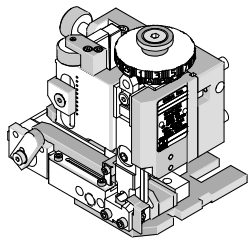
Mini-Mac Applicator

molex

Application Tooling Specification Sheet



Order No. 63888-1000

FEATURES

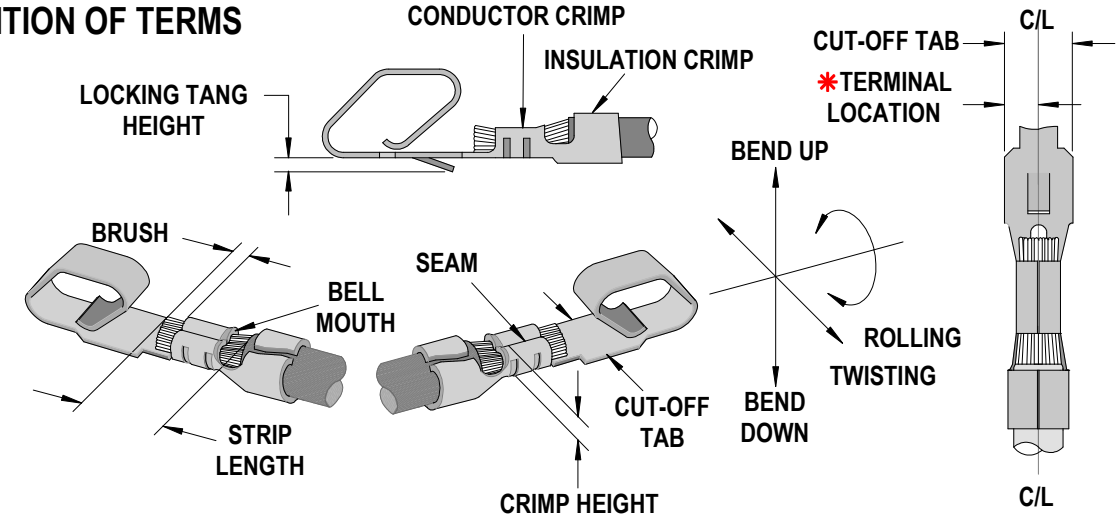
- Directly adapts to most automatic wire processing machines
- Applicator designed to industry standard mounting and shut height 135.80mm (5.346")
- Quick set-up time; plus the crimp height, track and feed adjustments can be set without removing the applicator from the press
- Fine adjustment allows 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
- Pilot pin in cut-off punch produces symmetrical cut-off tabs and consistent cut-off tab length, see terminal strip adjustment on page 3.

SCOPE

Products: Trifurcon™ Crimp Terminal, 22-26 AWG.

Terminal Series No.	Terminal Order No.				Wire Size		Insulation Diameter Maximum		Strip Length	
					AWG	mm²	mm	In.	mm	In.
2578	08-50-0018	08-50-0061	08-50-0065	08-50-0107	22-26	0.35-0.12	1.65	.065	2.54-3.18	.100-.125
	08-50-0111	08-50-0133	08-50-0504	08-52-0116						
	08-55-0105	08-55-0121	08-55-0123	08-56-0107						
	08-56-0121	08-56-0161	08-56-0162	08-58-0125						
	08-59-0101	08-60-0003	08-65-0108	08-65-0110						
	08-65-0116	40-01-0117	40-07-1105	50-29-1767						
	50-29-1877									
7258	08-04-0001	08-50-0183	08-52-0124	08-56-0123	22-26	0.35-0.12	1.65	.065	2.54-3.18	.100-.125
	08-56-0181	08-58-0133	08-65-0121	08-65-0126						

DEFINITION OF TERMS



✱ Terminal is to be centrally located between the two (2) cut-off tab edges by one half of the total cut-off tab tolerance.

