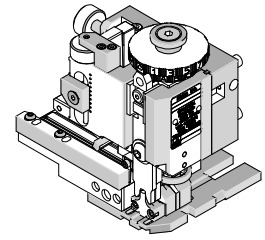




**Mini-Mac  
Applicator**

**Application Tooling  
Specification Sheet**



**Order No. 63882-1100**

**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.

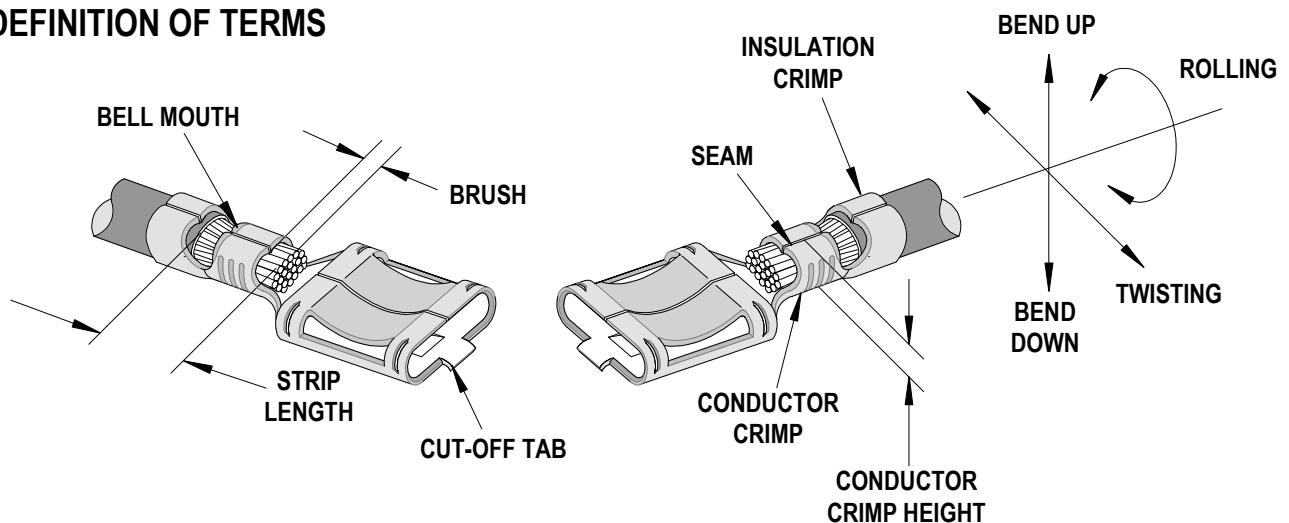
**SCOPE**

Products: Flat Blade Crimp Terminal 14-18 AWG

Terminal Series No.	Terminal Order No.		Wire Size		Insulation Diameter				Strip Length	
					IPC/WHMA-A620 (1)		Terminal (2)			
					AWG	mm <sup>2</sup>	mm	In.	mm	In.
41422	40-02-1602	41422-5001	14-18	2.00-0.80	2.80-3.30	.110-.130	3.10	.122	5.84	.230

(1) To achieve optimum IPC-A620 insulation crimps, use this insulation OD range.  
 (2) Overall insulation OD specification for terminal.  
 Applicator 63882-1300 should be used for insulation O.D. 1.90-2.40mm (.075-.095").

**DEFINITION OF TERMS**



## CRIMP SPECIFICATIONS

Terminal Series No.	Bell mouth		Cut-off Tab Maximum		Conductor Brush	
	mm	In.	mm	In.	mm	In.
41422			0.25	0.10		

Terminal Series No.	Bend up	Bend down	Twist	Roll	Punch Width (Ref)				Seam Seam shall not be open and no wire allowed out of the crimping area
	Degree		Degree		Conductor		Insulation		
	mm	In	mm	In	mm	In	mm	In	
41422					2.80	.110	3.70	.146	

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

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.
41422	14	2.00	1.70-1.75	.067-.069	266.9	60.0
	16	1.30	1.60-1.65	.063-.065	133.4	30.0
	18	0.80	1.50-1.55	.059-.061	88.9	20.0

