molex®

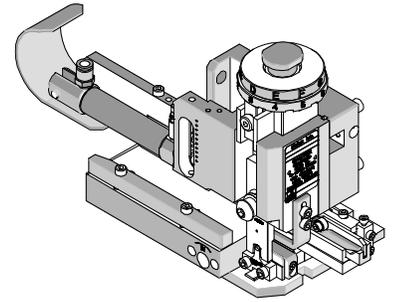**Mini-Mac Applicator
Application Tooling Specification
Air Feed-Mylar Tape
Part No. 63885-8300**

FEATURES

- Directly adapts to most crimp presses and automatic wire processors
- Applicator designed to industry-standard mounting and shut height of 135.80mm (5.346")
- Conductor and insulation rings allow quick adjustment for conductor and insulation crimp height change
- Quick set-up time; plus the crimp height, track and feed adjustments can be set without removing the applicator from the crimp press

SCOPE

Products: Insulkrimp™ Butt Splice Terminals 14-16 AWG.

Testing
Mechanical
The tensile test, or pull test, is a means of evaluating the mechanical properties of the crimped connections. The following chart shows the UL specifications for various wire sizes. The tensile strength is shown in pounds and indicates the minimum acceptable force to break or separate the terminal from the conductor.

Color Code	Wire Size (AWG)	*UL – 486 C
Blue	16	15
Blue	14	25

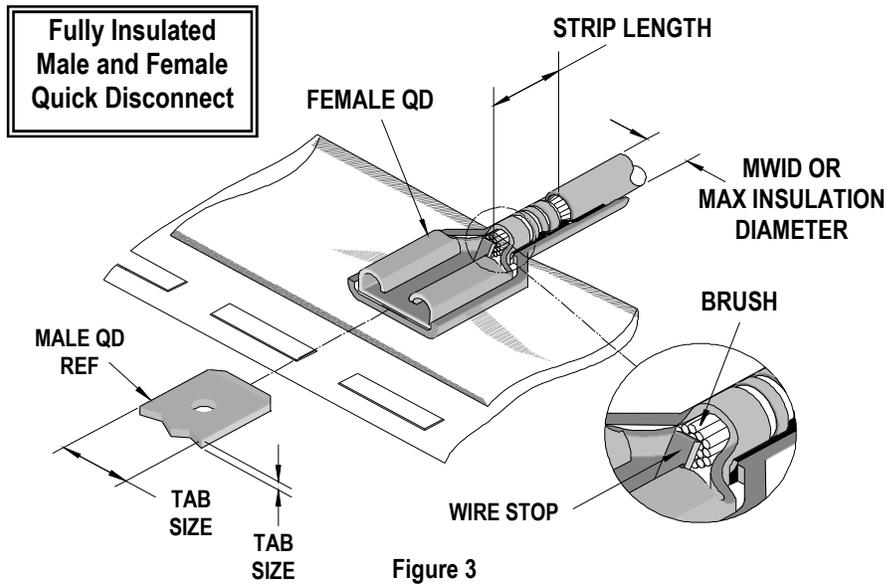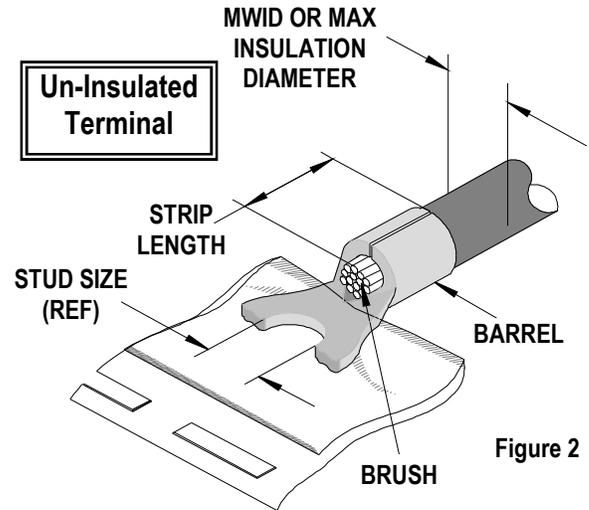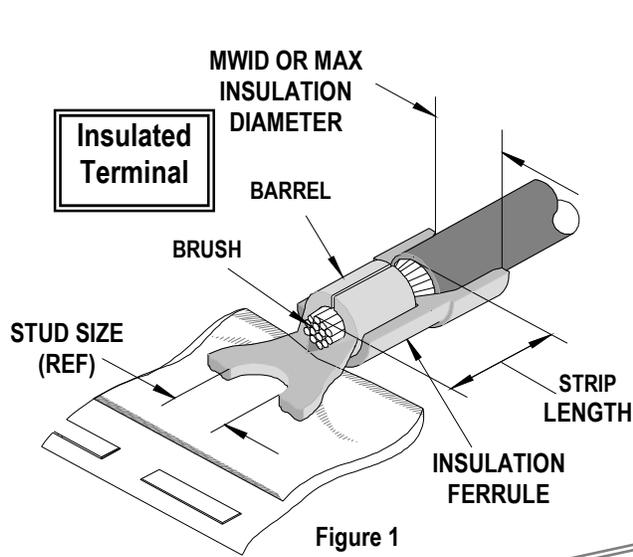*UL - 486 C - Butt Splices, Parallel Splices, Closed End Connectors, and Wire Nuts

Product List

The following is a partial list of the product order numbers and their specifications that this tool is designed to run. Updates to this list are available on www.molex.com.