CRIMP SPECIFICATIONS

Terminal Series No.	Bell mouth (Ref)		✱Cut-off Tab		Conductor Brush Maximum (Ref)	
	mm	In.	mm	In.	mm	In.
2578	0.08-0.48	.003-.019	2.64-2.80	.104-.110	1.00	.039
7258	0.08-0.48	.003-.019	2.64-2.80	.104-.110	1.00	.039

Terminal Series No.	Locking Tang Height		Bend up Bend down		Twist Roll		Punch Width (Ref)				Seam
							Conductor		Insulation		
	mm	In	Degree		Degree		mm	In	mm	In	
2578	0.64-0.76	.025-.030					1.55	.061	1.95	.077	Seam shall not be open and no wire allowed out of the crimping area
7258	0.63-0.79	.025-.031					1.55	.061	1.95	.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		Crimp Height		Crimp Width (Ref)		Pull Force Minimum	
	AWG	mm²	mm	In.	mm	In.	N	Lb.
2578	22	0.35	0.96-1.01	.038-.040	1.56	.061	44.48	10.0
	24	0.20	0.91-0.96	.036-.038	1.56	.061	35.59	8.0
	26	0.12	0.86-0.91	.034-.036	1.56	.061	26.69	6.0
7258	22	0.35	0.96-1.01	.038-.040	1.56	.061	44.48	10.0
	24	0.20	0.91-0.96	.036-.038	1.56	.061	35.59	8.0
	26	0.12	0.86-0.91	.034-.036	1.56	.061	26.69	6.0

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.

Terminal Strip Adjustment

The terminal strip hole must be aligned to the pilot pin before crimping under power. Hand cycle the press several times to check the alignment of the pilot pin to the terminal strip hole before crimping under power. Use the track adjusting screw and the terminal position adjusting knob to align the terminal strip hole to the pilot pin.

