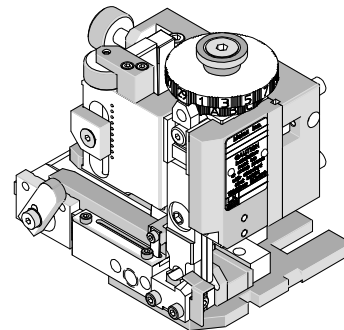




## Mini-Mac Applicator Application Tooling Specification Mechanical Feed-Front Metal Strip Order No. 63895-0800



### FEATURES

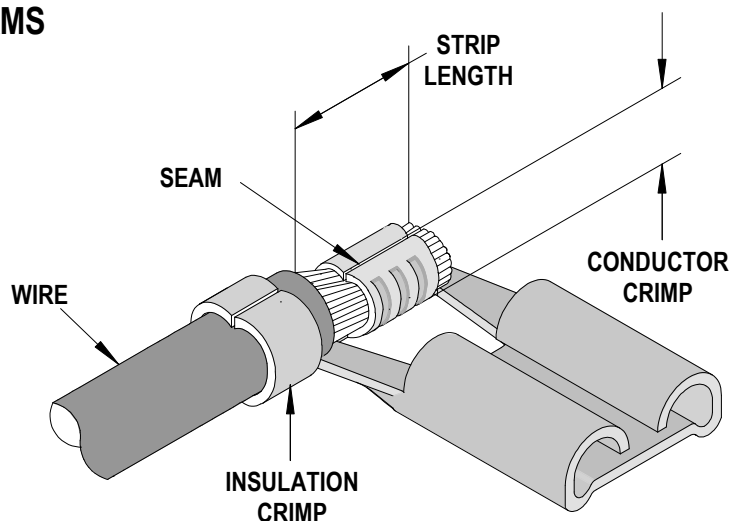
- Directly adapts to most automatic wire processing machines
- Applicator designed to industry standard mounting and shut height 135.80mm (5.346")
- Quick set-up time; plus the crimp height, track and feed adjustments can be set without removing the applicator from the press
- Fine adjustment allows 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: Quick Disconnect, Female, Flag, for 0.50-1.00mm<sup>2</sup> (18-20 AWG) Wire, Accepts 6.35mm (.250") by 0.81mm (.032") Tab Crimp Terminals.

| Terminal Series No.                                                            | Terminal Order No. |            | Wire Size |                 | Insulation Diameter |           |                   |      | Strip Length |           |
|--------------------------------------------------------------------------------|--------------------|------------|-----------|-----------------|---------------------|-----------|-------------------|------|--------------|-----------|
|                                                                                |                    |            |           |                 | IPC/WHMA-A620 ♦     |           | Terminal (Max) ♦♦ |      |              |           |
|                                                                                |                    |            | AWG       | mm <sup>2</sup> | mm                  | In.       | mm                | In.  | mm           | In.       |
| 94030                                                                          | 94030-5010         | 94030-5011 | -         | 2.50            | 2.10-2.60           | .083-.102 | 3.70              | .146 | 6.00-7.00    | .236-.276 |
|                                                                                |                    |            | -         | 1.50            |                     |           |                   |      |              |           |
|                                                                                |                    |            | -         | 1.00            |                     |           |                   |      |              |           |
| ♦ To achieve optimum IPC-A620 insulation crimps, use this insulation OD range. |                    |            |           |                 |                     |           |                   |      |              |           |
| ♦♦ Overall insulation OD specification for terminal.                           |                    |            |           |                 |                     |           |                   |      |              |           |

### DEFINITION OF TERMS



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

**CRIMP SPECIFICATION**

After crimping, the crimp profiles should measure the following:

| Terminal Series No. | Wire Size |      | Conductor    |           |                     |      | Insulation         |           |                     |      | Pull Force Minimum |       |
|---------------------|-----------|------|--------------|-----------|---------------------|------|--------------------|-----------|---------------------|------|--------------------|-------|
|                     |           |      | Crimp Height |           | Crimp Width Maximum |      | Crimp Height (Ref) |           | Crimp Width Maximum |      |                    |       |
|                     | AWG       | mm²  | mm           | In.       | mm                  | In.  | mm                 | In.       | mm                  | In.  | N                  | Lb.   |
| 94030               | -         | 2.50 | 2.05-2.15    | .081-.085 | 2.95                | .116 | 3.35-3.45          | .132-.136 | 4.50                | .177 | 245.2              | 55.12 |
|                     | -         | 1.50 | 1.85-1.95    | .073-.077 | 2.95                | .116 | 2.85-2.95          | .112-.116 | 4.50                | .177 | 196.1              | 44.09 |
|                     | -         | 1.00 | 1.70-1.80    | .067-.071 | 2.95                | .116 | 2.70-2.80          | .106-.110 | 4.50                | .177 | 156.9              | 35.27 |

