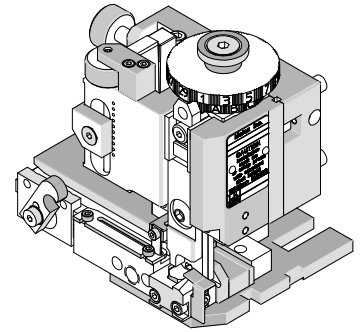




# Mini-Mac Applicator Specification Sheet Order No. 63891-6000



## FEATURES

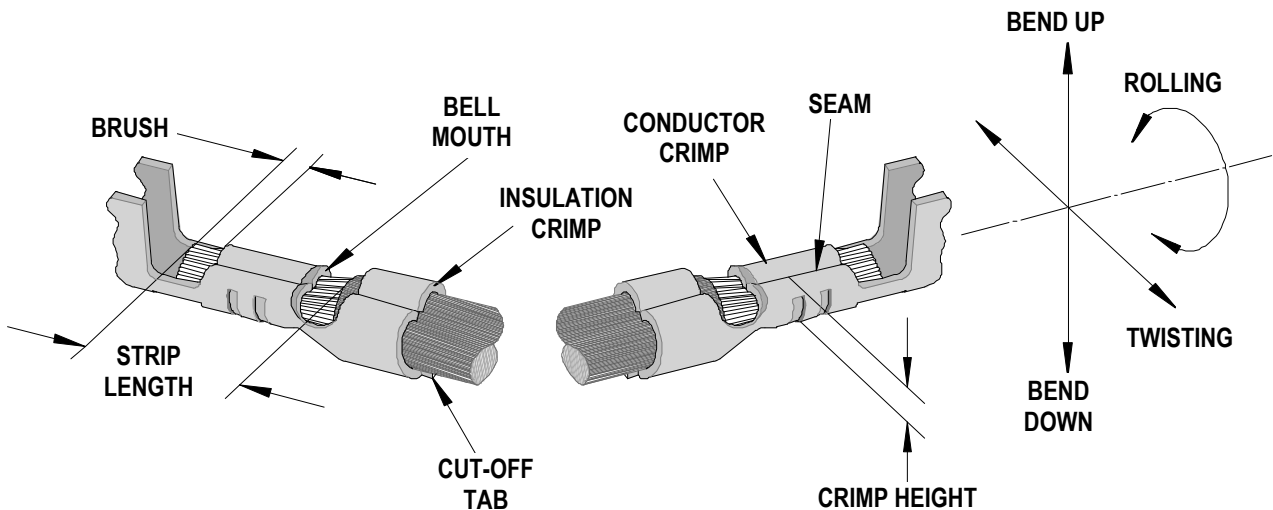
- Directly adapts to most automatic wire processing machines
- Applicator designed to industry standard mounting and shut height 135.80mm (5.346")
- Quick set-up time; plus the crimp height, track and feed adjustments can be set without removing the applicator from the press
- Fine adjustment allows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

| Terminal Series No. | Terminal Order No. | Wire Size |                 | Insulation Diameter |           | Strip Length |           |
|---------------------|--------------------|-----------|-----------------|---------------------|-----------|--------------|-----------|
|                     |                    | AWG       | mm <sup>2</sup> | mm                  | In.       | mm           | In.       |
| 43374               | 43374-0001         | 14-16     | 2.00-1.30       | 2.36-3.56           | .093-.140 | 3.96-5.54    | .156-.218 |
| 43375               | 43375-0001         | 14-16     | 2.00-1.30       | 2.36-3.56           | .093-.140 | 3.96-5.54    | .156-.218 |

## 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. | Wire Size |                 | Bell mouth |           | Cut-off Tab Maximum |      | Conductor Brush |      |
|---------------------|-----------|-----------------|------------|-----------|---------------------|------|-----------------|------|
|                     | AWG       | mm <sup>2</sup> | mm         | In.       | mm                  | In.  | mm              | In.  |
| 43374               | 14-16     | 2.00-0.80       | 0.20-0.50  | .008-.020 | 0.30                | .012 | 0.76            | .030 |
| 43375               | 14-16     | 2.00-0.80       | 0.20-0.50  | .008-.020 | 0.30                | .012 | 0.76            | .030 |

| Terminal Series No. | Bend up Bend down |    | Twist Roll |    | Punch Width (Ref) |      |            |      | Seam<br>Seam shall not be open<br>and no wire allowed out<br>of the crimping area |
|---------------------|-------------------|----|------------|----|-------------------|------|------------|------|---|
|                     | Degree            |    | Degree     |    | Conductor         |      | Insulation |      |   |
|                     | mm                | In | mm         | In | mm                | In   | mm         | In   |   |
| 43374               | 3                 | 3  | 4          | 8  | 2.50              | .098 | 3.90       | .154 |   |
| 43375               | 3                 | 3  | 4          | 8  | 2.50              | .098 | 3.90       | .154 |   |