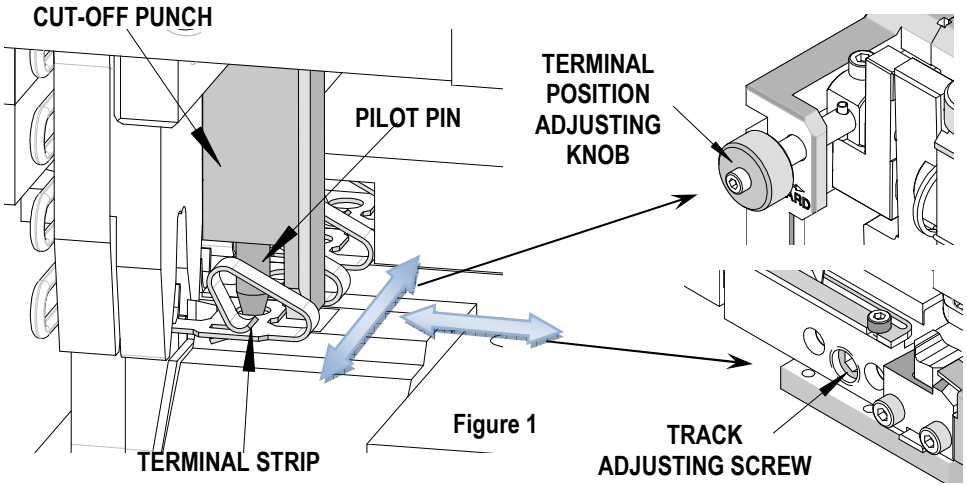


Figure 1

PARTS LIST

Mini-Mac Applicator 63888-1000				
Item	**Order No**	**Engineering No.**	**Description**	**Quantity**
Perishable Tooling				
	63888-1070	63888-1070	Tool Kit (All "Y" Items)	REF
1	11-18-4114	60712-14	Conductor Punch	1 Y
2	11-18-4115	60712-15	Conductor Anvil	1 Y
3	11-18-4113	60712-13	Insulation Punch	1 Y
4	11-18-4116	60712-16	Insulation Anvil	1 Y
5	63820-0038	63820-0038	Cut-Off Punch	1 Y
6	11-18-4470	60712-24	Cut-Off Insert	1 Y
Other Components				
7	11-18-4006	60703-8	Stripper Blade Holder	1
8	11-18-4103	60712-3	Cover Plate	1
9	11-18-4106	60712-6	Insulation Punch Spacer	1
10	11-18-4332	60703-16	Stripper	1
11	11-18-4471	60712-25	Retainer Block	1
12	11-18-5015	60805A122	Front Cover	1
13	11-40-4085	8301-10	Terminal Stop and Scrape Shield	1
14	63803-5119	63803-5119	Conductor Bushing	1
15	63820-0012	63820-0012	Cover-Drag Frame	1
16	63600-4664	63600-4664	Compression Spring	2
Frame				
17	63801-3201	63801-3201	Top	1
18	63801-3283	63801-3283	Base	1
19	63801-6950	63801-6950	Track	1
Hardware				
20	N/A	N/A	M3 by 6 Long SHCS	4**
21	N/A	N/A	M4 by 6 Long SHCS	2**
22	N/A	N/A	M4 by 12 Long BHCS	2**
23	N/A	N/A	M5 by 10 Long SHCS	1**
24	N/A	N/A	M8 by 20 Long BHCS	1**
25	N/A	N/A	#4-40 by 5/8" Long SHCS	2**
26	N/A	N/A	#6-32 by 3/8" Long BHCS	2**
27	N/A	N/A	#10-32 by 1.120" Long SHCS	1**
** Available from an industrial supply company such as MSC (1-800-645-7270).				

