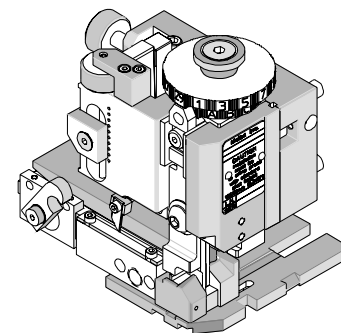




Mini-Mac Applicator Specification Sheet Order No. 63893-6000



FEATURES

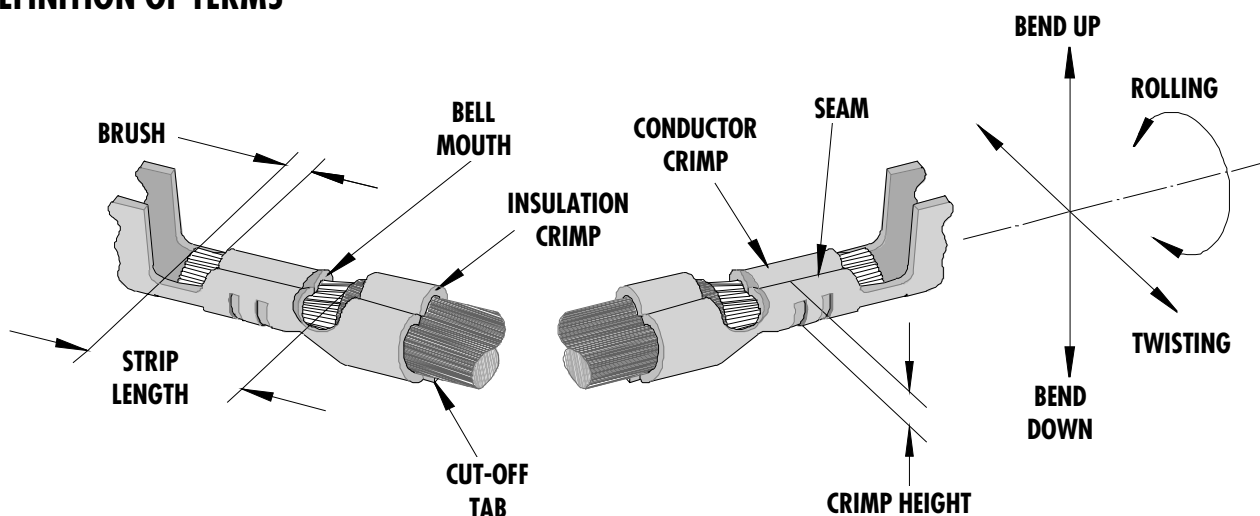
- Directly adapts to most automatic wire processing machines
- Applicator designed to industry standard mounting and shut height 135.80mm (5.346")
- Quick set-up time; plus the crimp height, track and feed adjustments can be set without removing the applicator from the press
- Fine adjustment allows 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: 4.80mm (.189") Pitch Male and Female Crimp Terminal, 18-24 AWG.

Terminal Series No.	Terminal Order No.		Wire Size		Insulation Diameter		Strip Length	
			AWG	mm ²	mm	In.	mm	In.
5005	08-70-0001	39-00-0013	18-24	0.80-0.20	1.30-3.00	.051-.118	2.70-3.30	.106-.130
	08-70-1011							
5006	08-70-0002	39-00-0015	18-24	0.80-0.20	1.30-3.00	.051-.118	2.70-3.30	.106-.130
	08-70-1013							

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.
5005	0.20-0.50	.008-.020	0.30	.012	0.00-1.00	.000-.040
5006	0.20-0.50	.008-.020	0.30	.012	0.00-1.00	.000-.040

Terminal Series No.	Bend up	Bend down	Twist	Roll	Punch Width (Ref)				Seam
	Degree	Degree	mm	In.	Conductor		Insulation		
					mm	In.	mm	In.	
5005	3	3	4	15	1.60	.063	2.80	.110	Seam shall not be open and no wire allowed out of the crimping area
5006	3	3	4	15	1.60	.063	2.80	.110	

