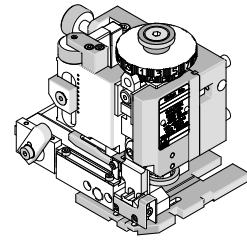


Mini-Mac
Applicator**molex****Application Tooling
Specification Sheet****Order No. 63894-1100****FEATURES**

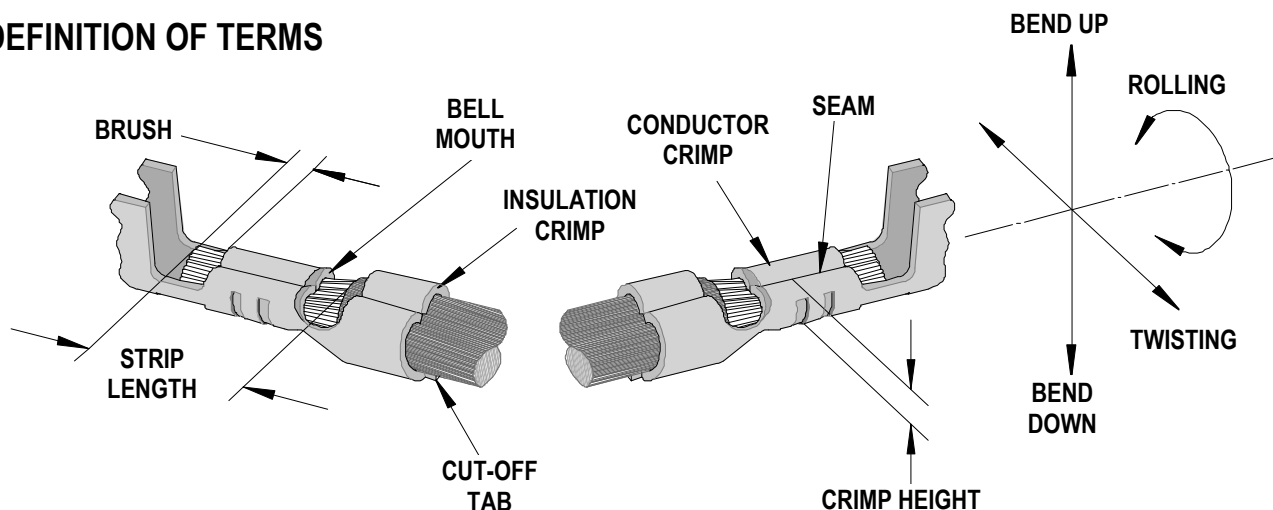
- Directly adapts to most automatic wire processing machines
- Applicator designed to industry standard mounting and shut height 135.80mm (5.346")
- Quick set-up time; plus the crimp height, track and feed adjustments can be set without removing the applicator from the press
- Fine adjustment allows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

Terminal Series No.	Terminal Order No	Wire Size		Insulation Diameter Max.		Strip Length	
		AWG	mm ²	mm	In.	mm	In.
1508	05-06-0117	14	2.00	3.55	.140	3.96-5.35	.156-.218
		18+18	0.80+0.80				
2776	◆	14	2.00	3.55	.140	3.96-5.35	.156-.218
		16+16	1.30+1.30				
		18+18	0.80+0.80				

For 16-20 AWG single wire applications 63894-1000 is recommended.
◆ Consult your Molex sales representative for details.

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		Cut-off Tab Maximum		Conductor Brush	
	mm	In.	mm	In.	mm	In.
1508						
2776			0.50	.020		

Terminal Series No.	Bend up	Bend down	Twist	Roll	Punch Width (Ref)			
	Degree		Degree		Conductor		Insulation	
					mm	In.	mm	In.
1508					3.10	.122	4.25	.167
2776					3.10	.122	4.25	.167

Seam

14 AWG UL Style 1015 may have pinched strands or an open seam. This condition is normal and does not effect crimp performance. The customer should determine suitability for the end application. For all other wire gauges the seam shall not be open and no wire is allowed out of the crimping area.

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.
1508	14	2.00	1.47-1.57	.058-.062	3.10-3.19	.122-.126	191.3	43.0
	18+18	0.80+0.80	1.37-1.47	.054-.058	3.10-3.19	.122-.126	133.4	30.0
2776	14	2.00	1.47-1.57	.058-.062	3.10-3.19	.122-.126	191.3	43.0
	16+16	1.30+1.30	1.57-1.68	.062-.066	3.10-3.19	.122-.126	177.9	40.0
	18+18	0.80+0.80	1.37-1.47	.054-.058	3.10-3.19	.122-.126	133.4	30.0

NOTE: Some of the specifications in these charts above are intentionally left blank due to the fact that the information does not currently exist.

