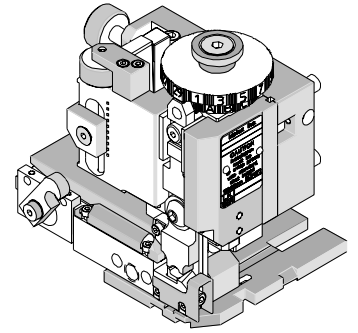




Mini-Mac Applicator Specification Sheet Order No. 63893-9000



FEATURES

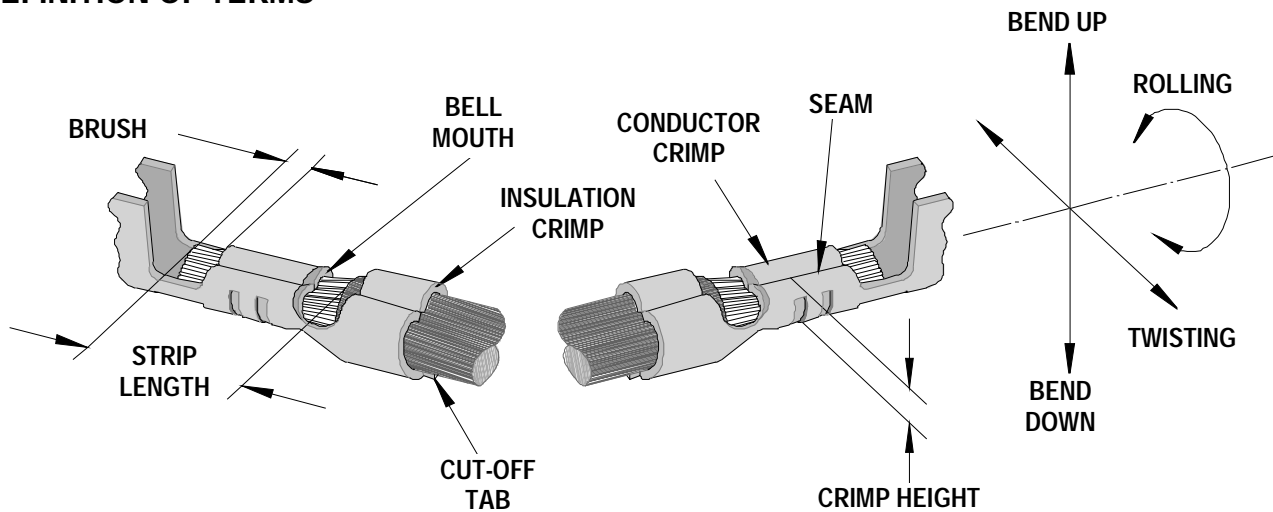
- Directly adapts to most automatic wire processing machines
- Applicator designed to industry standard mounting and shut height 135.80mm (5.346")
- Quick set-up time; plus the crimp height, track and feed adjustments can be set without removing the applicator from the press
- Fine adjustment allows 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: Mini KK® Crimp Terminals, 22-28 AWG.

Terminal Series No.	Terminal Order No	Wire Size		Insulation Diameter		Strip Length	
		AWG	mm ²	mm	In.	mm	In.
5659	08-70-0038	22-28	0.35-0.08	1.20-1.70	.047-.067	2.54-3.17	.100-.125

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 (Ref)		Cut-off Tab Maximum		Conductor Brush	
	mm	In.	mm	In.	mm	In.
5659	0.20-0.50	.008-.020	0.50	.020	0.00-1.00	.000-.040

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.					
5659	4	4	3	8	1.40	.055	2.00	.079	

After crimping, the conductor profile should measure the following.

Terminal Series No.	Wire Size		Conductor				Pull Force Minimum	
			Crimp Height		Crimp Width (Ref.)			
	AWG	mm ²	mm	In.	mm	In.	N	Lb.
5659	22	0.35	0.76-0.84	.030-.033	1.40	.055	39.23	8.82
	24	0.20	0.74-0.79	.029-.031	1.40	.055	29.45	6.62
	26	0.12	0.68-0.74	.027-.029	1.40	.055	19.62	4.41
	28	0.08	.066-0.71	.026-.028	1.40	.055	9.79	2.20