After crimping, the conductor profile should measure the following.

| Terminal Series No. | Wire Size |                 | Conductor Crimp Height |           | Pull Force Minimum |      |
|---------------------|-----------|-----------------|------------------------|-----------|--------------------|------|
|                     | AWG       | mm <sup>2</sup> | mm                     | In.       | N                  | Lb.  |
| 43374               | 14        | 2.00            | 1.65-1.75              | .065-.069 | 222.4              | 50.0 |
|                     | 16        | 1.30            | 1.47-1.57              | .058-.062 | 133.4              | 30.0 |
| 43375               | 14        | 2.00            | 1.65-1.75              | .065-.069 | 222.4              | 50.0 |
|                     | 16        | 1.30            | 1.47-1.57              | .058-.062 | 133.4              | 30.0 |

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

The above specifications are guidelines to an optimum crimp.

**PARTS LIST**

| <b>Mini-Mac Applicator 63891-6000</b>  |                 |                        |                          |                 |
|--|-----------------|------------------------|--------------------------|-----------------|
| <b>Item</b>  | <b>Order No</b> | <b>Engineering No.</b> | <b>Description</b>       | <b>Quantity</b> |
| <b>Perishable Tooling</b>  |                 |                        |                          |                 |
|  | 63891-6070      | 63891-6070             | Tool Kit (All "Y" Items) | REF             |
| 1  | 11-18-5418      | 60843A106              | Conductor Punch          | 1 Y             |
| 2  | 63445-2562      | 63445-2562             | Conductor Anvil          | 1 Y             |
| 3  | 11-18-5414      | 60842A108              | Insulation Punch         | 1 Y             |
| 4  | 63445-3947      | 63445-3947             | Insulation Anvil         | 1 Y             |
| 5  | 63443-0002      | 63443-0002             | Front Cut-Off Plunger    | 1 Y             |
| 6  | 63443-0012      | 63443-0012             | Cut-off Plunger Retainer | 1 Y             |
| <b>Other Components</b>  |                 |                        |                          |                 |
| 7  | 11-18-5007      | 60800D114              | Hold Down Plunger Spring | 1               |
| 8  | 11-18-5115      | 60805A119              | Wire Stop/Stripper       | 1               |
| 9  | 11-18-5410      | 60832A141              | Hold Down Block          | 1               |
| 10   | 11-18-5411      | 60832A142              | Spring Retainer          | 1               |
| 11   | 11-18-5412      | 60832A143              | Hold Down Plunger        | 1               |
| 12   | 11-18-5416      | 60842A115              | Tooling Washer           | 1               |
| 13   | 11-18-5420      | 60843A111              | Anvil Mount              | 1               |
| 14   | 11-18-5421      | 60843A114              | Plunger Striker          | 1               |
| 15   | 11-18-5442      | 60843A123              | Front Cover              | 1               |
| 16   | 11-24-1067      | 4996-4                 | Cut-off Plunger Spring   | 1               |
| 17   | 63443-0021      | 63443-0021             | Lower Tooling Key        | 1               |
| 18   | 63443-6125      | 63443-6125             | Rear Cover               | 1               |
| 19   | 63803-5105      | 63803-5105             | Conductor Bushing        | 1               |
| <b>Frame</b>   |                 |                        |                          |                 |
| 20   | 63801-3201      | 63801-3201             | Top                      | 1               |
| 21   | 63801-3282      | 63801-3282             | Base                     | 1               |
| 22   | 63801-6550      | 63801-6550             | Track                    | 1               |
| <b>Hardware</b>  |                 |                        |                          |                 |
| 23   | N/A             | N/A                    | M3 by 6 Long SHCS        | 4**             |
| 24   | N/A             | N/A                    | M4 by 10 Long BHCS       | 2**             |
| 25   | N/A             | N/A                    | M4 by 12 Long BHCS       | 2**             |
| 26   | N/A             | N/A                    | M4 by 12 Long SHCS       | 2**             |
| 27   | N/A             | N/A                    | M4 by 25 Long SHCS       | 2**             |
| 28   | N/A             | N/A                    | M5 by 10 Long SHCS       | 1**             |
| 29   | N/A             | N/A                    | M8 by 20 Long BHCS       | 1**             |
| 30   | N/A             | N/A                    | 3MM by 6 Long Roll Pin   | 1**             |
| ** Available from an industrial supply company such as MSC (1-800-645-7270). |                 |                        |                          |                 |