Assembly Drawing

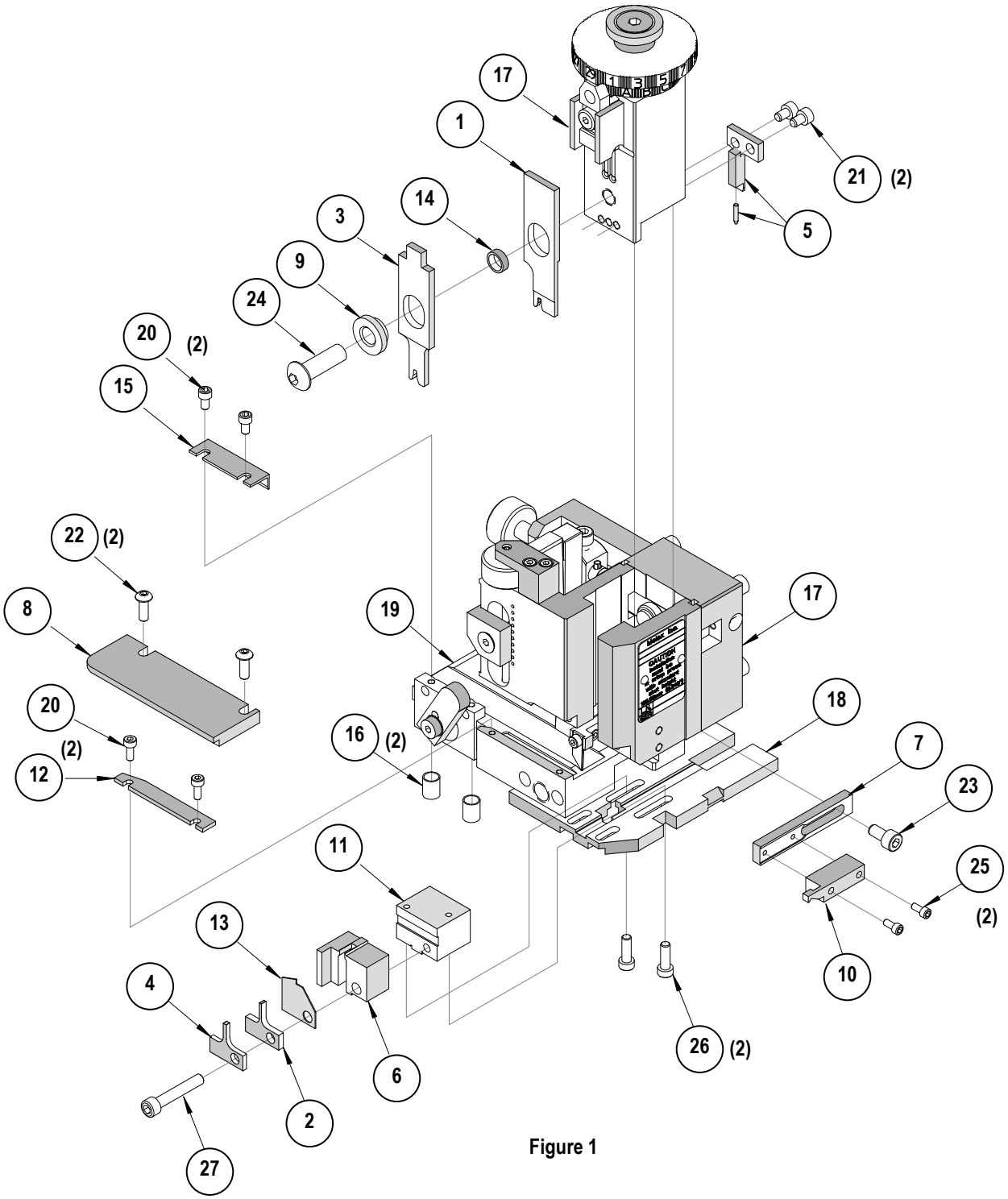


Figure 1

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 135.8 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.

http://www.molex.com

LifeElectronics
Живое партнерство

ООО «ЛайфЭлектроникс» **“LifeElectronics” LLC**

ИНН 7805602321 КПП 780501001 Р/С 40702810122510004610 ФАКБ "АБСОЛЮТ БАНК" (ЗАО) в г.Санкт-Петербурге К/С 30101810900000000703 БИК 044030703

Компания «Life Electronics» занимается поставками электронных компонентов импортного и отечественного производства от производителей и со складов крупных дистрибьюторов Европы, Америки и Азии.

С конца 2013 года компания активно расширяет линейку поставок компонентов по направлению коаксиальный кабель, кварцевые генераторы и конденсаторы (керамические, пленочные, электролитические), за счёт заключения дистрибьюторских договоров

Мы предлагаем:

- *Конкурентоспособные цены и скидки постоянным клиентам.*
- *Специальные условия для постоянных клиентов.*
- *Подбор аналогов.*
- *Поставку компонентов в любых объемах, удовлетворяющих вашим потребностям.*

- *Приемлемые сроки поставки, возможна ускоренная поставка.*
- *Доставку товара в любую точку России и стран СНГ.*
- *Комплексную поставку.*
- *Работу по проектам и поставку образцов.*
- *Формирование склада под заказчика.*

- *Сертификаты соответствия на поставляемую продукцию (по желанию клиента).*
- *Тестирование поставляемой продукции.*
- *Поставку компонентов, требующих военную и космическую приемку.*
- *Входной контроль качества.*
- *Наличие сертификата ISO.*

В составе нашей компании организован Конструкторский отдел, призванный помогать разработчикам, и инженерам.

Конструкторский отдел помогает осуществить:

- *Регистрацию проекта у производителя компонентов.*
- *Техническую поддержку проекта.*
- *Защиту от снятия компонента с производства.*
- *Оценку стоимости проекта по компонентам.*
- *Изготовление тестовой платы монтаж и пусконаладочные работы.*

Тел: +7 (812) 336 43 04 (многоканальный)
Email: org@lifeelectronics.ru

www.lifeelectronics.ru