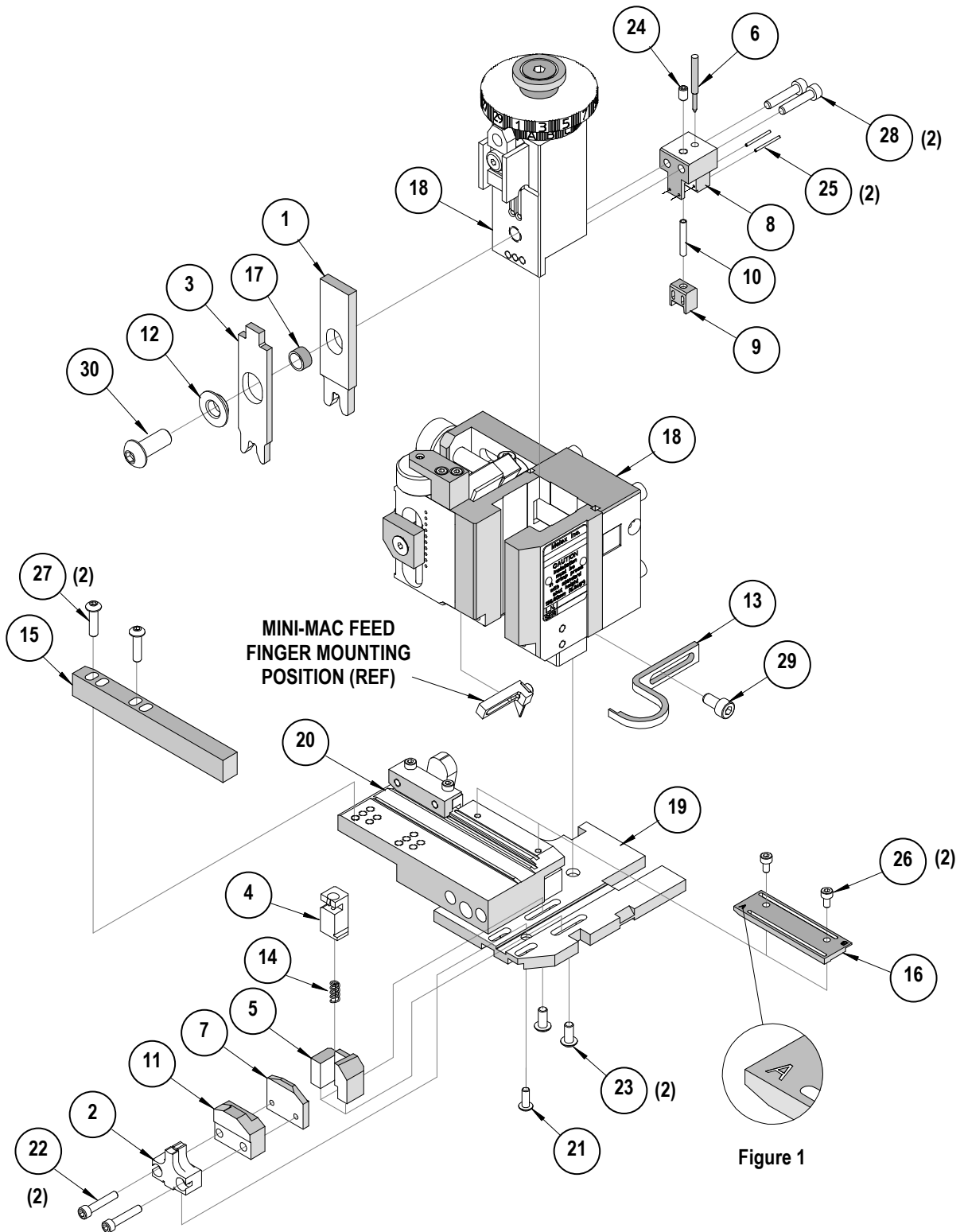
Tool Qualification Notes:

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**

<b>Mini-Mac Applicator 63882-1100</b>				
<b>Item</b>	<b>Order No</b>	<b>Engineering No.</b>	<b>Description</b>	<b>Quantity</b>
<b>Perishable Tooling</b>				
	63882-1170	63882-1170	Tool Kit (All "Y" Items)	REF.
1	11-18-4464	60739A201	Conductor Punch	1 Y
2	11-18-4465	60739A202	Combination Anvil	1 Y
3	11-18-4466	60739A203	Insulation Punch	1 Y
4	11-18-4451	60739A104	Cut-Off Plunger	1 Y
5	11-18-4452	60739A105	Plunger Retainer	1 Y
6	11-18-4454	60739A107	Pilot Pin	1 Y
7	11-18-4457	60739A110	Cut-off Die Blade	1 Y
<b>Other Components</b>				
8	11-18-4453	60739A106	Rear Plunger Striker	1
9	11-18-4455	60739A108	Terminal Hold Down	1
10	11-18-4456	60739A109	Hold Down Spring	1
11	11-18-4458	60739A111	Spacer	1
12	11-18-4467	60739A117	Tooling Washer	1
13	11-18-5012	60804A123	Wire Stop	1
14	11-24-1067	4996-4	Cut-Off Plunger Spring	1
15	63801-4510	63801-4510	Front Cover	1
16	63801-4558	63801-4558	Rear Cover	1
17	63803-5101	63803-5101	Conductor Bushing	1
<b>Frame</b>				
18	63801-3201	63801-3201	Top	1
19	63801-3282	63801-3282	Base	1
20	63801-6650	63801-6650	Track	1
<b>Hardware</b>				
21	N/A	N/A	#6-32 by 3/8" Long BHCS	1**
22	N/A	N/A	#6-32 by 3/4" Long SHCS	2**
23	N/A	N/A	#8-32 by 3/8" Long BHCS	2**
24	N/A	N/A	#8-32 by 1/4" Long SSS (Flat Point)	1**
25	N/A	N/A	3/64 by 5/8" Long Spirol Pin	2**
26	N/A	N/A	M3 by 6 Long SHCS	2**
27	N/A	N/A	M4 by 16 Long BHCS	2**
28	N/A	N/A	M4 by 22 Long SHCS	2**
29	N/A	N/A	M5 by 8 Long SHCS	1**
30	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



## NOTES

Molex recommends an extra perishable tooling kit be maintained at your facility.

1. Verify tooling alignment by manually cycling the press and Applicator before crimping under power. Check that all screws are tight.
2. Slugs, Terminals, Dirt and Oil should be kept clear of work area.
3. Wear safety glasses at all times.
4. For recommended maintenance refer to the Mini-Mac Manual.

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

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