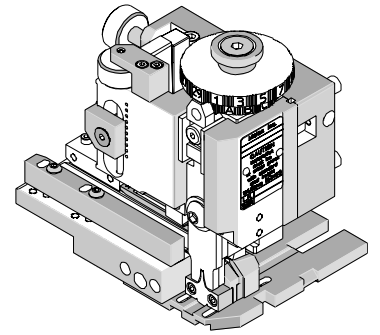




# Mini-Mac Applicator Specification Sheet Part No. 63882-2100



## FEATURES

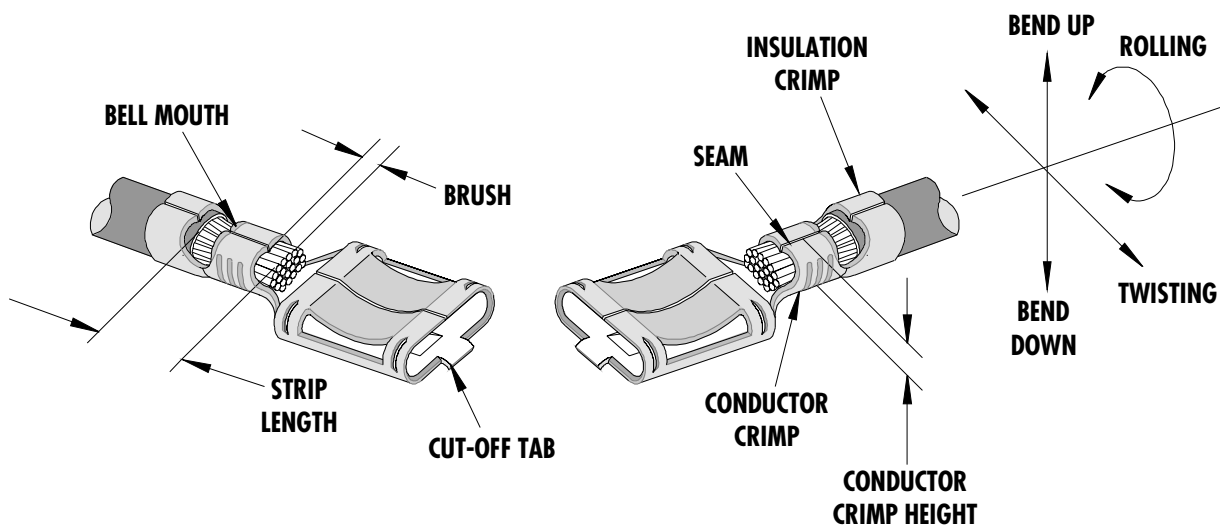
- Directly adapts to most automatic wire processing machines
- Applicator designed to industry standard mounting and shut height 135.80mm (5.346")
- Quick set-up time; plus the crimp height, track and feed adjustments can be set without removing the applicator from the press
- Fine adjustment allows 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: Flat Blade Crimp Terminal 22-28 AWG

Terminal Series No.	Terminal Reeled Order No	Wire Size		Insulation Diameter Maximum		Strip Length	
		AWG	mm <sup>2</sup>	mm	In.	mm	In.
2799	05-06-0307	22-28	0.35-0.08	1.73	.068	3.55-4.75	.140-.187
7676-IATO	05-06-0313	22-28	0.35-0.08	1.73	.068	3.55-4.75	.140-.187

## 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		Conductor Brush	
	mm	In.	mm	In.	mm	In.
2799			0.26-0.46	.010-.018		
7676			0.26-0.46	.010-.018		

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		Insulation		
					mm	In	mm	In	
2799					1.93	.076	1.96	.077	
7676					1.93	.076	1.96	.077	