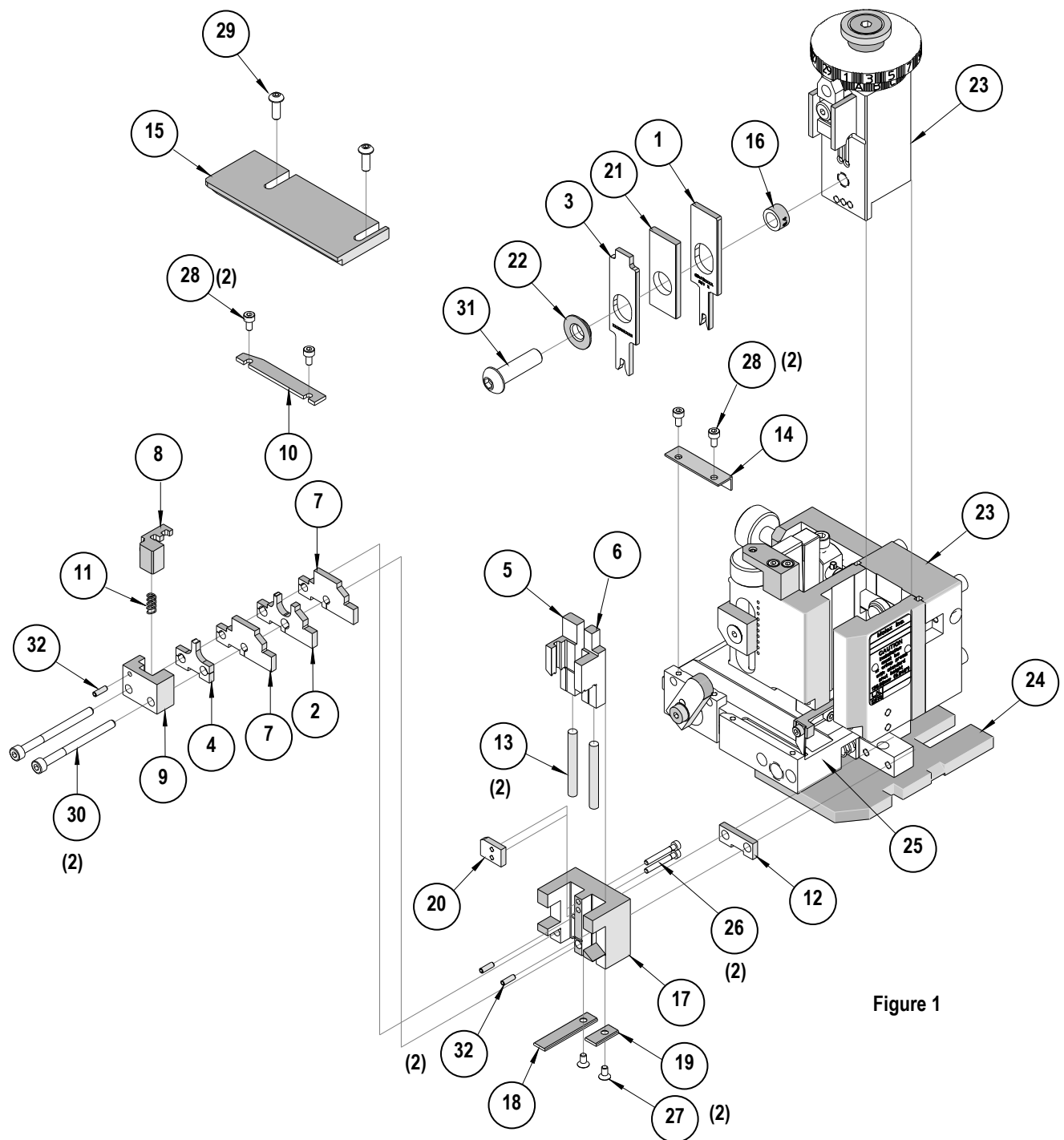
\* Tool Qualification Notes:

