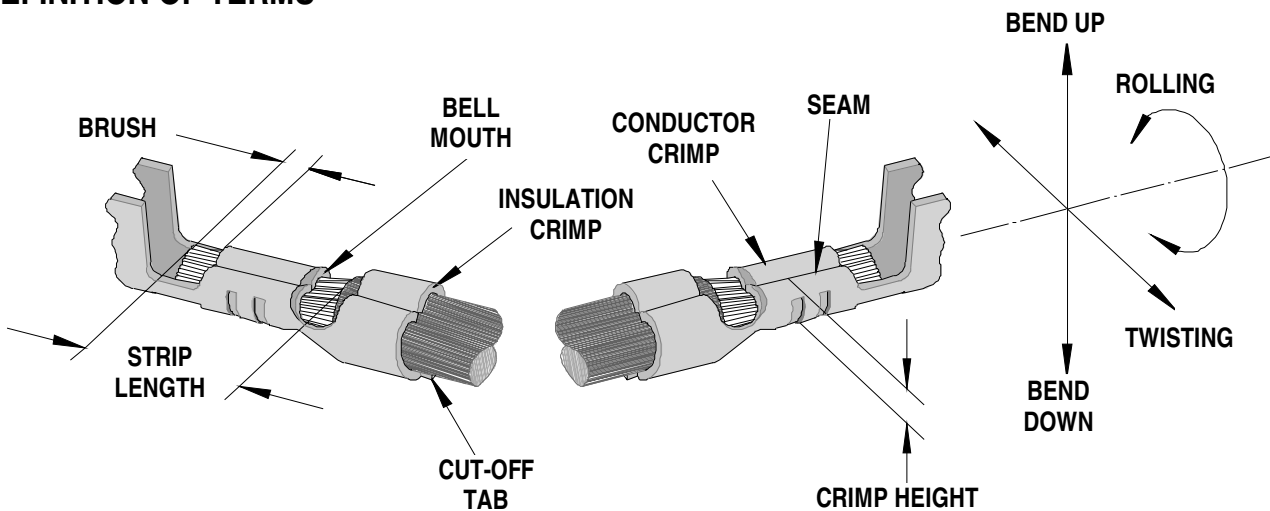
- Directly adapts to most automatic wire processing machines
- Applicator designed to industry standard mounting and shut height 135.80mm (5.346")
- Quick set-up time; plus the crimp height, track and feed adjustments can be set without removing the applicator from the press
- Fine adjustment allows 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: .093" Diameter Socket without Insulation Crimp, 16-20 AWG.

Terminal Series No.	Terminal Order No	Wire Size		Insulation Diameter Maximum		Strip Length	
		AWG	mm <sup>2</sup>	mm	In.	mm	In.
42464	02-09-1651	16-20	1.31-0.51	2.79	.110	3.96-5.33	.156-.218

## DEFINITION OF TERMS



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

**CRIMP SPECIFICATIONS**

Terminal Series No.	Bell mouth		Cut-off Tab Maximum		Conductor Brush	
	mm	In.	mm	In.	mm	In.
42464			0.13	.005		

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
	Degree		Degree		Conductor		
					mm	In	
42464					1.94	.076	

**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 (Ref)		N	Lb.
			mm	In.	mm	In.		
42464	16	1.31	1.17-1.22	.046-.048	1.94	.076	133.4	30
	18	0.82	1.12-1.17	.044-.046	1.94	.076	111.2	25
	20	0.51	1.04-1.09	.041-.043	1.94	.076	66.7	15

**PARTS LIST**

<b>Mini-Mac Applicator 63894-4000</b>				
<b>Item</b>	<b>Order No</b>	<b>Engineering No.</b>	<b>Description</b>	<b>Quantity</b>
<b>Perishable Tooling</b>				
	63894-4070	63894-4070	Tool Kit (All "Y" Items)	REF
1	11-18-5264	60831A106	Conductor Punch	1 Y
2	11-18-5292	60831A107	Conductor Anvil	1 Y
3	11-18-5263	60831A104	Front Cut-Off Plunger	1 Y
4	11-18-5265	60831A110	Front Cut-off Plunger Retainer	1 Y
<b>Other Components (944050)</b>				
5	11-18-4083	60707-8	Feed Guide	1
6	11-18-4810	60800A106	Rear Block	1
7	11-18-4815	60800A111	Guide Plate	1
8	11-18-4818	60800A114	Anvil Mount	1
9	11-18-5006	60800D113	Spring Retainer	1
10	11-18-5007	60800D114	Compression Spring (Hold Down)	1
11	11-18-5008	60800D115	Hold Down Plunger	1
12	11-18-5012	60804A123	Wire Stop	1
13	11-18-5109	60804A128	Front Plunger Striker	1
14	11-18-5111	60804A140	Knockout Blade	1
15	11-18-5114	60804A130	Scrap Deflector	1
16	11-18-5116	60804A141	Compression Spring (Knock out)	1
17	11-18-5266	60831A115	Tooling Washer	1
18	11-18-5267	60831A124	Hold Down Block	1
19	11-24-1067	4996-4	Cut Off Plunger Spring	1
20	63803-5127	63803-5127	Conductor Bushing	1
<b>Frame</b>				
21	63801-3201	63801-3201	Top	1
22	63801-3282	63801-3282	Base	1
23	63801-6550	63801-6550	Track	1
<b>Hardware</b>				
24	N/A	N/A	M3 by 6 Long SHCS	1**
25	N/A	N/A	M3 by 8 Long SHCS	2**
26	N/A	N/A	M3 by 20 Long SHCS	2**
27	N/A	N/A	M4 by 6 Long SHCS	3**
28	N/A	N/A	M4 by 8 Long BHCS	2**
29	N/A	N/A	M4 by 10 Long BHCS	2**
30	N/A	N/A	M4 by 16 Long SHCS	2**
31	N/A	N/A	M5 by 14 Long SHCS	1**
32	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