### Assembly Drawing

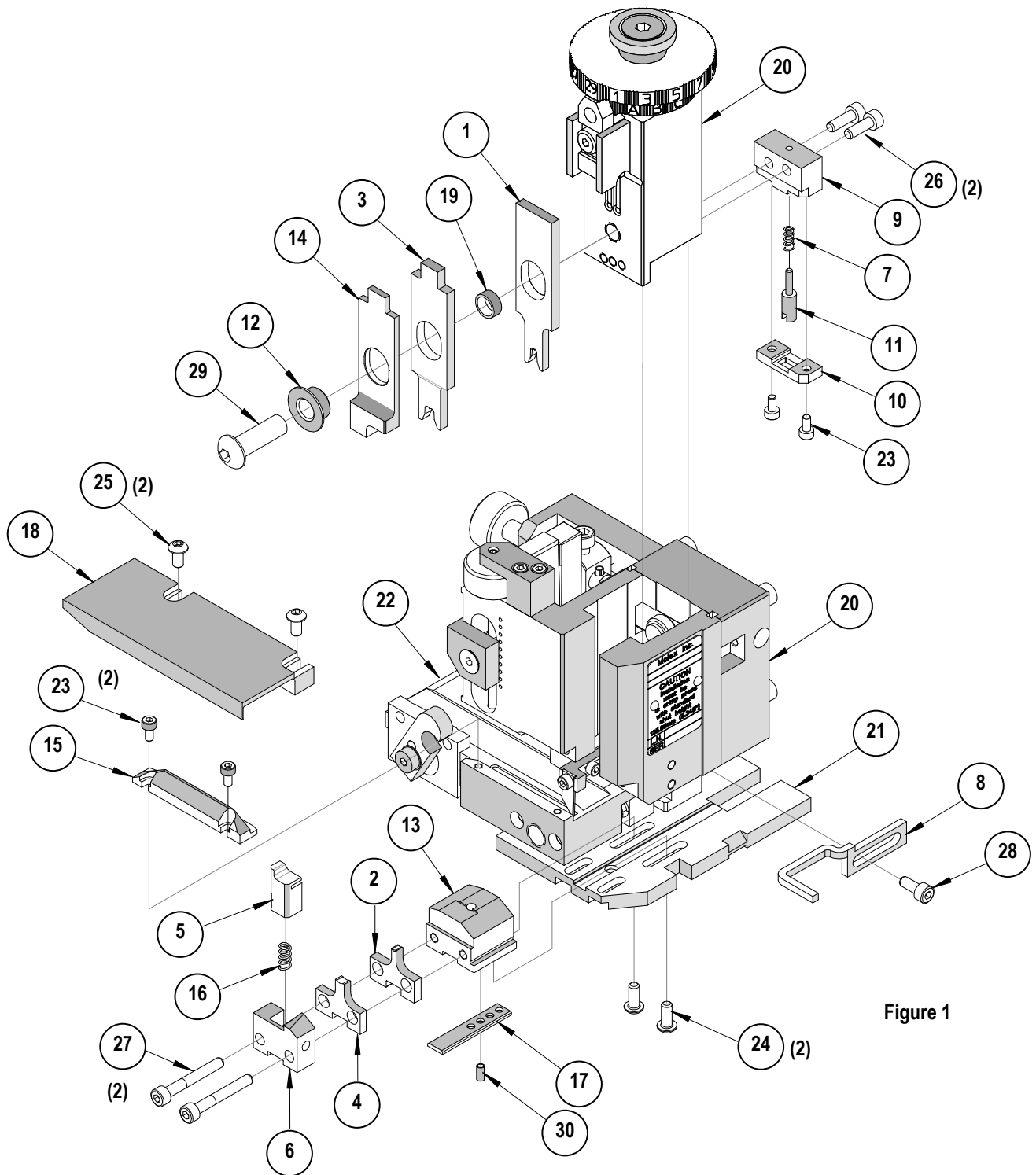


Figure 1

## 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.

**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

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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](mailto:info@moschip.ru)

Skype отдела продаж:

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