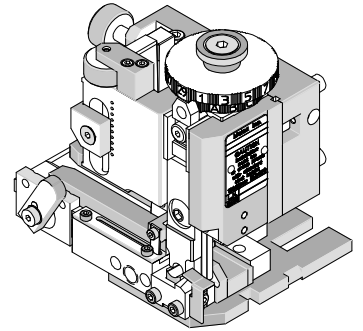




## Mini-Mac Applicator Application Tooling Specification Order No. 63832-6100



### FEATURES

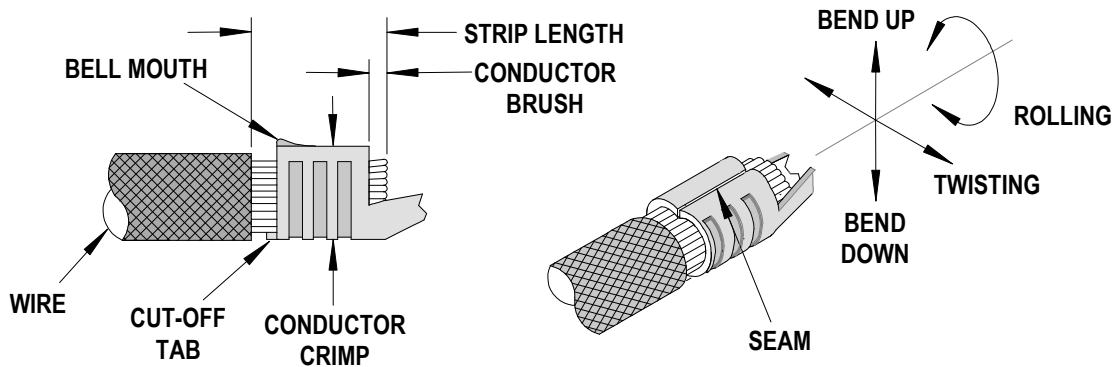
- Directly adapts to most automatic wire processing machines
- Applicator designed to industry standard mounting and shut height 135.80mm (5.346")
- Quick set-up time; plus the crimp height, track and feed adjustments can be set without removing the applicator from the press
- Fine adjustment allows 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: Male and Female Power Contact Crimp Terminals, 14-16 AWG, 18 AWG Doubles, and 16 AWG Doubles.

Terminal Series No.	*Terminal Order No.			Wire Size		Insulation Diameter Maximum		Strip Length	
				AWG	mm <sup>2</sup>	mm	In.	mm	In.
44262	44262-4306	44262-4506	44262-6412	14-16	2.00-1.30	N/A	N/A	6.35	.25
	44262-4336	44262-4536	44262-6420	18 (2)	0.80 (2)				
	44262-4406	44262-6410	44262-6422	16 (2)	1.30 (2)				
	44262-4436	44262-6411	44262-6421						
63832-6100 Applicator is set up to crimp Male terminals. To crimp female terminals perishable tooling set-up needs to be changed. No additional parts are required. *See Changeover Parts on page 3 for each terminal listed.									

### DEFINITION OF TERMS



The above terminal drawing is a generic terminal representation. It is not an image of any terminal listed in the scope.

### CRIMP SPECIFICATION

Terminal Series No.	Bell mouth		Cut-off Tab Maximum		Conductor Brush	
	mm	In.	mm	In.	mm	In.
44262	0.25-1.25	.010-.049	0.50	.020	0.64-1.90	.025-.075

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		
	mm	In	mm	In	mm	In	mm	In	
44262	3	3	3	3	3.90	.154	N/A	N/A	

After crimping, the crimp profiles should measure the following.

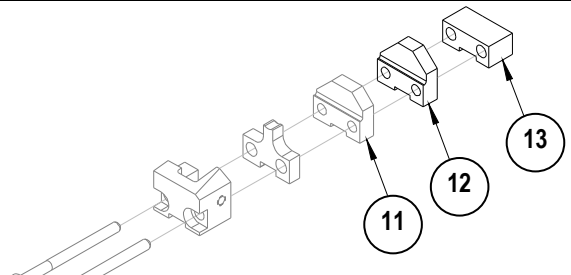
Terminal Series No.	Wire Size		Conductor				Pull Force Minimum	
	AWG	mm <sup>2</sup>	Crimp Height		Crimp Width (Ref.)		N	Lb.
			mm	In.	mm	In.		
44262	14	2.00	2.65-2.75	.104-.108	4.00	.158	222.41	50.0
	16	1.30	2.50-2.60	.098-.102	4.00	.158	133.45	30.0
	18 (2)	0.80 (2)	2.55-2.65	.100-.104	4.00	.158	88.96	20.0
	16 (2)	1.30 (2)	2.65-2.75	.104-.108	4.00	.158	133.45	30.0