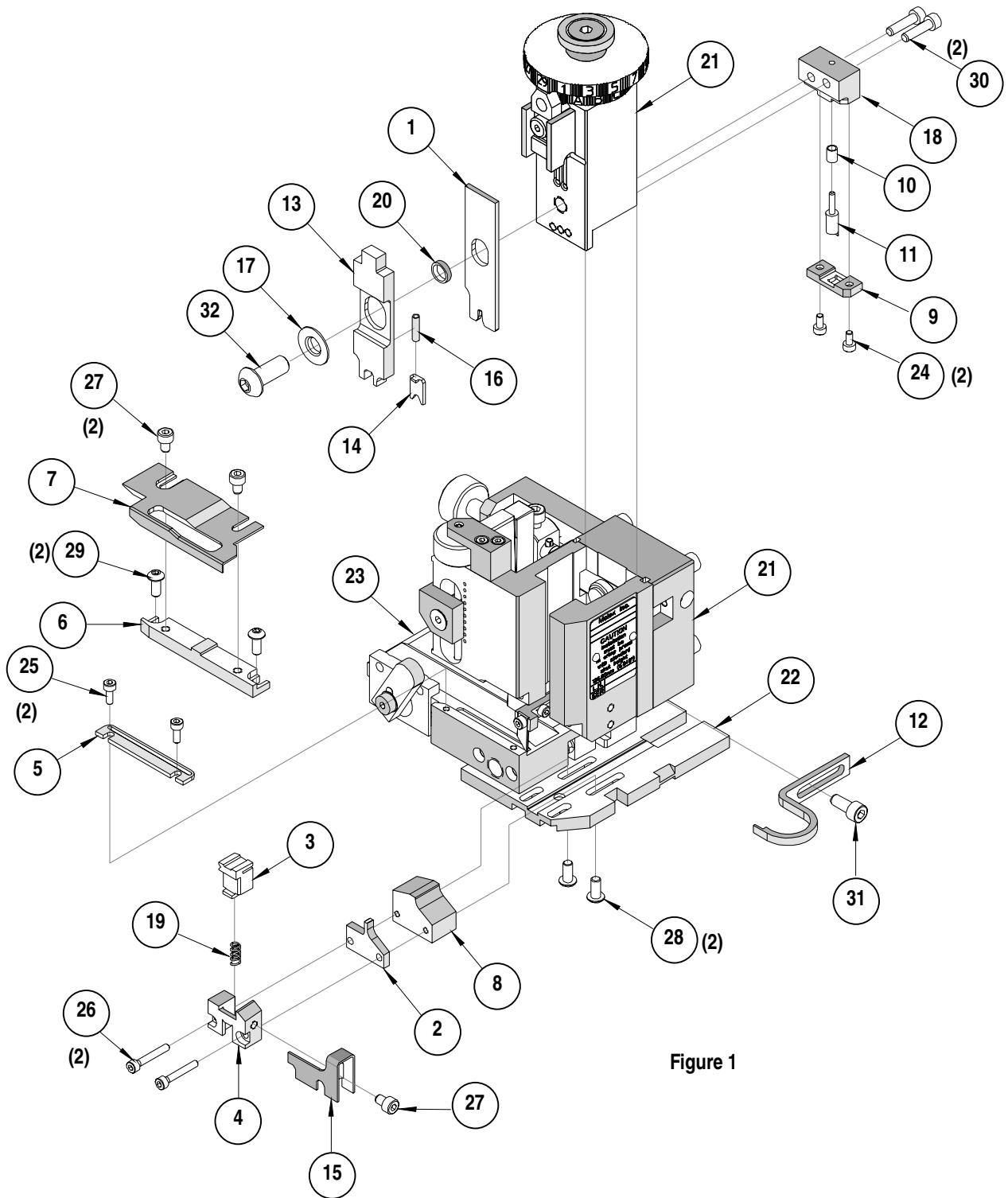


Figure 1

## 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 135.80 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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