

**Mini-Mac
Applicator**

**Application Tooling
Specification Sheet**

Order No. 63888-2100

FEATURES

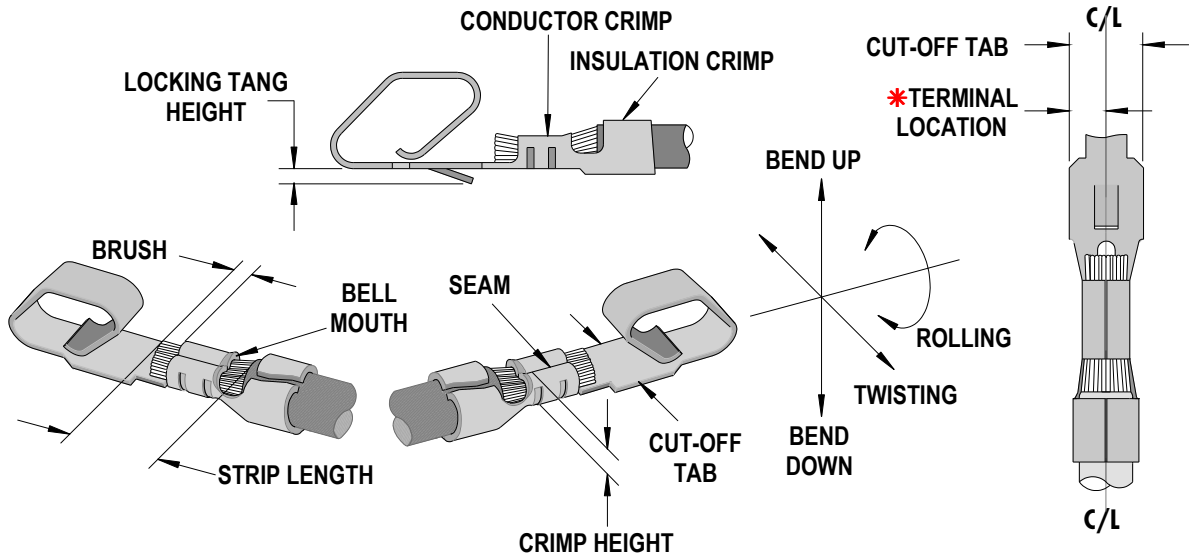
- Directly adapts to most automatic wire processing machines
- Applicator designed to industry standard mounting and shut height 135.80mm (5.346")
- Quick set-up time; plus the crimp height, track and feed adjustments can be set without removing the applicator from the press
- Fine adjustment allows 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: KK® Crimp Terminal and Cat Ear Crimp Terminals, 22-30 AWG. Use with smaller wire insulation diameters.

Terminal Series No.	Terminal Order No.			Wire Size		◆ Insulation Diameter		Strip Length	
				AWG	mm ²	mm	In.	mm	In.
2759	08-50-0113	08-55-0130	39-00-0374	22-30	0.35-0.05	0.96-1.20	.038-.047	2.54-3.18	.100-.125
	08-50-0159	08-56-0109	39-00-0376						
	08-50-0274	39-00-0032	39-00-0378						
	08-51-0101	39-00-0064	39-00-0380						
	08-51-0108	39-00-0372	50-29-1757						
	08-55-0101								
5139	08-70-0046			22-30	0.35-0.05	0.96-1.20	.038-.047	2.54-3.18	.100-.125
5159	08-70-0048	08-70-0064		22-28	0.35-0.08	0.96-1.20	.038-.047	2.54-3.18	.100-.125
6459	08-52-0101	08-65-0801	08-65-0815	22-30	0.35-0.05	0.96-1.20	.038-.047	2.54-3.18	.100-.125
	08-52-0118	08-65-0811	08-65-0817						
	08-52-0121	08-65-0813	40-07-0815						
40445	08-50-0321	97-00-0444	97-00-0920	22-30	0.35-0.05	0.96-1.20	.038-.047	2.54-3.18	.100-.125
41572	08-65-0804			22-30	0.35-0.05	0.96-1.20	.038-.047	2.54-3.18	.100-.125
◆ For larger Insulation Diameters use 63888-2000 Applicator.									