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		Conductor				Pull Force	
	AWG	mm ²	Crimp Height		Crimp Width (Ref.)		Minimum	
			mm	In.	mm	In.	N	Lb.
5005	18	0.80	1.10-1.20	.043-.047	1.60	.063	97.86	22.00
	20	0.50	1.01-1.11	.040-.044	1.60	.063	66.72	15.00
	22	0.35	0.92-0.97	.036-.038	1.60	.063	53.38	12.00
	24	0.20	0.83-0.88	.033-.035	1.60	.063	35.59	8.00
5006	18	0.80	1.10-1.20	.043-.047	1.60	.063	97.86	22.00
	20	0.50	1.01-1.11	.040-.044	1.60	.063	66.72	15.00
	22	0.35	0.92-0.97	.036-.038	1.60	.063	53.38	12.00
	24	0.20	0.83-0.88	.033-.035	1.60	.063	35.59	8.00

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 63893-6000				
Item	Order No	Engineering No.	Description	Quantity
Perishable Tooling				
	63893-6070	63893-6070	Tool Kit (All "Y" Items)	REF
1	11-18-4734	60762A101	Conductor Punch	1 Y
2	11-18-4735	60762A102	Combination Anvil	1 Y
3	11-18-4736	60762A103	Insulation Punch	1 Y
4	11-18-4652	60758A107	Front Cut-Off Plunger	1 Y
5	11-18-4653	60758A108	Front Plunger Retainer	1 Y
Other Components (REF 936050)				
6	11-18-4022	60704-10	Terminal Hold Down Adapter	1
7	11-18-4034	60705A108	Front Plunger Striker	1
8	11-18-4083	60707-8	Feed Guide	1
9	11-18-4739	60762A106	Tooling Washer	1
10	11-18-4741	60762A108	Spacer	1
11	11-18-4778	60762A113	Hold Down Pad	1
12	11-24-1067	4996-4	Cut-off Plunger Spring	1
13	63443-0090	63443-0090	Wire Stop	1
14	63443-6116	63443-6116	Rear Cover	1
15	63803-5123	63803-5123	Conductor Bushing	1
Frame				
16	63801-3201	63801-3201	Top	1
17	63801-3282	63801-3282	Base	1
18	63801-6550	63801-6550	Track	1
Hardware				
19	N/A	N/A	M3 by 8 Long SHCS	2**
20	N/A	N/A	M4 by 6 Long SHCS	1**
21	N/A	N/A	M4 by 12 Long BHCS	2**
22	N/A	N/A	M4 by 12 Long SHCS	2**
23	N/A	N/A	M5 by 12 Long SHCS	1**
24	N/A	N/A	M8 by 20 Long BHCS	1**
25	N/A	N/A	#6-32 by 3/8" Long BHCS	1**
26	N/A	N/A	#6-32 by 1/2" Long FHCS	1**
27	N/A	N/A	#6-32 Hex Jam Nut	1**
28	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