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

**PARTS LIST**

| <b>Mini-Mac Applicator 63895-0800</b>                                        |                 |                        |                          |                 |
|------------------------------------------------------------------------------|-----------------|------------------------|--------------------------|-----------------|
| <b>Item</b>                                                                  | <b>Order No</b> | <b>Engineering No.</b> | <b>Description</b>       | <b>Quantity</b> |
| <b>Perishable Tooling</b>                                                    |                 |                        |                          |                 |
|                                                                              | 63895-0870      | 63895-0870             | Tool Kit (All "Y" Items) | REF             |
| 1                                                                            | 63475-0003      | 63475-0003             | Conductor Punch-2.80pw   | 1 Y             |
| 2                                                                            | 63895-0802      | 63895-0802             | Anvil                    | 1 Y             |
| 3                                                                            | 63476-0003      | 63476-0003             | Insulation Punch-4.40pw  | 1 Y             |
| 4                                                                            | 63456-0056      | 63456-0056             | Insulation Anvil         | 1 Y             |
| 5                                                                            | 63895-0705      | 63895-0705             | Cut Punch Left           | 1 Y             |
| 6                                                                            | 63895-0706      | 63895-0706             | Cut Punch Right          | 1 Y             |
| 7                                                                            | 63895-0703      | 63895-0703             | Cut-Off Die-Front        | 2 Y             |
| 8                                                                            | 63895-0735      | 63895-0735             | Lifter                   | 1 Y             |
| 9                                                                            | 63895-0734      | 63895-0734             | Retainer Lifter          | 1 Y             |
| <b>Other Components (Ref. 50850)</b>                                         |                 |                        |                          |                 |
| 10                                                                           | 11-18-5015      | 60805A122              | Front Cover              | 1               |
| 11                                                                           | 11-24-1067      | 4996-4                 | Cut Off Plunger Spring   | 1               |
| 12                                                                           | 63443-2310      | 63443-2310             | 3.50mm Spacer            | 1               |
| 13                                                                           | 63600-2995      | 63600-2995             | Compression Spring       | 2               |
| 14                                                                           | 63890-0042      | 63890-0042             | Terminal Drag Cover      | 1               |
| 15                                                                           | 63890-0046      | 63890-0046             | Rear Cover               | 1               |
| 16                                                                           | 63890-0866      | 63890-0866             | Collar-6.40 Long         | 1               |
| 17                                                                           | 63895-0731      | 63895-0731             | Guide Cut Punch          | 1               |
| 18                                                                           | 63895-0732      | 63895-0732             | Key 37                   | 1               |
| 19                                                                           | 63895-0733      | 63895-0733             | Key 16                   | 1               |
| 20                                                                           | 63895-0736      | 63895-0736             | Wire Stop                | 1               |
| 21                                                                           | 63895-0737      | 63895-0737             | Punch Spacer 3.65        | 1               |
| 22                                                                           | 63895-0738      | 63895-0738             | Tooling Washer           | 1               |
| <b>Frame</b>                                                                 |                 |                        |                          |                 |
| 23                                                                           | 63801-3201      | 63801-3201             | Top                      | 1               |
| 24                                                                           | 63801-3281      | 63801-3281             | Base                     | 1               |
| 25                                                                           | 63801-4650      | 63801-4650             | Track                    | 1               |
| <b>Hardware</b>                                                              |                 |                        |                          |                 |
| 26                                                                           | N/A             | N/A                    | M2.5 by 20 Long SHCS     | 2**             |
| 27                                                                           | N/A             | N/A                    | M3 by 6 Long FHCS        | 2**             |
| 28                                                                           | N/A             | N/A                    | M3 by 6 Long SHCS        | 4**             |
| 29                                                                           | N/A             | N/A                    | M4 by 12 Long BHCS       | 2**             |
| 30                                                                           | N/A             | N/A                    | M4 by 50 Long SHCS       | 2**             |
| 31                                                                           | N/A             | N/A                    | M8 by 35 Long BHCS       | 1**             |
| 32                                                                           | N/A             | N/A                    | 2.5mm by 8 Lg Roll Pin   | 3**             |
| ** 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 with 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 Applicator Manual (Document no. 63880-0000).

**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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