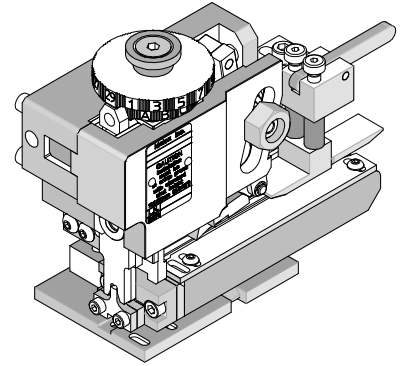




Mini-Mac Applicator Specification Sheet Order No. 63801-4300



FEATURES

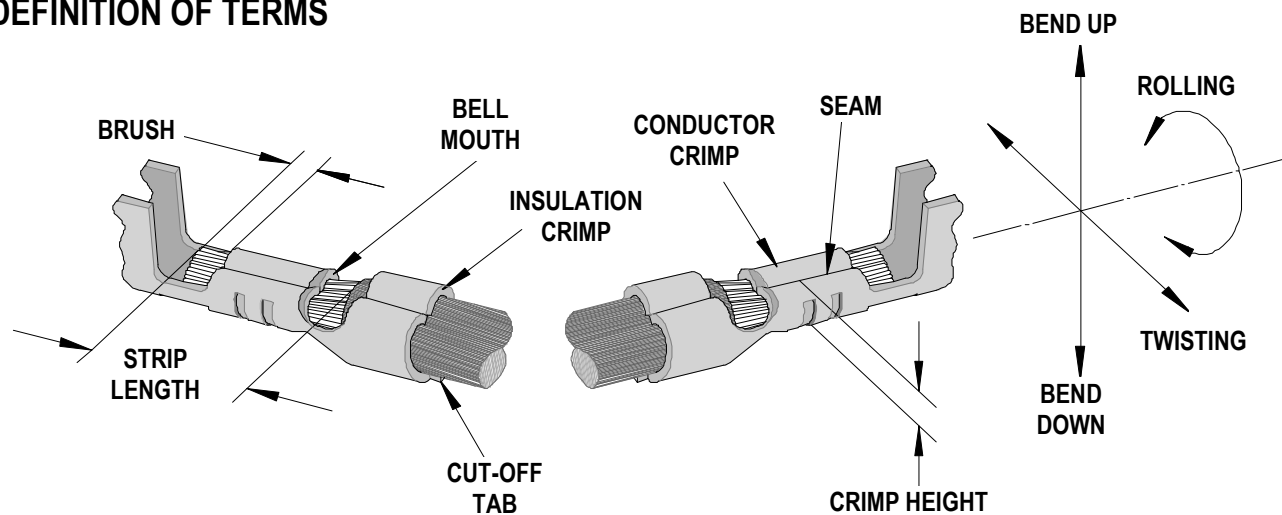
- Directly adapts to most automatic wire processing machines
- Applicator designed to industry standard mounting and shut height 135.80mm (5.346")
- Quick set-up time; plus the crimp height and feed adjustments can be set without removing the applicator from the press
- Fine adjustment allows users to 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: MP-Lock™ Quick Disconnect Female Terminal, 16-20 AWG.

Terminal Series No.	Terminal Order No.		Wire Size		Insulation Diameter		Strip Length	
			AWG	mm ²	mm	In.	mm	In.
35068	35068-9802	35068-9832	16-20	1.30-0.50	1.90-3.40	.075-.134	4.40-5.00	.173-.197
	35068-9812	35068-9842						
	35068-9822							

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.
35068	0.30-0.60	.012-.024	.50	.020	.30-.80	.012-.031

Terminal Series No.	Bend up Bend down		Twist Roll		Punch Width				Seam Seam shall not be open and no wire allowed out of the crimping area
					Conductor		Insulation		
	Degree		Degree		mm	In	mm	In	
35068	3	3	3	5	2.50-2.70	.098-.106	3.90-4.10	.153-.161	

After crimping, the conductor profile should measure the following.

Terminal Series No.	Wire Size		Crimp Height		Pull Force Minimum	
	AWG	mm ²	mm	In.	N	Lb.
35068	16	1.30	1.50 -1.60	.059-.063	147.1	33.07
	18	.80	1.20-1.30	.047-.051	98.1	22.05
	20	.50	1.00-1.10	.040-.043	58.8	13.23