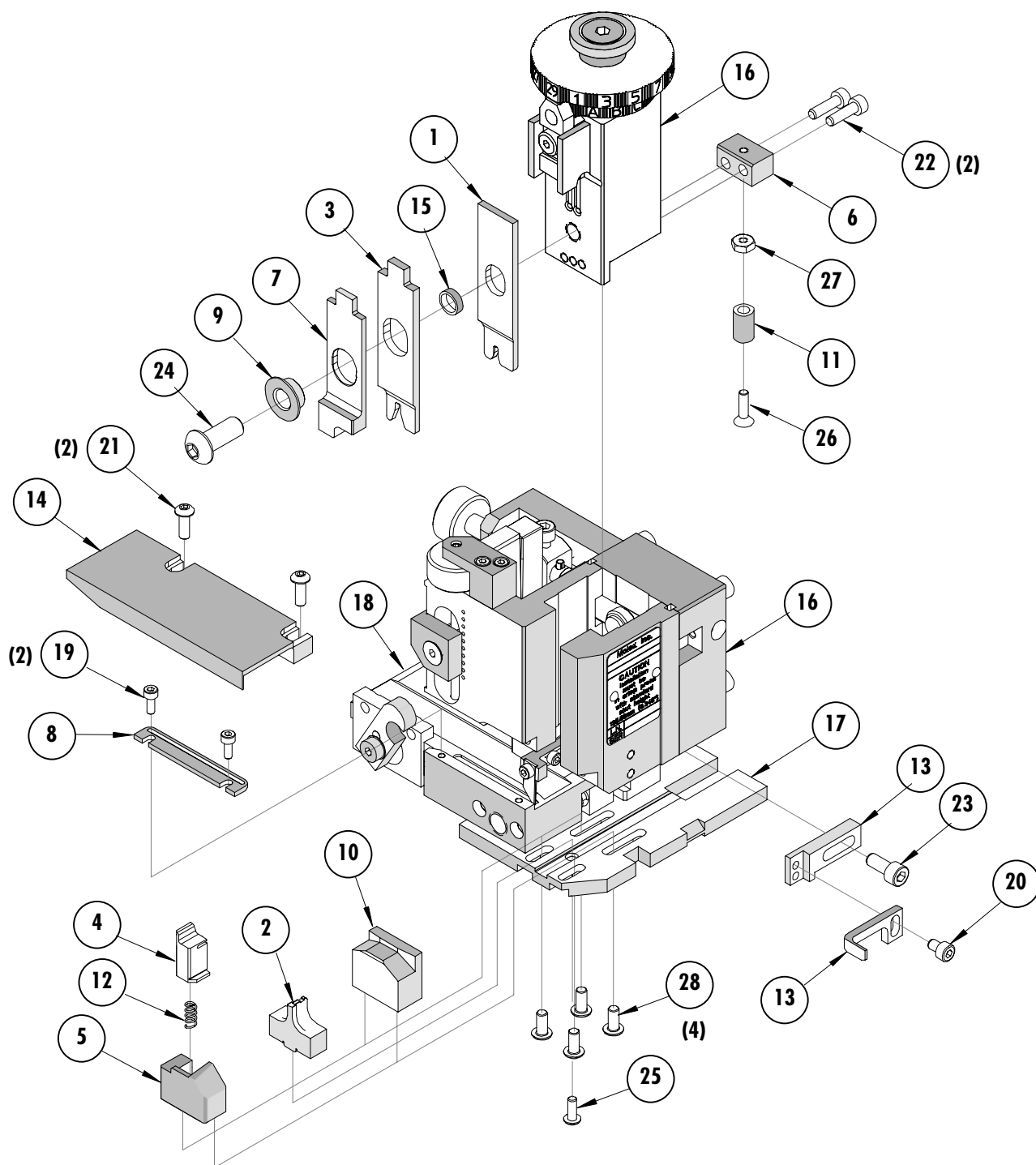


Figure 1

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.

Americas Headquarters

Lisle, Illinois 60532 U.S.A.
1-800-78MOLEX
amerinfo@molex.com

Far East North Headquarters

Yamato, Kanagawa, Japan
81-462-65-2324
feninfo@molex.com

Far East South Headquarters

Jurong, Singapore
65-6-268-6868
fesinfo@molex.com

European Headquarters

Munich, Germany
49-89-413092-0
eurinfo@molex.com

Corporate Headquarters

2222 Wellington Ct.
Lisle, IL 60532 U.S.A.
630-969-4550
Fax: 630-969-1352

Visit our Web site at <http://www.molex.com>

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Тел: +7 (812) 336 43 04 (многоканальный)

Email: org@lifeelectronics.ru

www.lifeelectronics.ru