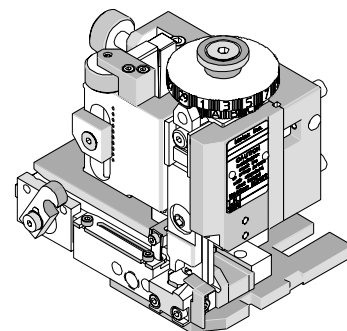




Mini-Mac Applicator Specification Sheet Order No. 63892-6100



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.

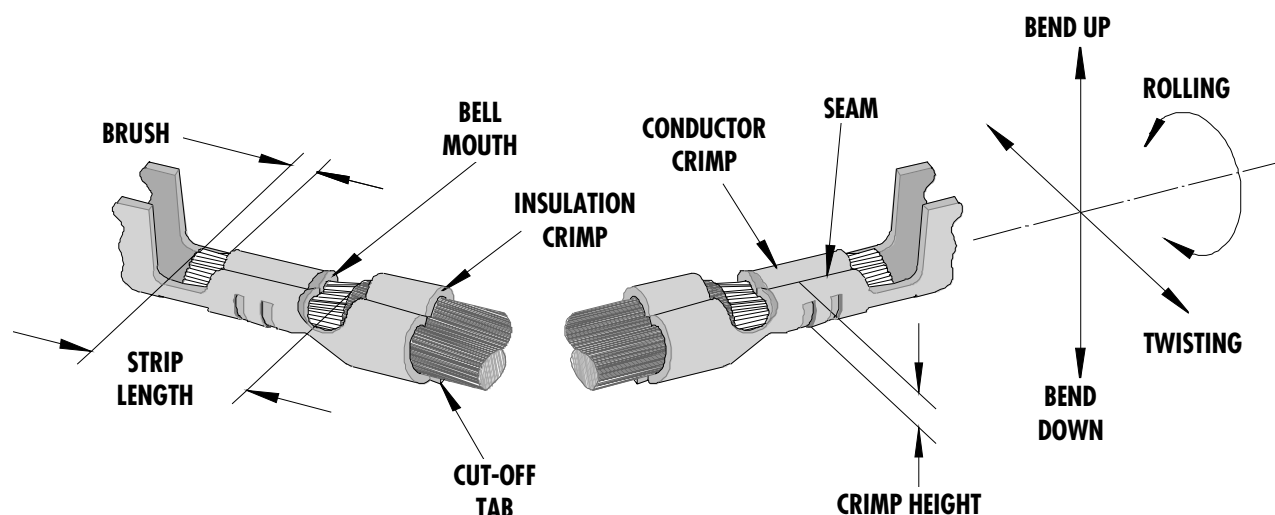
SCOPE

Products: High Normal Force (HNF) Female Terminals. High Normal Force (HNF) Female Terminal, For 6.3 x 0.8mm (.248 x .031") Tabs, 12-16.

Terminal Series No.	Terminal Order No.	Wire Size		Insulation Diameter		Strip Length	
		AWG	mm ²	mm	In.	mm	In.
94518	94518-0400 94518-0401	16(2)	1.50 (2)	3.14 Max.	.123 Max.	5.00-5.50	.197-.216
		18 + 16	0.75 + 1.50	3.14 Max.	.123 Max.	5.00-5.50	.197-.216
		18 (2)	0.75 (2)	3.14 Max.	.123 Max.	5.00-5.50	.197-.216
		20+16	0.50+1.50	3.14 Max.	.123 Max.	5.00-5.50	.197-.216
		20+18	0.50+0.75	3.14 Max.	.123 Max.	5.00-5.50	.197-.216
		20 (2)	0.50 (2)	3.14 Max.	.123 Max.	5.00-5.50	.197-.216