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 63893-9000				
Item	Order No	Engineering No.	Description	Quantity
Perishable Tooling				
	63893-9070	63893-9070	Tool Kit (All "Y" Items)	REF
1	11-18-5162	60819A106	Conductor Punch	1 Y
2	11-18-5163	60819A107	Combination Anvil	1 Y
3	11-18-5164	60819A108	Insulation Punch	1 Y
4	11-18-5108	60804A127	Cut-Off Plunger	1 Y
5	11-18-5107	60804A126	Plunger Retainer	1 Y
Other Components (REF 939050)				
6	11-18-4083	60707-8	Feed Guide	1
7	11-18-4898	60804A104	Anvil Mount	1
8	11-18-5109	60804A128	Front Plunger Striker	1
9	11-18-5111	60804A140	Knock-Out Blade	1
10	11-18-5114	60804A130	Scrap Deflector	1
11	11-18-5116	60804A141	Compression Spring (Knock-Out)	1
12	11-18-5146	60818A115	Tooling Washer	1
13	11-24-1067	4996-4	Cut-off Plunger Spring	1
14	63443-0090	63443-0090	Wire Stop	1
15	63443-6113	63443-6113	Rear Cover	1
16	63803-5105	63803-5105	Conductor Bushing	1
Frame				
17	63801-3201	63801-3201	Top	1
18	63801-3282	63801-3282	Base	1
19	63801-6550	63801-6650	Track	1
Hardware				
20	N/A	N/A	M3 by 8 Long SHCS	2**
21	N/A	N/A	M3 by 20 Long SHCS	2**
22	N/A	N/A	M4 by 6 Long SHCS	2**
23	N/A	N/A	M4 by 8 Long BHCS	2**
24	N/A	N/A	M4 by 12 Long BHCS	2**
25	N/A	N/A	M5 by 12 Long SHCS	1**
26	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

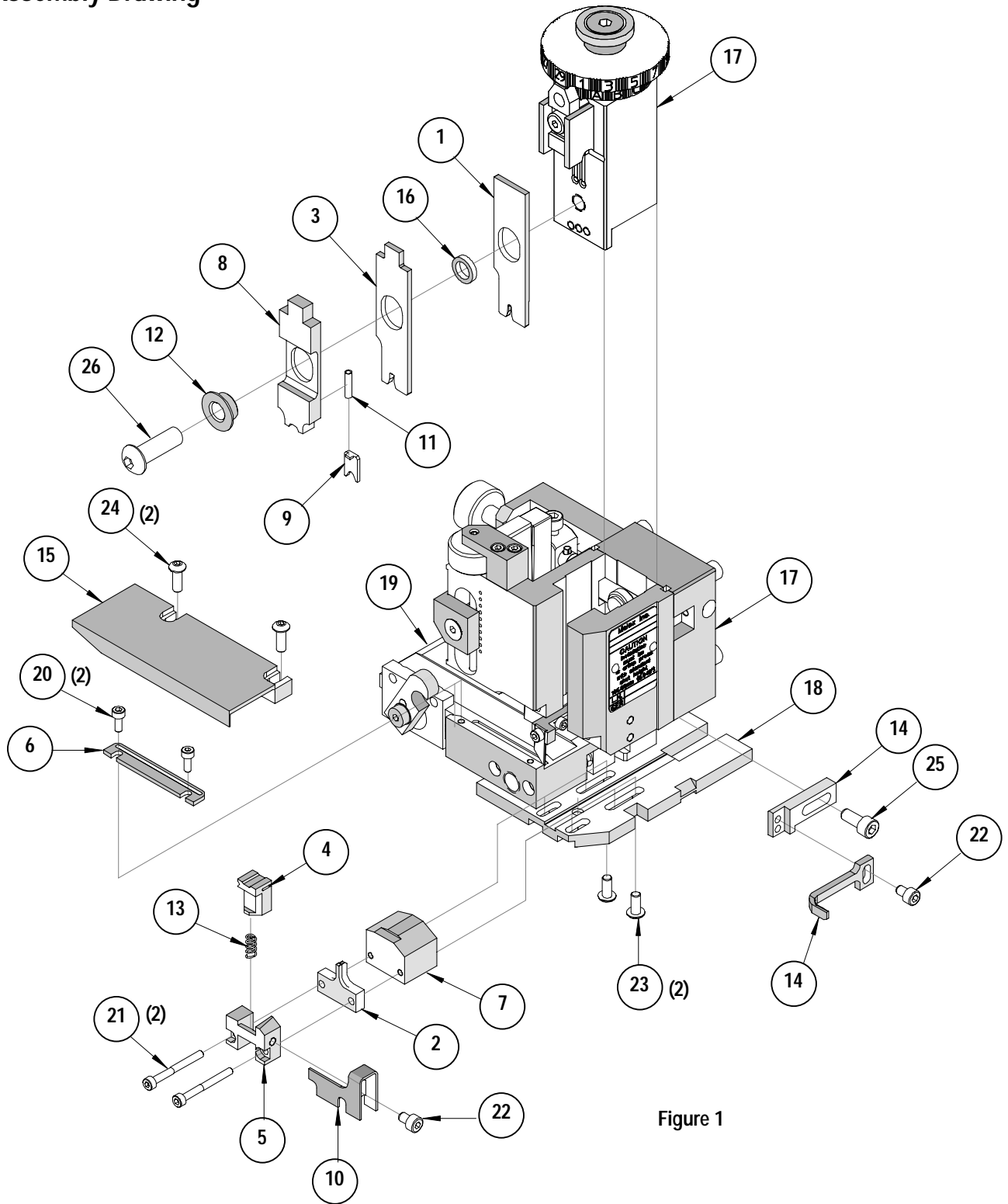


Figure 1

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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