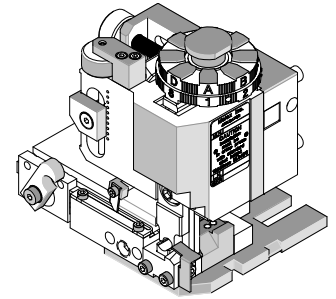




Mini-Mac Applicator Specification Sheet Order No. 63830-0100



FEATURES

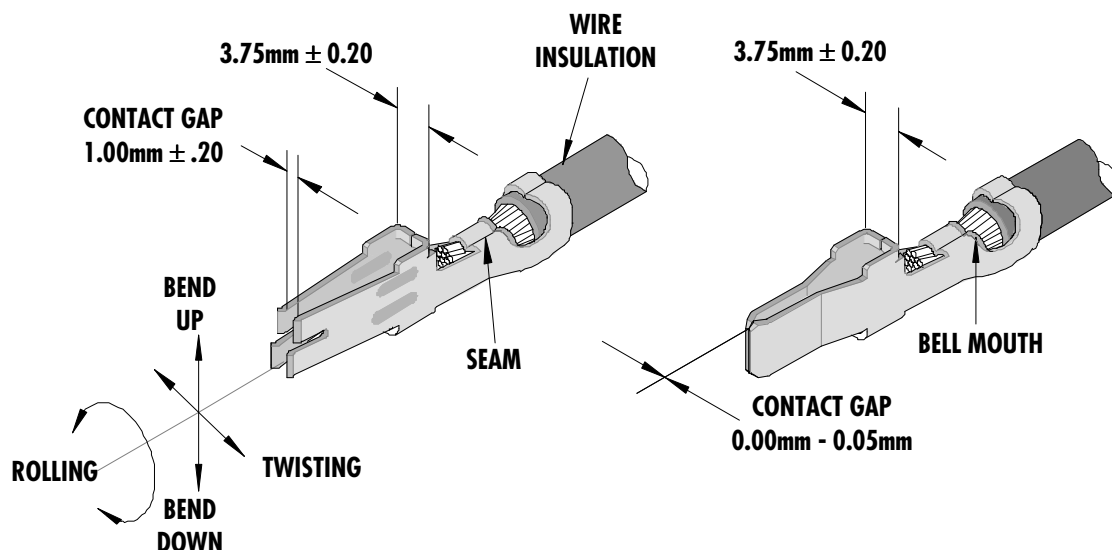
- Quick set-up time; plus the crimp height, track and feed adjustments can be preset in applicator
- Conductor and insulation rings allow quick adjustment for conductor and insulation diameter change
- Applicator designed to industry standard mounting and shut height 135.80mm (5.346")
- Directly adapts to most automatic wire processing machines. Optimum terminal feed/indexing can be obtained with the optional terminal guide assembly, Order No. 63830-0120. See page 5.

SCOPE

Mini-Fit Sr.™ Male and Female Crimp Terminals, 10 to 12 AWG

Terminal Series No.	Terminal Order No.		Wire Size		Insulation Diameter		Strip Length	
			AWG	mm ²	mm	In.	mm	In.
42815	42815-0010	42815-0012	10-12	3.30 - 5.00	3.50-5.30	.138-.209	7.50-8.50.	295-.335
	42815-0011	42815-0019						
42817	42817-0010	42817-0110	10-12	3.30 - 5.00	3.50-5.30	.138-.209	7.50-8.50.	295-.335
	42817-0011	42817-0111						
	42817-0012	42817-0112						
	42817-0019							

DEFINITION OF TERMS



CRIMP SPECIFICATIONS

Terminal Series No.	Wire Size		Bell mouth		Cut-off Tab Max.		Conductor Brush	
	AWG	mm ²	mm	In.	mm	In.	mm	In.
42815	10-12	3.30 - 5.00	.20-.50	.008-.020	.30-.50 Max.	.012-.020	3.50-4.50	.138-.177
42817	10-12	3.30 - 5.00	.20-.50	.008-.020	.30-.50 Max.	.012-.020	3.50-4.50	.138-.177

Terminal Series No.	Wire Size		Bend up Bend down		Twist Roll		Seam Seam shall not be open and no wire allowed out of the crimping area.
	AWG	mm ²	Degree		Degree		
42815	10-12	3.30 - 5.00	3	3	4	8	
42817	10-12	3.30 - 5.00	3	3	4	8	

After crimping, the conductor profile should measure the following.