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

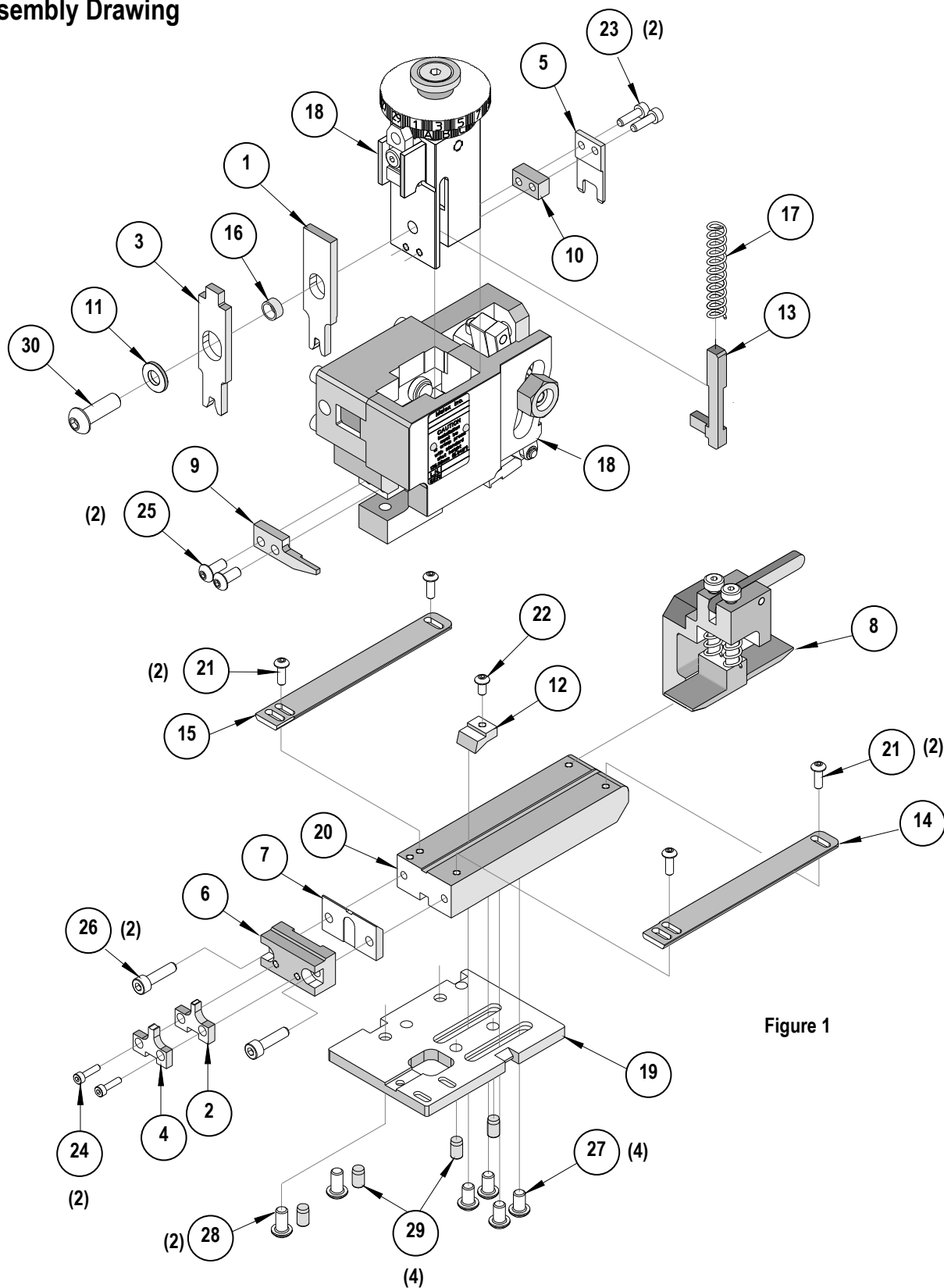
The above specifications are guidelines to an optimum crimp.

PARTS LIST

Mini-Mac Applicator 63801-4300				
Item	Order No	Engineering No.	Description	Quantity
Perishable Tooling				
	63801-4370	63801-4370	Tool Kit (All "Y" Items)	REF
1	63801-3901	63801-3901	Conductor Punch	1 Y
2	63445-2672	63445-2672	Conductor Anvil	1 Y
3	63801-3903	63801-3903	Insulation Punch	1 Y
4	63445-4037	63445-4037	Insulation Anvil	1 Y
5	63801-3918	63801-3918	Cut-off Punch	1 Y
6	63801-3906	63801-3906	Cut-off Die	1 Y
7	63801-3907	63801-3907	Cut-Off Blade	1 Y
Other Components				
8	63801-2695	63801-2695	Terminal Drag Assembly	1
9	63801-3913	63801-3913	Wire Stop	1
10	63801-3922	63801-3922	Spacer Cut-off Punch	1
11	63801-3933	63801-3933	Tooling Washer	1
12	63801-3934	63801-3934	Feed Finger	1
13	63801-3939	63801-3939	Hold Down Blade	1
14	63801-3960	63801-3960	Guide – R.H.	1
15	63801-3961	63801-3961	Guide – L.H.	1
16	63803-5137	63803-5137	Conductor Bushing	1
17	63700-4411	63700-4411	Compression Spring	1**
Frame				
18	63801-2600	63801-2600	Rear Feed Applicator	1
19	63801-2603	63801-2603	Base	1
20	63801-3949	63801-3949	Terminal Track	1
Hardware				
21	N/A	N/A	M4 by 8 Long BHCS	4**
22	N/A	N/A	M4 by 10 Long BHCS	1**
23	N/A	N/A	M4 by 14 Long SHCS	2**
24	N/A	N/A	M4 by 16 Long SHCS	2**
25	N/A	N/A	M5 by 12 Long BHCS	2**
26	N/A	N/A	M5 by 25 Long SHCS	2**
27	N/A	N/A	M6 by 10 Long BHCS	4**
28	N/A	N/A	M6 by 12 Long BHCS	2**
29	N/A	N/A	6mm by 10 Long Dowel Pin	4**
30	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.

Wear Safety Glasses At All Times.

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