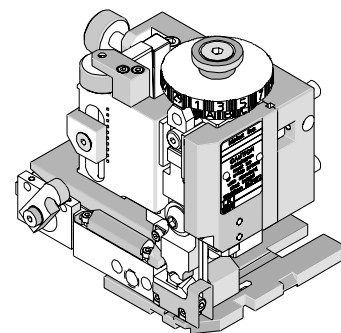




## Mini-Mac Applicator Specification Sheet Order No. 63894-1000



### 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.

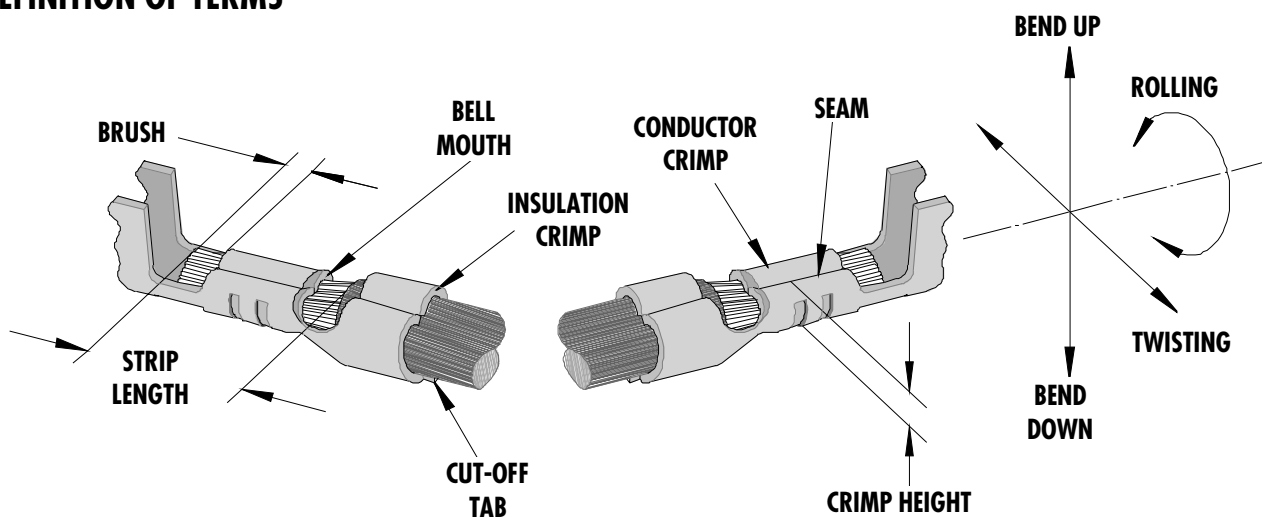
### SCOPE

Products: Flat Blade Crimp Terminals, 16-20 AWG.

| Terminal Series No. | Terminal Order No | Wire Size |                 | Insulation Diameter Max. |      | Strip Length |           |
|---------------------|-------------------|-----------|-----------------|--------------------------|------|--------------|-----------|
|                     |                   | AWG       | mm <sup>2</sup> | mm                       | In.  | mm           | In.       |
| 1508                | 05-06-0117        | 16-20     | 1.30-0.50       | 3.55                     | .140 | 3.96-5.35    | .156-.218 |
| 2776                | Ⓟ                 | 16-20     | 1.30-0.50       | 3.55                     | .140 | 3.96-5.35    | .156-.218 |

For 14 AWG and double wire crimp applications 63894-1100 is recommended.  
Ⓟ Consult your Molex sales representative for details.

### 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 Max. |      | Conductor Brush |     |
|---------------------|------------|-----|------------------|------|-----------------|-----|
|                     | mm         | In. | mm               | In.  | mm              | In. |
| 1508                |            |     |                  |      |                 |     |
| 2776                |            |     | 0.50             | .020 |                 |     |

| Terminal Series No.                                                                                                                                                                                                                                                                     | Bend up | Bend down | Twist  | Roll | Punch Width (Ref) |      |            |      |
|-----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|---------|-----------|--------|------|-------------------|------|------------|------|
|                                                                                                                                                                                                                                                                                         | Degree  |           | Degree |      | Conductor         |      | Insulation |      |
|                                                                                                                                                                                                                                                                                         |         |           |        |      | mm                | In.  | mm         | In.  |
| 1508                                                                                                                                                                                                                                                                                    |         |           |        |      | 2.30              | .091 | 3.10       | .122 |
| 2776                                                                                                                                                                                                                                                                                    |         |           |        |      | 2.30              | .091 | 3.10       | .122 |
| <b>Seam</b><br>Seam shall not be open and no wire allowed out of the crimping area<br>16 AWG UL Style 1015 may have pinched strands or an open seam. This condition is normal and does not effect crimp performance. The customer should determine suitability for the end application. |         |           |        |      |                   |      |            |      |