DEFINITION OF TERMS



*Terminal is to be centrally located between the two (2) cut-off edges by 1/2 of the total cut-off tab tolerance.

CRIMP SPECIFICATIONS

Terminal Series No.	Bell mouth		*Cut-off Tab		Conductor Brush	
	mm	In.	mm	In.	mm	In.
2759	0.20-0.50	.008-.020	1.98-1.85	.078-.073	.00-1.0	.000-.040
5139	0.20-0.50	.008-.020	1.98-1.85	.078-.073	.00-1.0	.000-.040
5159	0.20-0.50	.008-.020	1.98-1.85	.078-.073	.00-1.0	.000-.040
6459	0.20-0.50	.008-.020	1.98-1.85	.078-.073	.00-1.0	.000-.040
40445	0.20-0.50	.008-.020	1.98-1.85	.078-.073	.00-1.0	.000-.040
41572	0.20-0.50	.008-.020	1.98-1.85	.078-.073	.00-1.0	.000-.040

Terminal Series No.	Locking Tang Height		Bend up Bend down		Twist Roll		Punch Width (Ref)				Seam Seam shall not be open and no wire allowed out of the crimping area
	mm	In	Degree	Degree	Degree	Degree	Conductor		Insulation		
							mm	In	mm	In	
2759	0.51-0.64	.020-.025	3	3	4	8	1.38	.054	1.60	.063	
5139	0.34-0.60	.013-.024	3	3	4	8	1.38	.054	1.60	.063	
5159	0.40-0.55	.016-.022	3	3	4	8	1.38	.054	1.60	.063	
6459	0.51-0.64	.020-.025	3	3	4	8	1.38	.054	1.60	.063	
40445	0.51-0.64	.020-.025	3	3	4	8	1.38	.054	1.60	.063	
41572	0.51-0.64	.020-.025	3	3	4	8	1.38	.054	1.60	.063	

After crimping, the conductor profile should measure the following.

Terminal Series No.	Wire Size		Crimp Height		Crimp Width (Ref)		Pull Force Minimum	
	AWG	mm ²	mm	In.	mm	In.	N	Lb.
2759	22	0.35	0.79-0.84	.031-.033	1.37	.054	44.88	10.0
	24	0.20	0.73-0.79	.029-.031	1.37	.054	35.59	8.0
	26	0.12	0.71-0.76	.028-.030	1.37	.054	17.79	4.0
	28	0.08	0.68-0.73	.027-.029	1.37	.054	13.34	3.0
	30	0.05	0.66-0.71	.026-.028	1.37	.054	8.89	2.0
5139	22	0.35	0.79-0.84	.031-.033	1.37	.054	44.88	10.0
	24	0.20	0.74-0.79	.029-.031	1.37	.054	35.59	8.0
	26	0.12	0.68-0.74	.027-.029	1.37	.054	17.79	4.0
	28	0.08	0.66-0.71	.026-.028	1.37	.054	13.34	3.0
	30	0.05	0.63-0.66	.026-.027	1.37	.054	8.89	2.0
5159	22	0.35	0.79-0.84	.031-.033	1.37	.054	44.88	10.0
	24	0.20	0.74-0.79	.029-.031	1.37	.054	35.59	8.0
	26	0.12	0.68-0.74	.027-.029	1.37	.054	17.79	4.0
	28	0.08	0.66-0.71	.026-.028	1.37	.054	13.34	3.0
6459	22	0.35	0.79-0.84	.031-.033	1.37	.054	44.88	10.0
	24	0.20	0.74-0.79	.029-.031	1.37	.054	35.59	8.0
	26	0.12	0.68-0.74	.027-.029	1.37	.054	17.79	4.0
	28	0.08	0.66-0.71	.026-.028	1.37	.054	13.34	3.0
	30	0.05	0.63-0.66	.026-.027	1.37	.054	8.89	2.0
40445	22	0.35	0.79-0.84	.031-.033	1.37	.054	44.88	10.0
	24	0.20	0.74-0.79	.029-.031	1.37	.054	35.59	8.0
	26	0.12	0.68-0.74	.027-.029	1.37	.054	17.79	4.0
	28	0.08	0.66-0.71	.026-.028	1.37	.054	13.34	3.0
	30	0.05	0.63-0.66	.026-.027	1.37	.054	8.89	2.0
41572	22	0.35	0.79-0.84	.031-.033	1.37	.054	44.88	10.0
	24	0.20	0.74-0.79	.029-.031	1.37	.054	35.59	8.0
	26	0.12	0.68-0.74	.027-.029	1.37	.054	17.79	4.0
	28	0.08	0.66-0.71	.026-.028	1.37	.054	13.34	3.0
	30	0.05	0.63-0.66	.026-.027	1.37	.054	8.89	2.0