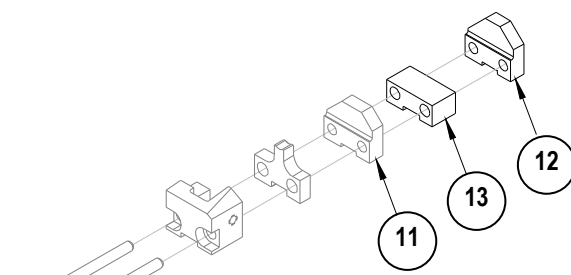
\* This applicator was qualified to the above specifications with UL 1015 wire.

The above specifications are guidelines to an optimum crimp.

**\* Changeover Parts**

The following charts below show the different locations for the spacers when crimping male or female terminals.

Terminal Series No.	Terminal Order No.			
44262 (Male)	44262-6410	44262-6411	44262-6412	44262-6420
	44262-6421	44262-6422		
<b>Note:</b> To properly crimp these terminals, assemble spacers with cutoff tooling as shown in Figure 1. See also parts list and assembly drawing.				
 <p style="text-align: center;"><b>Figure 1</b></p>		Item No.	Order No.	Description
		11	63443-1719	18.90mm Spacer
		12	63443-1734	20.40mm Spacer
		13	63443-2212	12.00mm Spacer

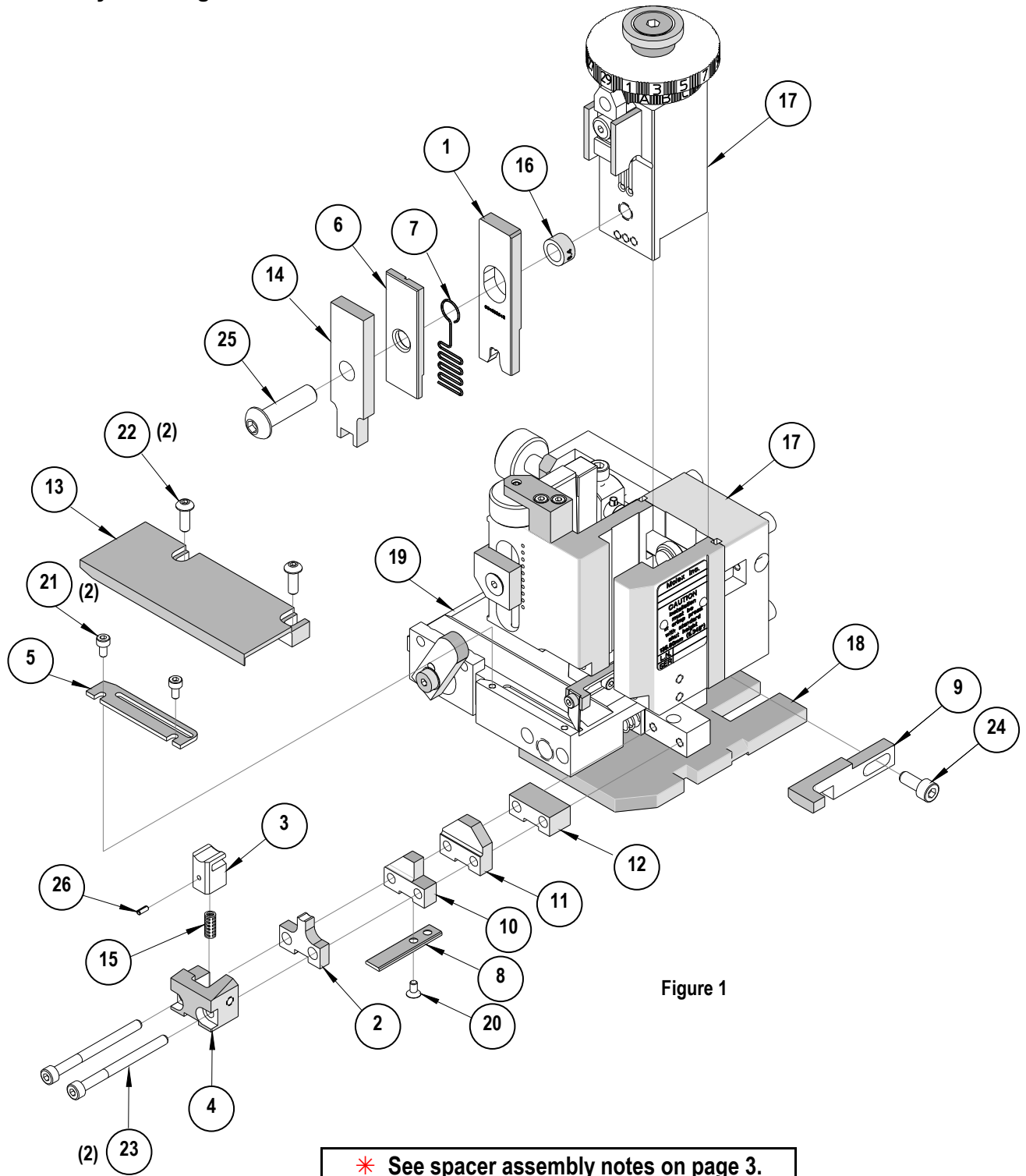
Terminal Series No.	Terminal Order No.			
44262 (Female)	44262-4306	44262-4336	44262-4406	44262-4436
<b>Note:</b> To properly crimp these terminals, assemble spacers with cutoff tooling as shown in Figure 1. See also parts list and assembly drawing.				
 <p style="text-align: center;"><b>Figure 2</b></p>		Item No.	Order No.	Description
		11	63443-1719	18.90mm Spacer
		13	63443-2212	12.00mm Spacer
		12	63443-1734	20.40mm Spacer