**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 |           | N                  | Lb.   |
|                     |                        |      | mm           | In.       | mm          | In.       |                    |       |
| 1508                | 16                     | 1.30 | 1.60-1.70    | .063-.067 | 2.30-2.47   | .091-.097 | 191.3              | 43.00 |
|                     | 18                     | 0.80 | 1.47-1.55    | .058-.061 | 2.30-2.45   | .091-.096 | 120.1              | 27.00 |
|                     | 20                     | 0.50 | 1.37-1.45    | .054-.057 | 2.30-2.42   | .091-.095 | 89.0               | 20.00 |
| 2776                | 16                     | 1.30 | 1.60-1.70    | .063-.067 | 2.30-2.47   | .091-.097 | 191.3              | 43.00 |
|                     | 18                     | 0.80 | 1.47-1.55    | .058-.061 | 2.30-2.45   | .091-.096 | 120.1              | 27.00 |
|                     | 20                     | 0.50 | 1.37-1.45    | .054-.057 | 2.30-2.42   | .091-.095 | 89.0               | 20.00 |

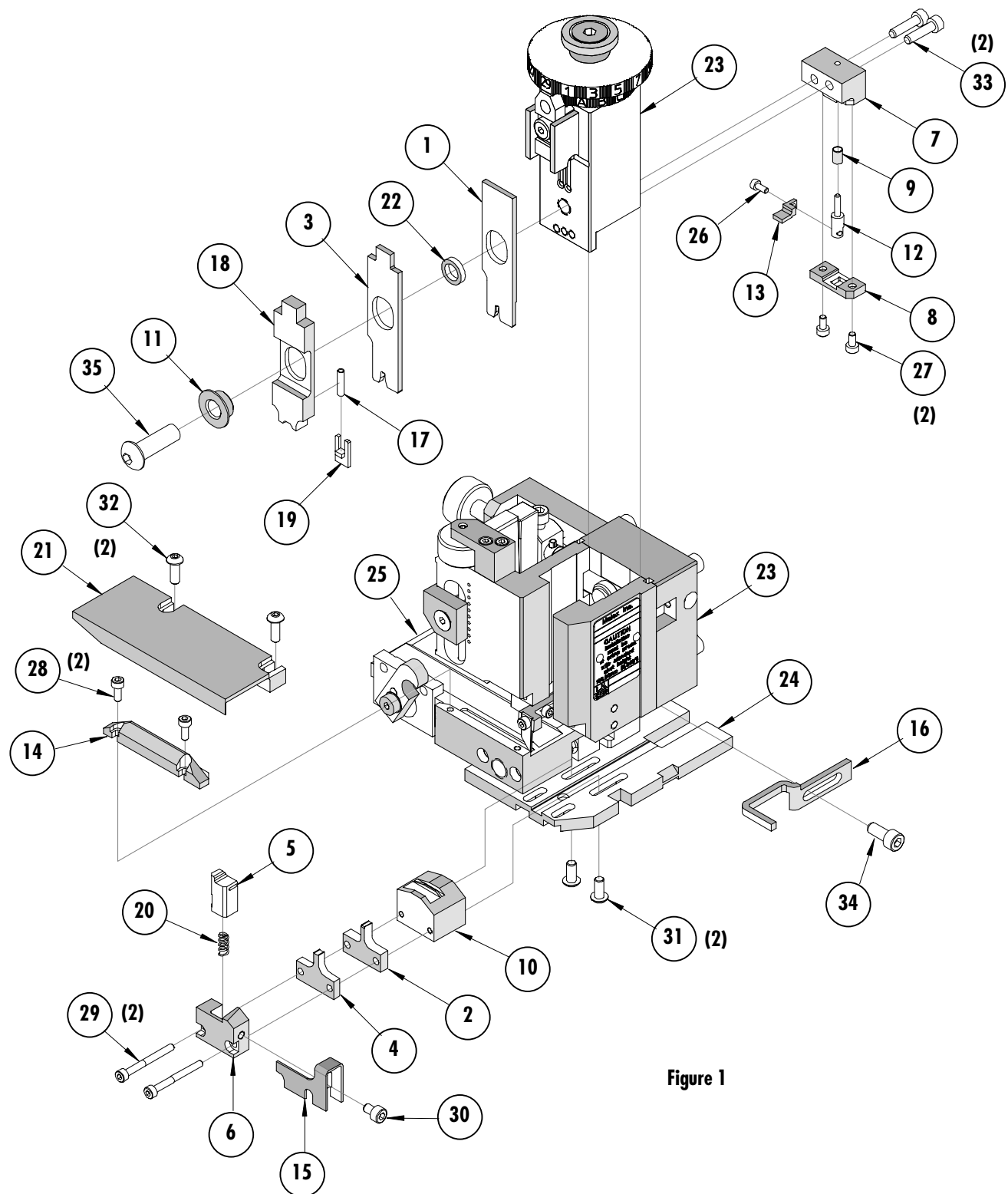
Pull Force should be measured with no influence from the insulation crimp.