Terminal Series No.	Wire Size		Conductor				Pull Force Min.	
	AWG	mm ²	Crimp Height		Crimp Width		N	Lb.
			mm	In.	mm	In.		
42815	10	5.00	2.69-2.79	.106-.110	3.60	.142	355.0	80.0
	12	3.30	2.39-2.49	.094-.098	3.60	.142	311.0	70.0
42817	10	5.00	2.69-2.79	.106-.110	3.60	.142	355.0	80.0
	12	3.30	2.39-2.49	.094-.098	3.60	.142	311.0	70.0

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

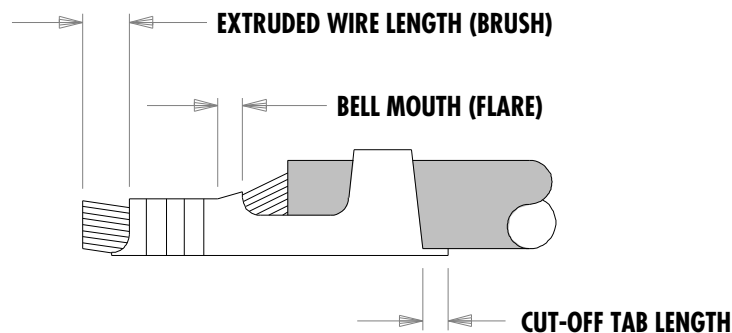


Figure 1

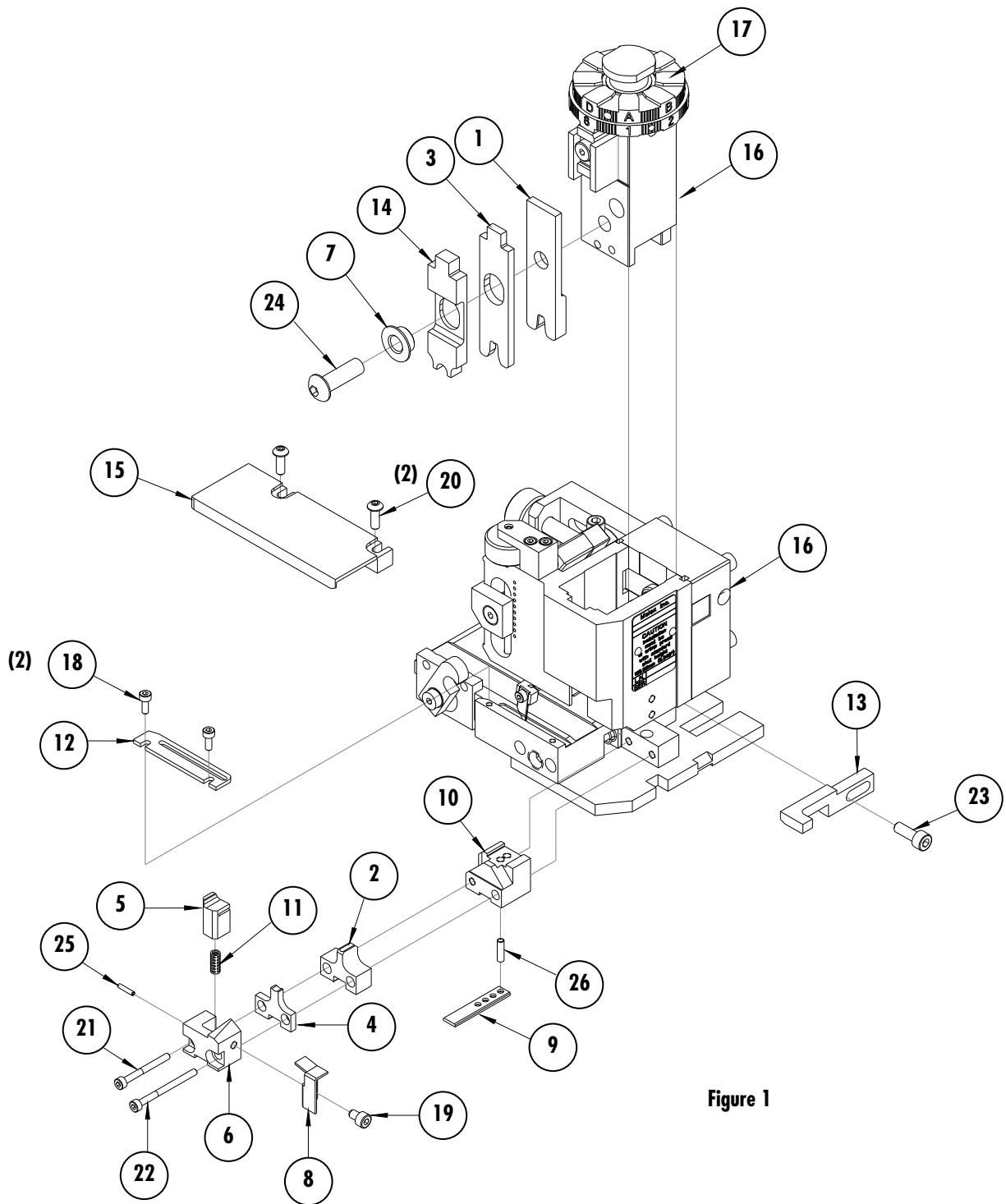
Special Note:

Cut-off Tab length below 0.30mm may cause the box dimension to be under recommendation. See Figure 1