Tool Qualification Notes:

1. Pull Force should be measured with no influence from the insulation crimp.
2. The above specifications are guidelines to an optimum crimp.

PARTS LIST

Mini-Mac Applicator 63888-2100				
Item	Order No	Engineering No.	Description	Quantity
Perishable Tooling				
	63888-2170	63888-2170	Tool Kit (All "Y" Items)	REF
1	11-18-5258	60703C131	Conductor Punch	1 Y
2	11-18-5259	60703C132	Conductor Anvil	1 Y
3	63891-0030	63891-0030	Insulation Punch	1 Y
4	63891-0080	63891-0080	Insulation Anvil	1 Y
5	11-18-4009	60703-11	Cut-Off Punch	1 Y
6	11-18-4468	60703-19	Cut-off Insert	1 Y
Other Components				
7	11-18-4001	60703-3	Cover Plate	1
8	11-18-4003	60703-5	Front Cover	1
9	11-18-4004	60703-6	Insulation Punch Spacer	1
10	11-18-4006	60703-8	Stripper Blade Holder	1
11	11-18-4332	60703-16	Stripper	1
12	11-18-4469	60703-20	Retainer Block	1
13	11-40-4085	8301-10	Terminal Stop and Scrape Shield	1
14	63803-5117	63803-5117	Conductor Bushing	1
15	63820-0012	63820-0012	Cover-Drag Frame	1
Frame				
16	63801-3201	63801-3201	Top	1
17	63801-3283	63801-3283	Base	1
18	63801-6950	63801-6950	Track	1
Hardware				
19	N/A	N/A	M3 by 6 Long SHCS	2**
20	N/A	N/A	M3 by 8 Long SHCS	2**
21	N/A	N/A	M4 by 6 Long SHCS	2**
22	N/A	N/A	M4 by 12 Long BHCS	2**
23	N/A	N/A	M5 by 10 Long SHCS	1**
24	N/A	N/A	M8 by 20 Long BHCS	1**
25	N/A	N/A	#4-40 by .19" Long SHCS	2**
26	N/A	N/A	#6-32 by 3/8" Long BHCS	2**
27	N/A	N/A	#10-32 by 1.120" Long SHCS	1**
** Available from an industrial supply company such as MSC (1-800-645-7270).				