**PARTS LIST**

<b>Mini-Mac Applicator 63832-6100</b>				
<b>Item</b>	<b>Order No</b>	<b>Engineering No.</b>	<b>Description</b>	<b>Quantity</b>
<b>Perishable Tooling</b>				
	63832-6170	63832-6170	Tool Kit (All "Y" Items)	REF
1	63465-0050	63465-0050	Conductor Punch	1 Y
2	63455-0046	63455-0046	Conductor Anvil	1 Y
3	63443-0095	63443-0095	Front Cut-Off Plunger	1 Y
4	63890-0487	63890-0487	Front Plunger Retainer	1 Y
<b>Other Components (REF 326150)</b>				
5	63821-0012	63821-0012	Feed Guide	1
6	11-18-4848	60800A123	Spring Retainer	1
7	11-18-4849	60800A124	Wire Hold Down Spring	1
8	63443-0024	63443-0024	Key	1
9	63821-0015	63821-0015	Wire Stop	1
10	*63443-1719	63443-1719	18.90mm Spacer	1
11	*63443-1734	63443-1734	20.40mm Spacer	1
12	*63443-2212	63443-2212	12.00mm Spacer	1
13	63443-6130	63443-6130	Rear Cover	1
14	63466-0509	63466-0509	Striker-Flat Bottom	1
15	63700-0539	63700-0539	Compression Spring	1
16	63890-0866	63890-0866	Bushing-Punch (Conductor)	1
<b>Frame</b>				
17	63801-3201	63801-3201	Top	1
18	63801-3281	63801-3281	Base	1
19	63801-4650	63801-4650	Track	1
<b>Hardware</b>				
20	N/A	N/A	M3 by 6 Long FHCS	1**
21	N/A	N/A	M3 by 6 Long SHCS	2**
22	N/A	N/A	M4 by 12 Long BHCS	2**
23	N/A	N/A	M4 by 50 Long SHCS	2**
24	N/A	N/A	M5 by 12 Long SHCS	1**
25	N/A	N/A	M8 by 30 Long BHCS	1**
26	N/A	N/A	2mm by 5 Long Roll Pin	1**
** Available from an industrial supply company such as MSC (1-800-645-7270).				

**\* See spacer assembly notes on page 3.**

### 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 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.

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63832-6100 Applicator  
is set up to crimp Male  
terminals. To crimp female  
terminals perishable tooling  
set-up needs to be changed.  
No additional parts are  
required.

See Changeover Parts on  
page 3 of Application Tooling  
Specification for each  
terminal listed.

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