PARTS LIST

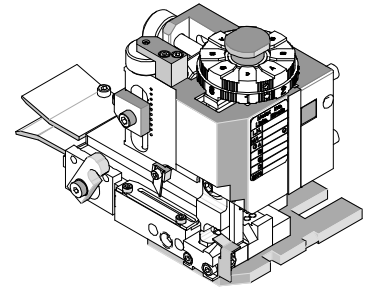
Mini-Mac Applicator 63830-0100				
Item	Order No	Engineering No.	Description	Quantity
Perishable Tooling				
	63830-0170	63830-0170	Tool Kit (All "Y" Items)	REF
1	11-18-5244	60827A106	Conductor Punch	1 Y
2	63821-0002	63821-0002	Conductor Anvil	1 Y
3	11-18-5246	60827A108	Insulation Punch	1 Y
4	63821-0004	63821-0004	Insulation Anvil	1 Y
5	63443-0045	63443-0045	Front Cut-off Plunger	1 Y
6	63443-0046	63443-0046	Front Cut-off Plunger Retainer	1 Y
Other Components				
7	11-18-5248	60827A115	Tooling Washer	1
8	63443-0009	63443-0009	Scrap Chute Front	1
9	63443-0021	63443-0021	Lower Tooling Key	1
10	63443-2401	63443-2401	Anvil Mount	1
11	63700-0539	63700-0539	Cut-Off Plunger Spring	1
12	63821-0012	63821-0012	Front Cover	1
13	63821-0015	63821-0015	Wire Stop	1
14	63830-0008	63830-0008	Front Plunger Striker	1
15	63830-0113	63830-0113	Rear Cover	1
15A	63830-0120	63830-0120	Optional Terminal Guide Assembly	0
Frame				
16	63800-4300	63800-4300	Mini-Mac Applicator Frame	1
17	69028-0806	69028-0806	Conductor Adjusting Cam	1
Hardware				
18	N/A	N/A	M3 by 6 Long SHCS	2**
19	N/A	N/A	M4 by 6 Long SHCS	1**
20	N/A	N/A	M4 by 12 Long BHCS	2**
21	N/A	N/A	M4 by 30 Long SHCS	1**
22	N/A	N/A	M4 by 50 Long SHCS	1**
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	2mm by 8 Long Roll Pin	1**
26	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

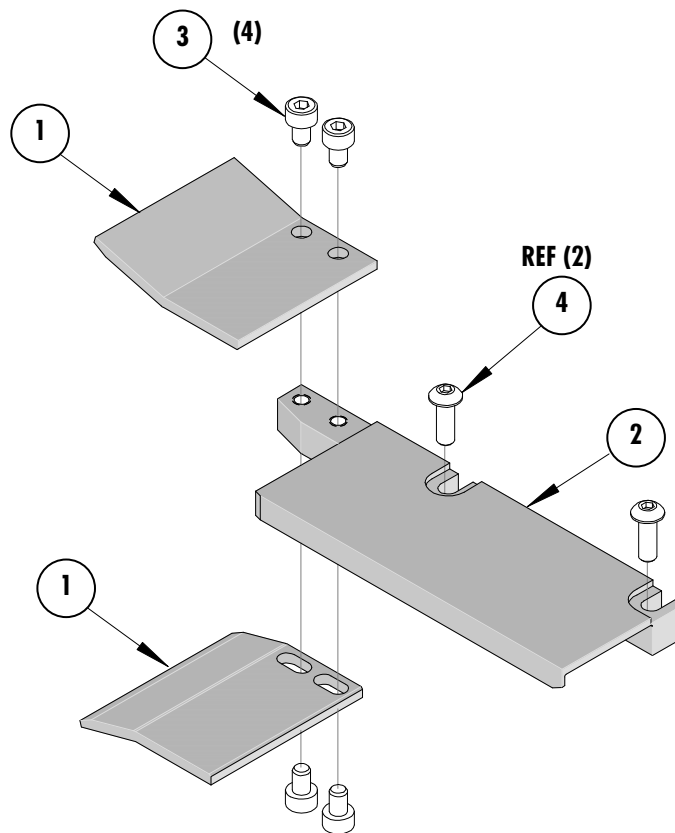


OPERATION:

The Optional Terminal Guide Assembly helps to align slightly bent up or down terminals, entering the track. Recommended for use with wire processing equipment, or roughly handled terminal reels. To install the Optional Terminal Guide assembly follow the steps below.



- 1 Remove the M4 X 12 BHCS (2) from the existing rear cover (Part No. 63830-0113) on the applicator.
- 2 Remove the 63830-0113 rear cover.
- 3 Replace it with the 63830-0120 Optional Terminal Guide Assembly.
- 4 Replace the M4 X 12 BHCS (2).



Optional Terminal Guide Assembly 63830-0120				
Item	Order No	Engineering No.	Description	Quantity
1	63830-0117	63830-0117	Terminal Lead-In	2
2	63830-0118	63830-0118	Rear Cover	1
Hardware				
3	N/A	N/A	M3 by 6 Long SHCS	4**
4	N/A	N/A	M4 by 12 Long BHCS	REF**
** Available from an industrial supply company such as MSC (1-800-645-7270).				

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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