Assembly Drawing

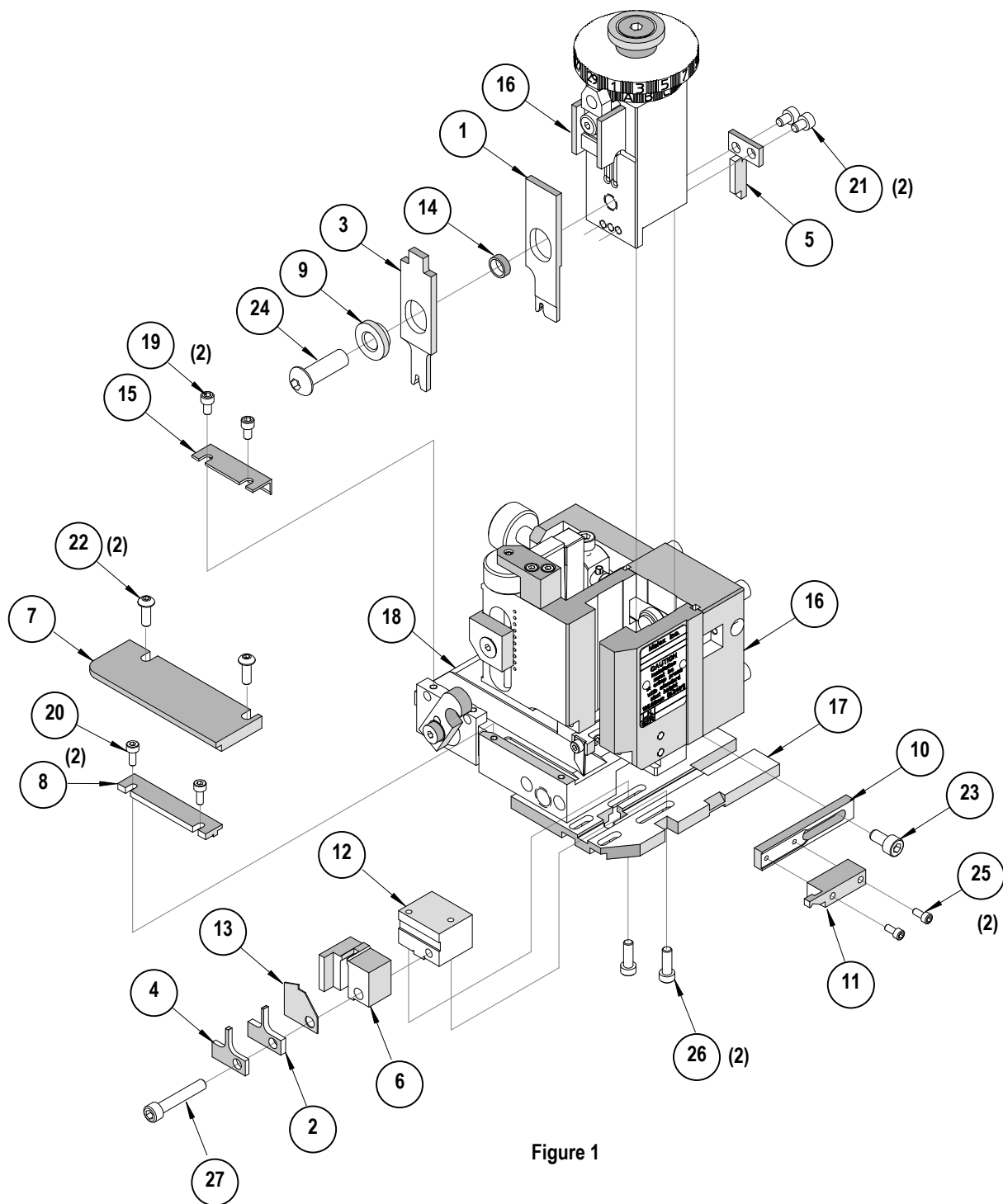


Figure 1

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 MiniMac Manual.

CAUTION: This applicator should only be used in a press with a shut height of 135.8 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.

<http://www.molex.com>

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Офис по работе с юридическими лицами:

105318, г.Москва, ул.Щербаковская д.3, офис 1107, 1118, ДЦ «Щербаковский»

Телефон: +7 495 668-12-70 (многоканальный)

Факс: +7 495 668-12-70 (доб.304)

E-mail: info@moschip.ru

Skype отдела продаж:

moschip.ru

moschip.ru_4

moschip.ru_6

moschip.ru_9