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 63894-1100				
Item	Order No	Engineering No.	Description	Quantity
Perishable Tooling				
	63894-1170	63894-1170	Tool Kit (All "Y" Items)	REF
1	11-18-5069	60811B106	Conductor Punch	1 Y
2	11-18-5070	60811B107	Conductor Anvil	1 Y
3	11-18-5071	60811B108	Insulation Punch	1 Y
4	11-18-5072	60811B109	Insulation Anvil	1 Y
5	11-18-5376	60804F144	Front Cut-Off Plunger	1 Y
6	11-18-5375	60804F143	Front Cut-Off Plunger Retainer	1 Y
Other Components				
7	11-18-4083	60707-8	Feed Guide	1
8	11-18-5005	60800D112	Hold Down Block	1
9	11-18-5006	60800D113	Spring Retainer	1
10	11-18-5007	60800D114	Compression Spring (Hold Down)	1
11	11-18-5064	60811A111	Anvil Mount	1
12	11-18-5065	60811A115	Tooling Washer	1
13	11-18-5067	60811A121	Hold Down Plunger	1
14	11-18-5068	60811A122	Hold Down 1508 Terminal	1
15	11-18-5114	60804A130	Scrap Deflector	1
16	11-18-5115	60805A119	Wire Stop	1
17	11-18-5116	60804A141	Compression Spring (Knock out)	1
18	11-18-5374	60804F142	Knockout Blade	1
19	11-24-1067	4996-4	Cut Off Plunger Spring	1
20	63443-6125	63443-6125	Rear Cover	1
21	63803-5118	63803-5118	Conductor Bushing	1
22	63894-1101	63894-1101	Front Plunger Striker	1
Frame				
23	63801-3201	63801-3201	Top	1
24	63801-3282	63801-3282	Base	1
25	63801-6550	63801-6550	Track	1
Hardware				
26	N/A	N/A	M2.5 by 6 Long SHCS	1**
27	N/A	N/A	M3 by 6 Long SHCS	4**
28	N/A	N/A	M3 by 20 Long SHCS	2**
29	N/A	N/A	M4 by 6 Long SHCS	1**
30	N/A	N/A	M4 by 8 Long BHCS	2**
31	N/A	N/A	M4 by 12 Long BHCS	2**
32	N/A	N/A	M4 by 16 Long SHCS	2**
33	N/A	N/A	M5 by 14 Long SHCS	1**
34	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

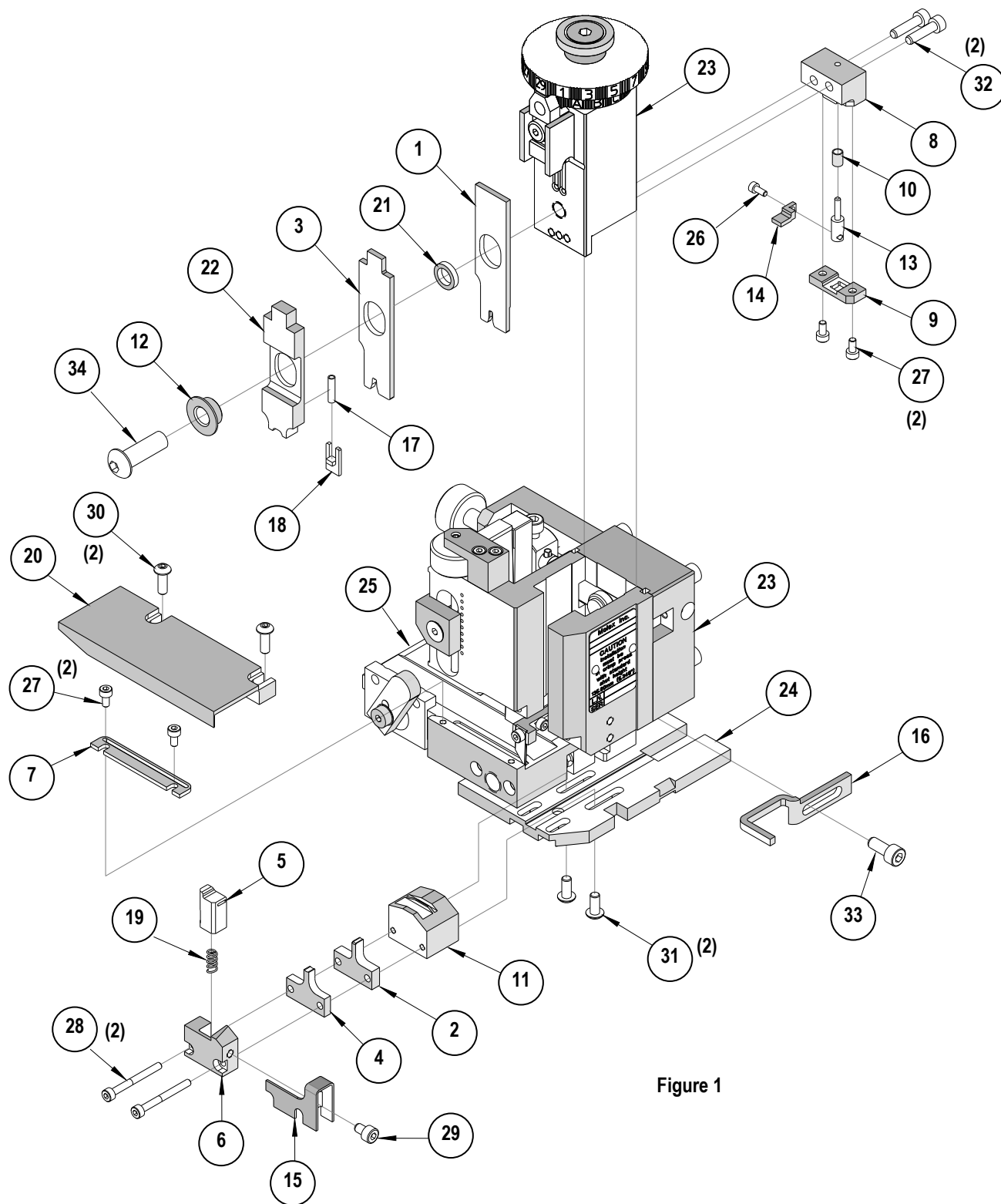


Figure 1

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.

<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