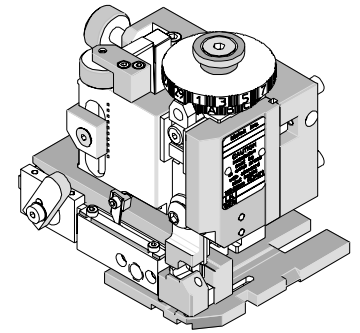




# Mini-Mac Applicator Specification Sheet Order No. 63894-3000



## FEATURES

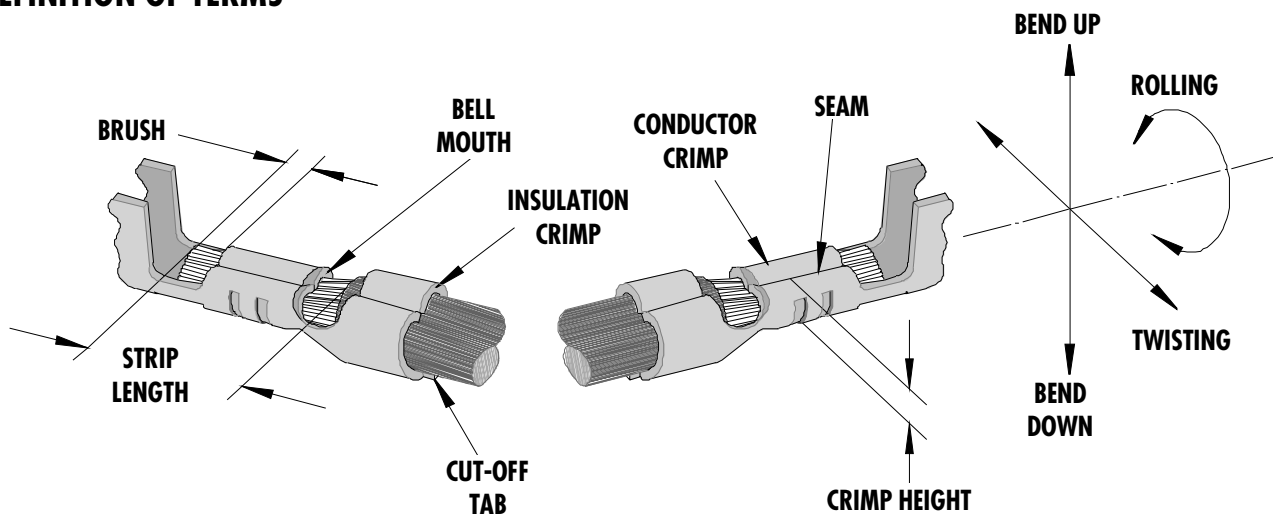
- Directly adapts to most automatic wire processing machines
- Applicator designed to industry standard mounting and shut height 135.80mm (5.346")
- Quick set-up time; plus the crimp height, track and feed adjustments can be set without removing the applicator from the press
- Fine adjustment allows 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: Board-In Connector Mini Crimp Pin Terminal, 24-28 AWG.

Terminal Series No.	Terminal Order No.	Wire Size		Insulation Diameter Maximum		Strip Length	
		AWG	mm <sup>2</sup>	mm	In.	mm	In.
5294	08-70-1041	24-28	0.20-0.08	1.50	.059	2.00-2.50	.080-.098

## 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 Maximum		Conductor Brush	
	mm	In.	mm	In.	mm	In.
5294	0.20-0.50	.008-.020	0.30	.012	0.70	.028

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.	mm	In.	mm	In.	
5294	3	3	3	8	1.19	.047	1.32	.052	

After crimping, the conductor profile should measure the following.

Terminal Series No.	Wire Size		Conductor				Insulation (Ref)				Pull Force Minimum	
			Crimp Height		Crimp Width		Crimp Height Maximum		Crimp Width			
	AWG	mm <sup>2</sup>	mm	In.	mm	In.	mm	In.	mm	In.	N	Lb.
5294	24	0.20	0.76-0.81	.030-.032			1.65	.065			29.42	6.61
	26	0.12	0.69-0.74	.027-.029			1.65	.065			19.61	4.41
	28	0.08	0.66-0.71	.026-.028			1.65	.065			9.79	2.20

**NOTE:** Some of the specifications in these charts above are intentionally left blank due to the fact that the information does not currently exist.