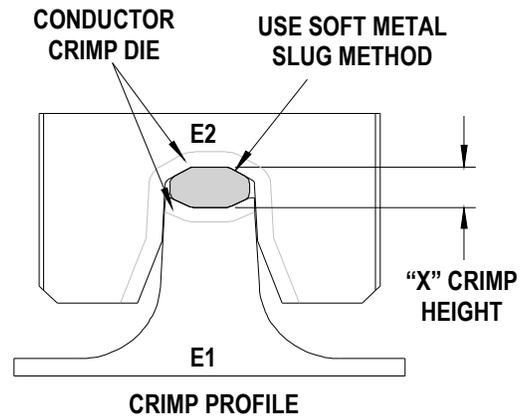| Terminal No.	Terminal Eng. No.	Wire Size		Insulation Diameter Maximum		Strip Length	
		AWG	mm²	mm	In.	mm	In.
19154-0014	B-231OVT	14 - 16	2.00 - 1.30	4.57	.180	5.94	.234
19154-0017	B-231XT	14 - 16	2.00 - 1.30	4.57	.180	5.94	.234
19154-0021	B-L231XT	14 - 16	2.00 - 1.30	3.81	.150	7.14	.281
19154-0024	BS-V-331XT	14 - 16	2.00 - 1.30	4.57	.180	7.14	.281
19154-0057	BA-631XT	14 - 16	2.00 - 1.30	4.46	.175	7.14	.281

DEFINITION OF TERMS

The following illustrations are a generic terminal representation and not an exact image of any terminal listed in the scope.

Insulated Terminal

MWID OR MAX INSULATION DIAMETER

BARREL

BRUSH

STUD SIZE (REF)

STRIP LENGTH

INSULATION FERRULE

Figure 1

Un-Insulated Terminal

MWID OR MAX INSULATION DIAMETER

STRIP LENGTH

STUD SIZE (REF)

BARREL

BRUSH

Figure 2

Fully Insulated Male and Female Quick Disconnect

STRIP LENGTH

FEMALE QD

MWID OR MAX INSULATION DIAMETER

BRUSH

MALE QD REF

TAB SIZE

TAB SIZE

WIRE STOP

Figure 3

Tool Calibration

To recalibrate this Applicator, make sure the power is completely shut off on the press.

1. The Mini-Mac applicator must be properly installed in the press.
2. Crimping dies must be properly installed in the Mini-Mac applicator.
3. The recommended method of measuring the crimp height of the conductor dies is the soft metal slug method, (See Figure 4).
4. The slug must have a diameter 0.51mm (.020") larger than the "X" No Go dimension before crimping.
5. Place the soft metal slug (solder) into the nest of the bottom die and crimp (by hand cycling the press) similar to a terminal. The crimp height can be measured with a blade type micrometer or dial caliper, (Dimension "X").
6. Adjustment of the crimp height can be accomplished by indexing the conductor cam. The letter "A" gives the loosest position and "K" gives the tightest position. A total adjustment of 0.50mm (.020") can be achieved by adjusting the conductor cam.

Note: If the crimp height is too tight on the setting "A", check the shut height of the press. See the Industrial Mini-Mac Applicator Manual Section 2.1 for adjustments.

CRIMP PROFILE

Use soft metal slug (solder) method to measure the "X" dimension. Verify tooling crimp height calibration by referring to the Go/No Go dimensions shown in the chart below.

Figure 2

CRIMP SPECIFICATIONS

Wire Size		"X" Dimension Conductor Crimp						Pull Force Minimum	
AWG	mm²	Mean		Go		No Go		Lbs	N
		In	mm	In	mm	In	mm		
14	2.00	.108	2.74	.105	2.67	.112	2.84	25	111.25
16	1.30	.108	2.74	.105	2.67	.112	2.84	15	66.75