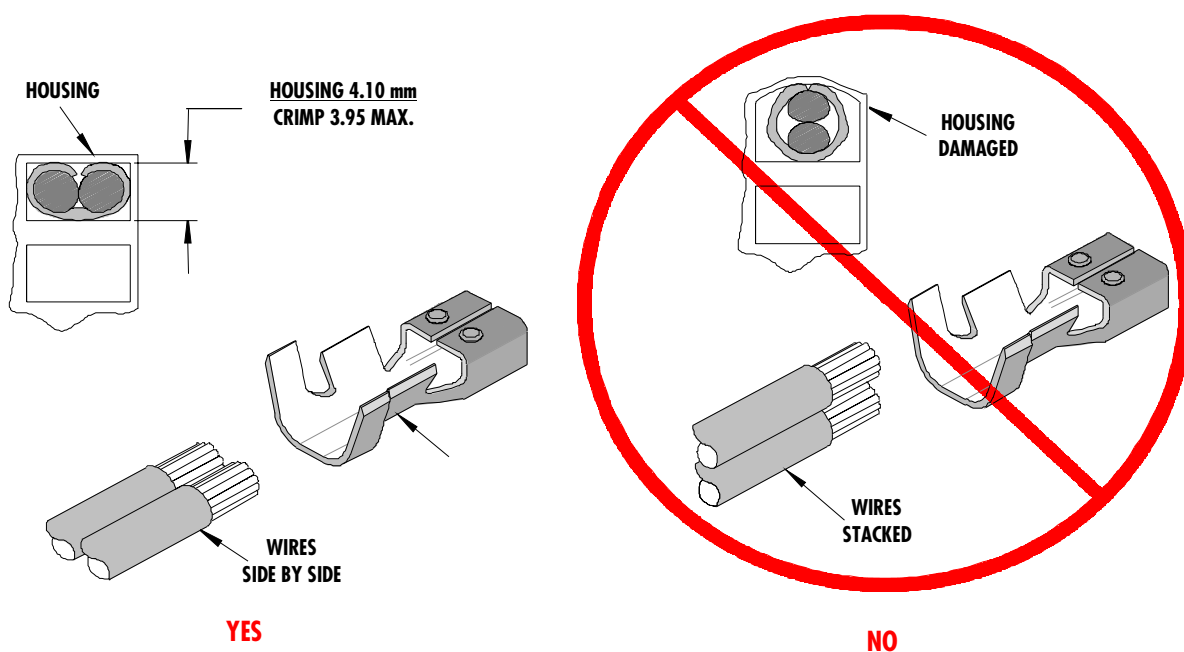
DEFINITION OF TERMS

The following illustration is a generic terminal representation and not an exact image of any terminal listed in the scope.



Wire Feeding Orientation

This Terminal and Connector Housing requires that the wires be crimped **side by side** to function properly, otherwise the housing and the latch may be damaged. It also may cause high insertion force to the header. See the following illustrations below.



CRIMP SPECIFICATION

Terminal Series No.	Bell mouth		Cut-off Tab Max.		Conductor Brush	
	mm	In.	mm	In.	mm	In.
94518	0.20-0.40	.008-.016	0.60	.024	0.50-1.50	.020-.059

Terminal Series No.	Bend up Bend down		Twist Roll		Punch Width (Ref)				Seam
	Degree		Degree		Conductor		Insulation		Seam shall not be open and no wire allowed out of the crimping area
					mm	In	mm	In	
94518	3	3	4	8	2.75	.108	5.50	.216	

After crimping, the crimp profiles should measure the following.

Terminal Series No.	Wire Size		Crimp Height				Crimp Width (Ref.)				Pull Force Minimum	
			Conductor		Insulation (Ref.)		Conductor (Ref.)		Insulation (Ref.)			
	AWG	mm ²	mm	In.	mm	In.	mm	In.	mm	In.	N	Lb.
94518	16+16	1.5+1.5	1.95-2.05	.077-.081	3.70-3.80	.146-.150	2.80-2.90	.110-.114	5.50-5.70	.216-.224	176.4	39.7
	18+16	0.75+1.5	1.95-2.05	.077-.081	3.70-3.80	.146-.150	2.80-2.90	.110-.114	5.50-5.70	.216-.224	176.4	39.7
	18+18	0.75+0.75	1.85-1.95	.073-.077	3.45-3.55	.136-.140	2.80-2.90	.110-.114	5.50-5.70	.216-.224	176.4	39.7
	20+16	0.5+1.5	1.85-1.95	.073-.077	3.45-3.55	.136-.140	2.80-2.90	.110-.114	5.50-5.70	.216-.224	78.2	17.6
	20+18	0.5+0.75	1.80-1.90	.070-.075	3.40-3.50	.134-.138	2.80-2.90	.110-.114	5.50-5.70	.216-.224	78.2	17.6
	20+20	0.5+0.5	1.75-1.85	.068-.073	3.35-3.45	.132-.136	2.80-2.90	.110-.114	5.50-5.70	.216-.224	78.2	17.6

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

Pull force listed is for the smaller AWG wire, one wire only.

The above specifications are guidelines to an optimum crimp.

PARTS LIST

Mini-Mac Applicator 63892-6100				
Item	Order No	Engineering No.	Description	Quantity
Perishable Tooling				
	63892-6170	63892-6170	Tool Kit (All "Y" Items)	REF
1	63470-0004	63470-0004	Conductor Punch	1 Y
2	63832-0402	63832-0402	Conductor Anvil	1 Y
3	63471-0006	63471-0006	Insulation Punch	1 Y
4	63832-0408	63832-0408	Insulation Anvil	1 Y
5	63832-0406	63832-0406	Front Cut-off Plunger	1 Y
6	63443-0036	63443-0036	Front Cut-off Plunger Retainer	1 Y
Other Components				
7	11-18-4083	60707-8	Feed Cover	1
8	63443-0009	63443-0009	Scrap Chute Front	1
9	63443-0025	63443-0025	Key Dual Carrier	1
10	63443-0062	63443-0062	Collar-8.0mm Long	1
11	63443-0090	63443-0090	Wire Stop	1
12	63443-1700	63443-1700	Z Spacer	1
13	63443-2214	63443-2214	14.0mm Spacer	1
14	63443-2310	63443-2310	3.5mm Spacer	1
15	63443-6123	63443-6123	Rear Cover	1
16	63700-0539	63700-0539	Cut-Off Plunger Spring	1
17	63700-3597	63700-3597	Compression Spring (Wire Locator)	1
18	63830-0505	63830-0505	Striker (Front Plunger)	1
19	63832-0407	63832-0407	Wire Locator	1
Frame				
20	63801-3201	63801-3201	Top	1
21	63801-3281	63801-3281	Base	1
22	63801-4650	63801-4650	Track	1
Hardware				
23	N/A	N/A	M3 by 6 Long FHCS	1**
24	N/A	N/A	M3 by 6 Long SHCS	2**
25	N/A	N/A	M4 by 6 Long SHCS	2**
26	N/A	N/A	M4 by 12 Long BHCS	2**
27	N/A	N/A	M4 by 50 Long SHCS	2**
28	N/A	N/A	M5 by 12 Long SHCS	1**
29	N/A	N/A	M8 by 30 Long BHCS	1**
** Available from an industrial supply company such as MSC (1-800-645-7270).				