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 63894-3000</b>				
<b>Item</b>	<b>Order No</b>	<b>Engineering No.</b>	<b>Description</b>	<b>Quantity</b>
<b>Perishable Tooling</b>				
	63894-3070	63894-3070	Tool Kit (All "Y" Items)	REF
1	11-18-4424	60731A101	Conductor Punch	1 Y
2	11-18-4425	60731A102	Combination Anvil	1 Y
3	11-18-4426	60731A103	Insulation Punch	1 Y
4	11-18-4032	60705A106	Front Cut-Off Plunger	1 Y
5	11-18-4033	60705A107	Cut-off Plunger Retainer	1 Y
<b>Other Components (REF 943050)</b>				
6	11-18-4034	60705A108	Front Plunger Striker	1
7	11-18-4083	60707-8	Feed Guide	1
8	11-18-4427	60731A104	Spacer	1
9	11-18-4429	60731A106	Tooling Washer	1
10	11-24-1067	4996-4	Cut-off Plunger Spring	1
11	63443-0090	63443-0090	Wire Stop	1
12	63443-6108	63443-6108	Rear Cover	1
13	63803-5128	63803-5128	Conductor Bushing	1
<b>Frame</b>				
14	63801-3201	63801-3201	Top	1
15	63801-3282	63801-3282	Base	1
16	63801-6550	63801-6550	Track	1
<b>Hardware</b>				
17	N/A	N/A	M3 by 8 Long SHCS	2**
18	N/A	N/A	M4 by 6 Long SHCS	1**
19	N/A	N/A	M4 by 12 Long BHCS	2**
20	N/A	N/A	M5 by 12 Long SHCS	1**
21	N/A	N/A	M8 by 20 Long BHCS	1**
22	N/A	N/A	#6-32 by 3/8" Long BHCS	1**
23	N/A	N/A	#8-32 by 3/8" Long BHCS	4**
** Available from an industrial supply company such as MSC (1-800-645-7270).				

### Assembly Drawing

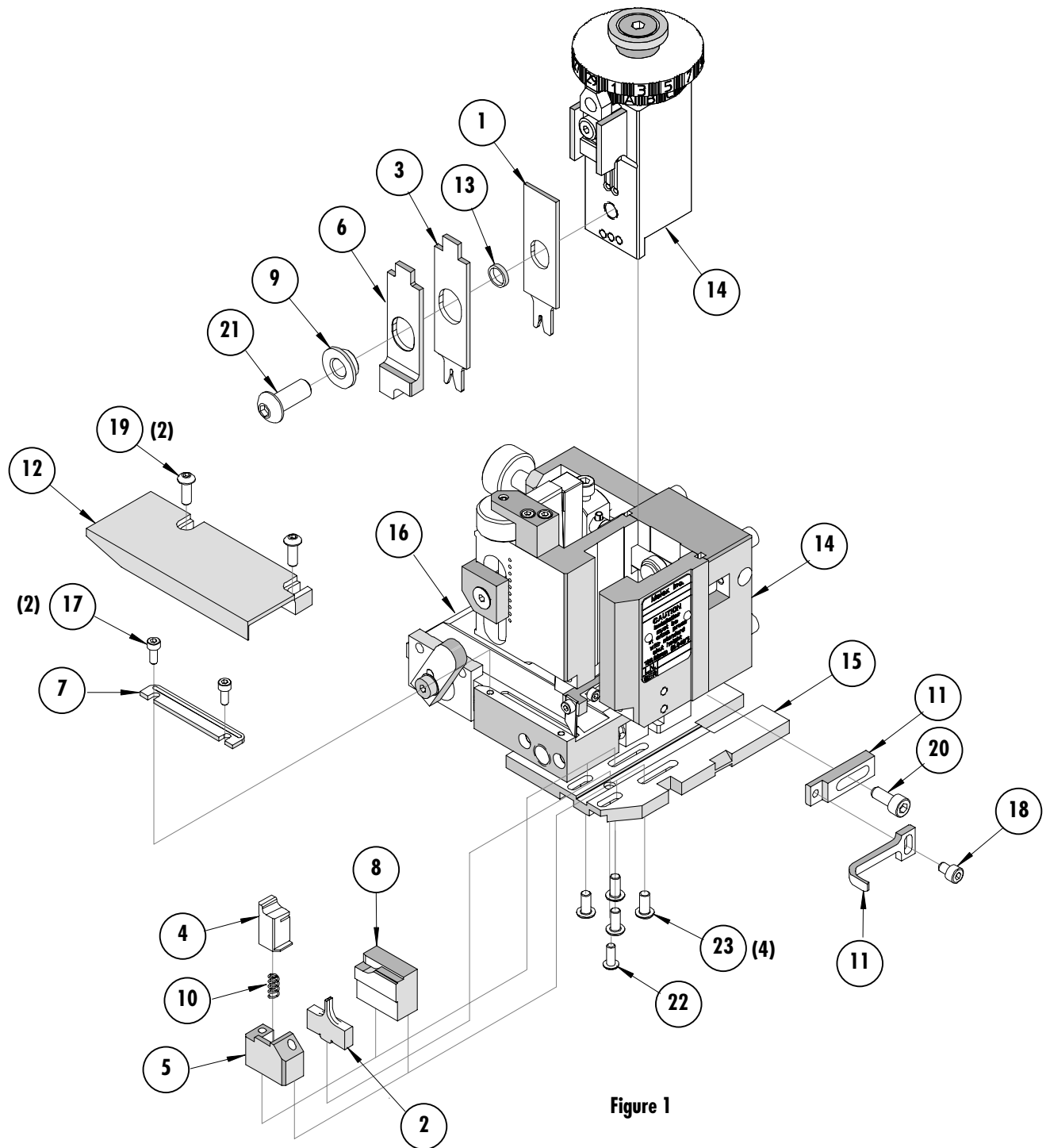


Figure 1

## 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 135.80 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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