The above specifications are guidelines to an optimum crimp.

**PARTS LIST**

| <b>Mini-Mac Applicator 63894-1000</b>                                        |                 |                        |                                |                 |
|------------------------------------------------------------------------------|-----------------|------------------------|--------------------------------|-----------------|
| <b>Item</b>                                                                  | <b>Order No</b> | <b>Engineering No.</b> | <b>Description</b>             | <b>Quantity</b> |
| <b>Perishable Tooling</b>                                                    |                 |                        |                                |                 |
|                                                                              | 63894-1070      | 63894-1070             | Tool Kit (All "Y" Items)       | REF             |
| 1                                                                            | 11-18-5061      | 60811A106              | Conductor Punch                | 1 Y             |
| 2                                                                            | 11-18-4896      | 60804A102              | Conductor Anvil                | 1 Y             |
| 3                                                                            | 11-18-5062      | 60811A108              | Insulation Punch               | 1 Y             |
| 4                                                                            | 11-18-5063      | 60811A109              | Insulation Anvil               | 1 Y             |
| 5                                                                            | 11-18-5376      | 60804F144              | Front Cut-Off Plunger          | 1 Y             |
| 6                                                                            | 11-18-5375      | 60804F143              | Front Cut-off Plunger Retainer | 1 Y             |
| <b>Other Components (941050)</b>                                             |                 |                        |                                |                 |
| 7                                                                            | 11-18-5005      | 60800D112              | Hold Down Block                | 1               |
| 8                                                                            | 11-18-5006      | 60800D113              | Spring Retainer                | 1               |
| 9                                                                            | 11-18-5007      | 60800D114              | Compression Spring (Hold Down) | 1               |
| 10                                                                           | 11-18-5064      | 60811A111              | Anvil Mount                    | 1               |
| 11                                                                           | 11-18-5065      | 60811A115              | Tooling Washer                 | 1               |
| 12                                                                           | 11-18-5067      | 60811A121              | Hold Down Plunger              | 1               |
| 13                                                                           | 11-18-5068      | 60811A122              | Hold Down 1508 Terminal        | 1               |
| 14                                                                           | 11-18-5110      | 60804A129              | Front Cover                    | 1               |
| 15                                                                           | 11-18-5114      | 60804A130              | Scrap Deflector                | 1               |
| 16                                                                           | 11-18-5115      | 60805A119              | Wire Stop                      | 1               |
| 17                                                                           | 11-18-5116      | 60804A141              | Compression Spring (Knock out) | 1               |
| 18                                                                           | 11-18-5352      | 60804D140              | Front Plunger Striker          | 1               |
| 19                                                                           | 11-18-5374      | 60804F142              | Knockout Blade                 | 1               |
| 20                                                                           | 11-24-1067      | 4996-4                 | Cut Off Plunger Spring         | 1               |
| 21                                                                           | 63443-6125      | 63443-6125             | Rear Cover                     | 1               |
| 22                                                                           | 63803-5118      | 63803-5118             | Conductor Bushing              | 1               |
| <b>Frame</b>                                                                 |                 |                        |                                |                 |
| 23                                                                           | 63801-3201      | 63801-3201             | Top                            | 1               |
| 24                                                                           | 63801-3282      | 63801-3282             | Base                           | 1               |
| 25                                                                           | 63801-6550      | 63801-6550             | Track                          | 1               |
| <b>Hardware</b>                                                              |                 |                        |                                |                 |
| 26                                                                           | N/A             | N/A                    | M2.5 by 6 Long SHCS            | 1**             |
| 27                                                                           | N/A             | N/A                    | M3 by 6 Long SHCS              | 2**             |
| 28                                                                           | N/A             | N/A                    | M3 by 8 Long SHCS              | 2**             |
| 29                                                                           | N/A             | N/A                    | M3 by 20 Long SHCS             | 2**             |
| 30                                                                           | N/A             | N/A                    | M4 by 6 Long SHCS              | 1**             |
| 31                                                                           | N/A             | N/A                    | M4 by 8 Long BHCS              | 2**             |
| 32                                                                           | N/A             | N/A                    | M4 by 12 Long BHCS             | 2**             |
| 33                                                                           | N/A             | N/A                    | M4 by 16 Long SHCS             | 2**             |
| 34                                                                           | N/A             | N/A                    | M5 by 14 Long SHCS             | 1**             |
| 35                                                                           | 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 135.80 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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