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

PARTS LIST

Item	Order No	Engineering No.	Description	Quantity
Mini-Mac Applicator 63885-8300				
Perishable Tooling				
	63885-8370	63885-8370	Tool Kit (All "Y" Items)	REF
1	63465-0062	63465-0062	Conductor Punch	1 Y
2	63464-0056	63464-0056	Conductor Anvil	1 Y
3	63463-0039	63463-0039	Insulation Punch	1 Y
4	63462-0045	63462-0045	Insulation Anvil	1 Y
Other Components (Ref. 50050)				
5	63466-0912	63466-0912	Anvil Mount	1
6	63466-0913	63466-0913	Terminal Support	1
7	63443-0021	63443-0021	Lower Tooling Key	1
8	63466-0921	63466-0921	Terminal Stripping Blade	1
9	63600-1290	63600-1290	Washer	1
10	63890-0866	63890-0866	Collar-6.4mm Long	1
11	63890-0867	63890-0867	Collar-7.7mm Long	1
Frame				
12	63801-3301	63801-3301	Air Feed Applicator Frame Head	REF
13	63801-3281	63801-3281	Base	REF
14	63801-5850	63801-5850	Track Assembly	REF
15	63801-3390	63801-3390	Air Kit	REF
Hardware				
16	N/A	N/A	M3 by 12 Long SHCS	1**
17	N/A	N/A	M4 by 10 Long SHCS	2**
18	N/A	N/A	M4 by 20 Long SHCS	1**
19	N/A	N/A	M4 by 50 Long SHCS	1**
20	N/A	N/A	M8 by 30 Long BHCS	1**
21	N/A	N/A	3mm by 6 Long Roll Pin	1**
** Available from an industrial supply company such as MSC (1-800-645-7270).				

Note: Crimp profiles used in 63885-8300 are equivalent to 19288-0090 / ATP-B-521 (UL file number E32244).
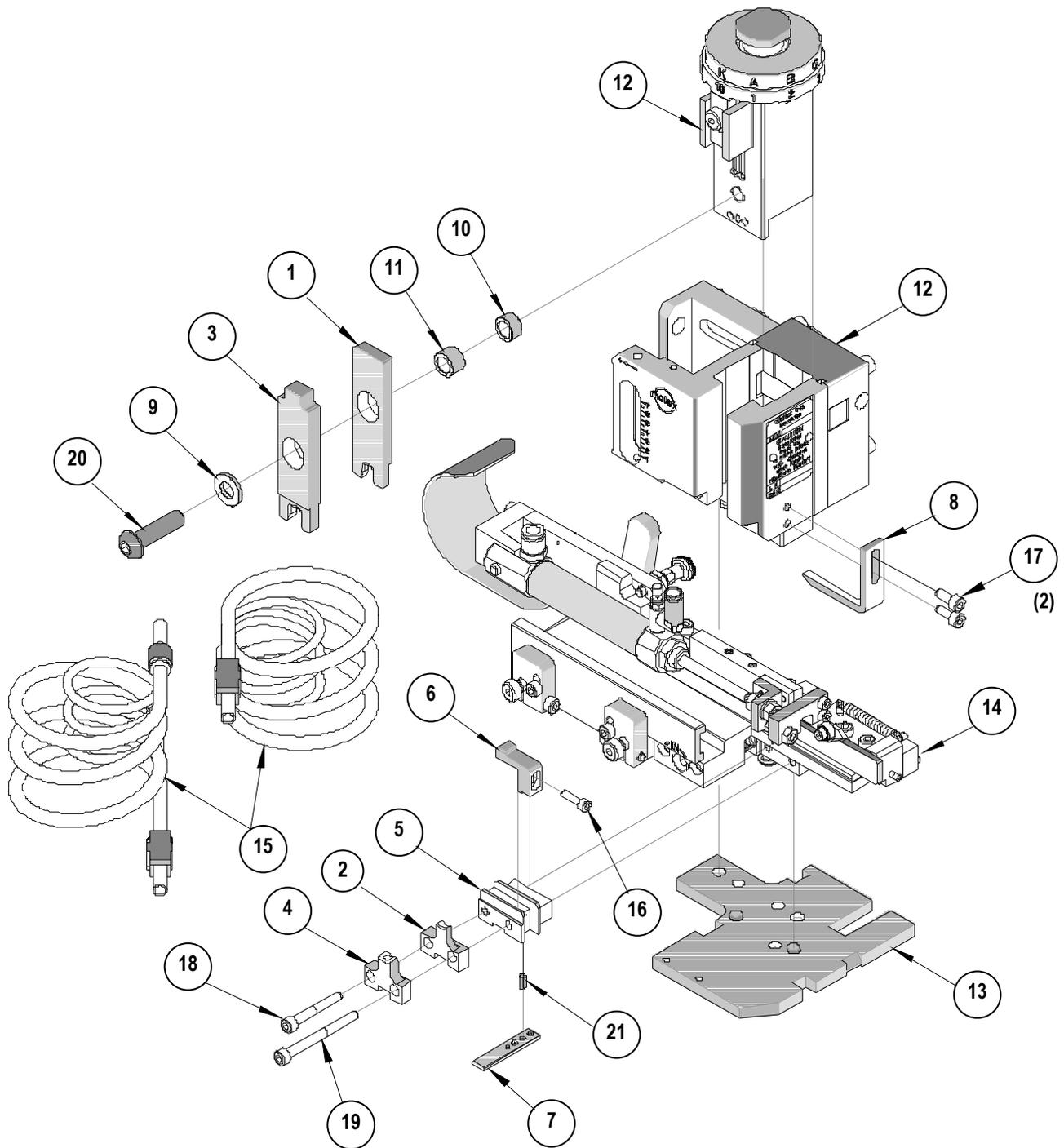
Assembly Drawing

Figure 5

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.

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.

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- Входной контроль качества.
- Наличие сертификата ISO.

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- 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.