Assembly Drawing

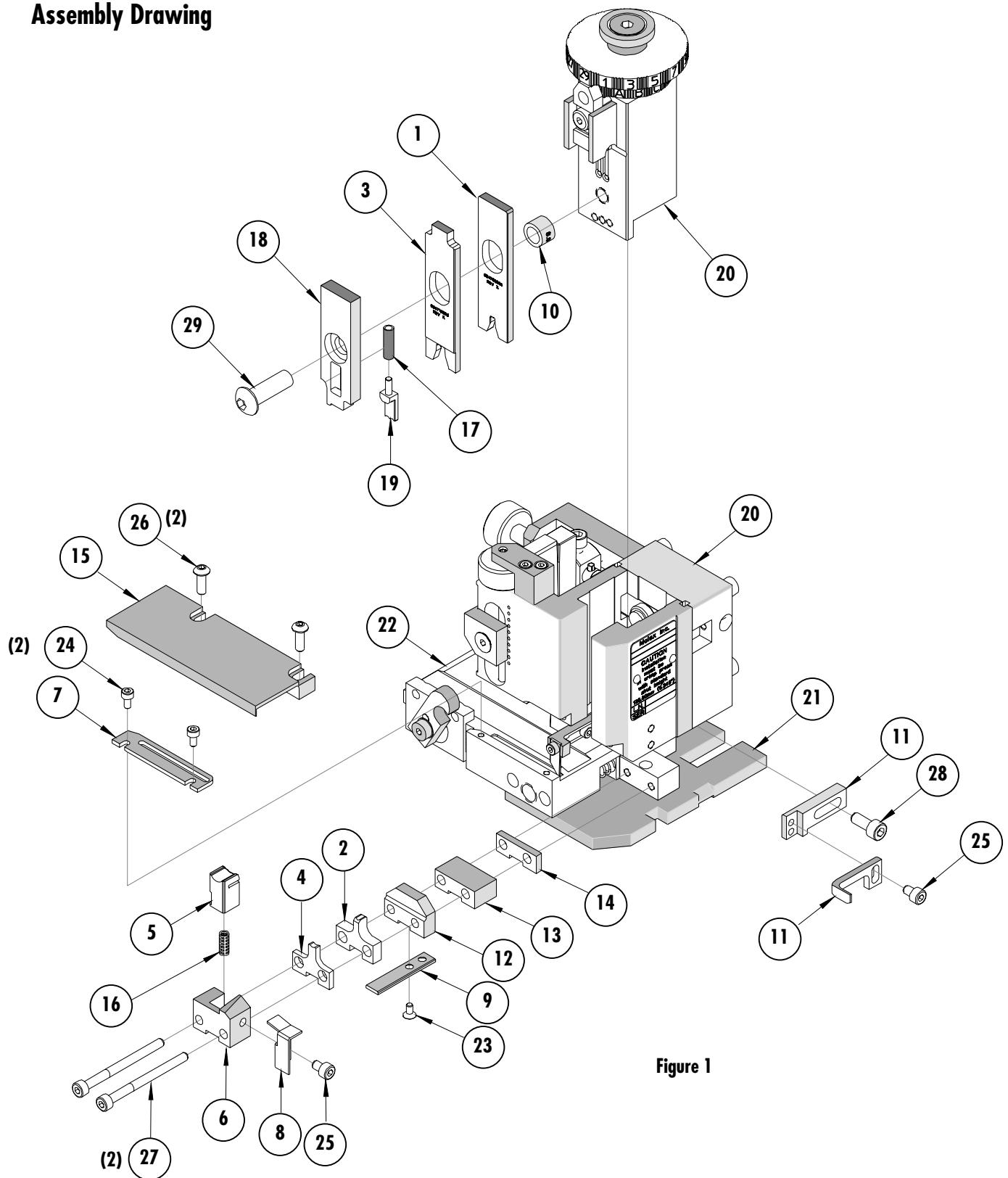


Figure 1

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.

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