**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.

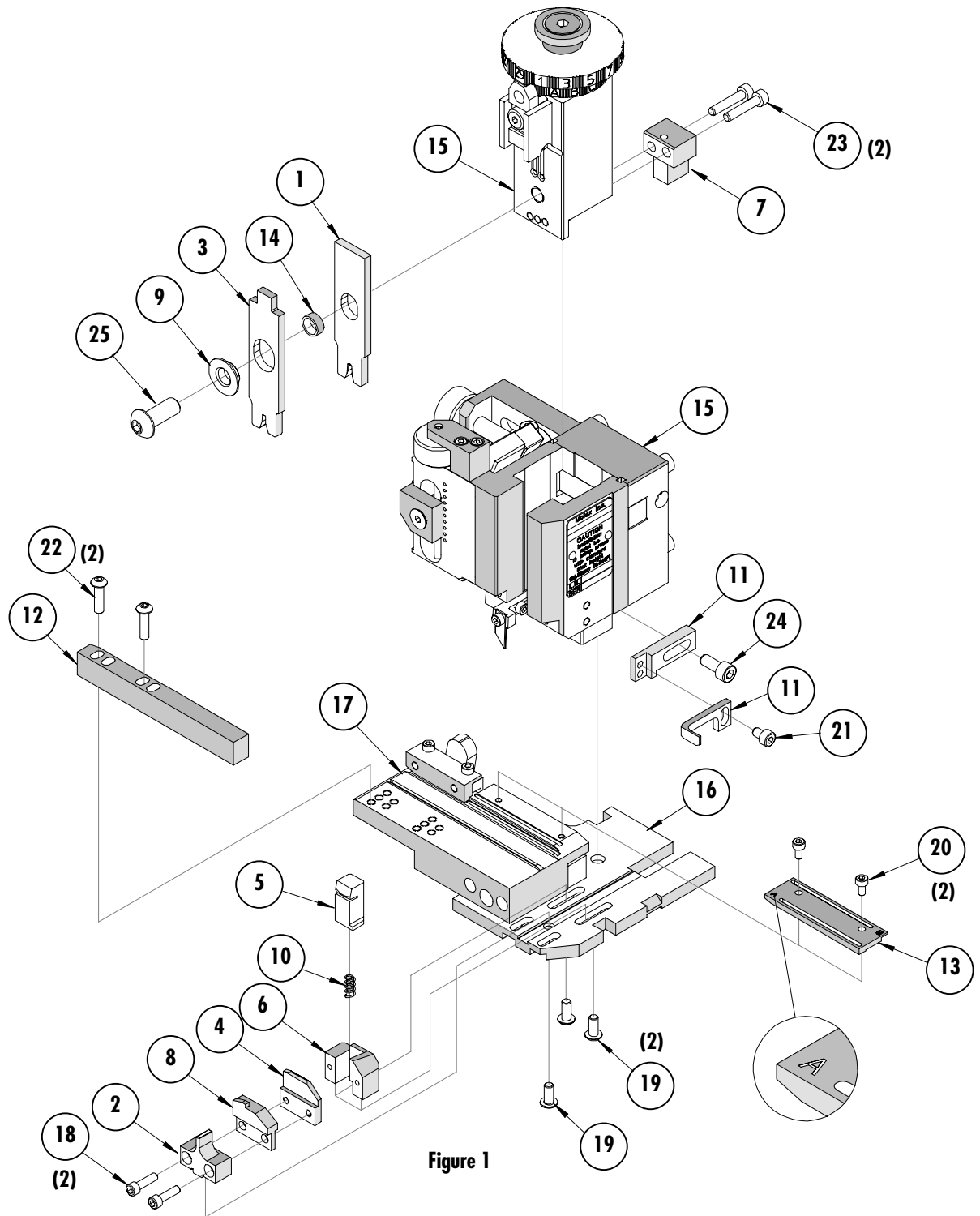
Terminal Series No.	Wire Size		Conductor Crimp Height		Pull Force Minimum	
	AWG	mm <sup>2</sup>	mm	In.	N	Lb.
2799	22	0.35	0.94-0.99	.037-.039	53.4	12.0
	24	0.20	0.89-0.94	.035-.037	35.6	8.0
	26	0.12	0.84-0.89	.033-.035	26.7	6.0
	28	0.08	0.81-0.86	.032-.034	17.8	4.0
7676	22	0.35	0.94-0.99	.037-.039	53.4	12.0
	24	0.20	0.89-0.94	.035-.037	35.6	8.0
	26	0.12	0.84-0.89	.033-.035	26.7	6.0
	28	0.08	0.81-0.86	.032-.034	17.8	4.0

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

**PARTS LIST**

<b>Mini-Mac Applicator 63882-2100</b>				
Item	Order No	Engineering No.	Description	Quantity
<b>Perishable Tooling</b>				
	63882-2170	63882-2170	Tool Kit (All "Y" Items)	REF.
1	11-18-4200	60711A201	Conductor Punch	1 Y
2	11-18-4201	60711A202	Combination Anvil	1 Y
3	11-18-4202	60711A203	Insulation Punch	1 Y
4	11-18-4193	60711A104	Cut-off Blade	1 Y
5	11-18-4194	60711A105	Cut-Off Plunger	1 Y
6	11-18-4090	60709A107	Plunger Retainer	1 Y
<b>Other Components (REF 822050)</b>				
7	11-18-4091	60709A108	Rear Plunger Striker	1
8	11-18-4195	60711A106	Spacer	1
9	11-18-4199	60711A110	Tooling Washer	1
10	11-24-1067	4996-4	Cut-Off Plunger Spring	1
11	63443-0090	63443-0090	Wire Stop	1
12	63801-4510	63801-4510	Front Cover	1
13	63801-4558	63801-4558	Rear Cover	1
14	63803-5105	63803-5105	Conductor Bushing	1
<b>Frame</b>				
15	63801-3201	63801-3201	Top	1
16	63801-3282	63801-3282	Base	1
17	63801-6650	63801-6650	Track	1
<b>Hardware</b>				
18	N/A	N/A	#6-32 by 1/2" Long SHCS	2**
19	N/A	N/A	#8-32 by 3/8" Long BHCS	3**
20	N/A	N/A	M3 by 6 Long SHCS	2**
21	N/A	N/A	M4 by 6 Long SHCS	1**
22	N/A	N/A	M4 by 16 Long BHCS	2**
23	N/A	N/A	M4 by 18 Long SHCS	2**
24	N/A	N/A	M5 by 8 Long SHCS	1**
25	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



## 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 135.8 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.

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