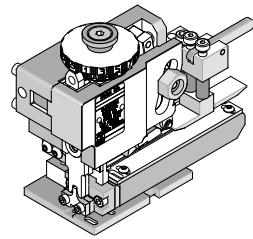




Rear Feed
Mini-Mac
Applicator

Application Tooling Specification Sheet



Order No. 63801-9000

FEATURES

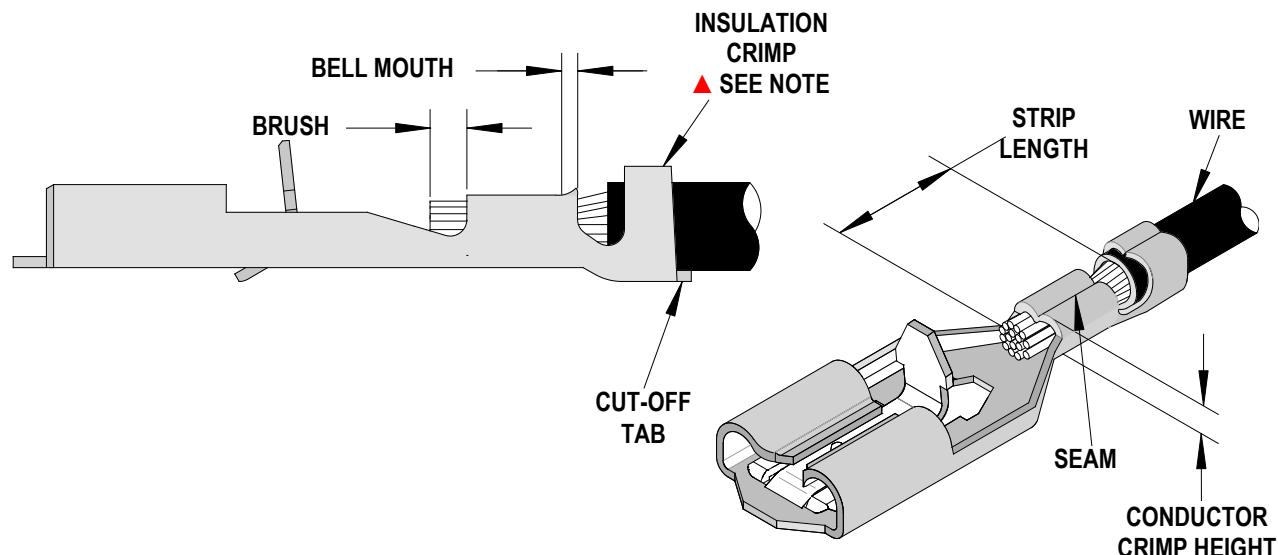
- Quick set-up time; plus the crimp height, track and feed adjustments can be preset in applicator
- Conductor and insulation rings allow quick adjustment for conductor and insulation diameter change
- Applicator designed to industry standard mounting and shut height 135.80mm (5.346")
- Directly adapts to most automatic wire processing machines

SCOPE

Products: MP-Lock™ Quick Disconnect, Female, for 20-22 AWG.

Terminal Series No.	Wire Size		Insulation Diameter		Strip Length	
	AWG	mm ²	mm	In.	mm	In.
35068-9702	22-20	0.3-0.5	2.70 Max.	.106	4.4-5.0	.173-.197
35068-9722	22-20	0.3-0.5	2.70 Max.	.106	4.4-5.0	.173-.197

DEFINITION OF TERMS



CRIMP SPECIFICATIONS

Terminal Series No.	Bell mouth		Cut-off Tab Maximum		Conductor Brush	
	mm	In.	mm	In.	mm	In.
35068	0.3-0.6	.012-.024	.50	.020	0.03-0.80	.012-.031

Terminal Series No.	Bend up Bend down	Twist	Roll	Punch Width				Seam Seam shall not be open and no wire allowed out of the crimping area
				Conductor		Insulation		
	Degree		Degree		mm	In	mm	
35608	3	3	3	5	1.75	.069	2.90	.114

After crimping, the crimp profile should measure the following.

Terminal Series No.	Wire Size		Conductor				Insulation				Pull Force Minimum	
			Crimp Height		Crimp Width		Crimp Height		Crimp Width		Kg Lb.	
	AWG	mm ²	mm	In.	mm	In.	mm	In.	mm	In.	Kg	Lb.
35068	20	.5	1.10-1.20	.043-.047	1.70-1.90	.066-.075	---	---	2.9-3.1	.114-.122	6.0	13.0
35068	22	.3	1.00-1.10	.039-.043	1.70-1.90	.066-.075	---	---	2.9-3.1	.114-.122	4.0	8.0

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

Mini-Mac Applicator 63801-9000				
Item	Order No	Engineering No.	Description	Quantity
Perishable Tooling				
	63801-9070	63801-9070	Tool Kit (All "Y" Items)	REF
1	63470-0010	63470-0010	Conductor Punch	1 Y
2	63801-9072	63801-9072	Conductor Anvil	1 Y
3	63471-0008	63471-0008	Insulation Punch	1 Y
4	63445-2988	63445-2988	Insulation Anvil	1 Y
5	63485-1118	63485-1118	Cut-off Punch	1 Y
6	63485-1318	63485-1318	Cut-off Die	1 Y
7	63485-1401	63485-1401	Cut-off Die Blade	1 Y
Other Components				
8	63443-0062	63443-0062	Collar-8.00mm Long	1
9	63485-1802	63485-1802	Hold-down Blade	1
10	63485-7602	63485-7602	Feed Finger	1
11	63600-1290	63600-1290	Washer	1
12	63700-4411	63700-4411	Compression Spring	1
13	63801-5013	63801-5013	Wire Stop	1
14	63801-7151	63801-7151	Terminal Track	1
15	63801-7152	63801-7152	Guide Rail	2
Frame				
16	63801-2600	63801-2600	Rear Feed Applicator Frame Head	REF
17	63801-2603	63801-2603	Base	REF
18	63801-7160	63801-7160	Terminal Drag Assembly	REF
Hardware				
19	N/A	N/A	M4 by 8 Long BHCS	1**
20	N/A	N/A	M4 by 16 Long BHCS	4**
21	N/A	N/A	M4 by 10 Long SHCS	2**
22	N/A	N/A	M4 by 35 Long SHCS	2**
23	N/A	N/A	M5 by 12 Long BHCS	2**
24	N/A	N/A	M6 by 10 Long BHCS	4**
25	N/A	N/A	M6 by 12 Long BHCS	2**
26	N/A	N/A	M8 by 20 Long BHCS	1**
27	N/A	N/A	6mm by 10 Long Dowel Pin	4**

** Available from an industrial supply company such as MSC (1-800-645-7270).

Assembly Drawing

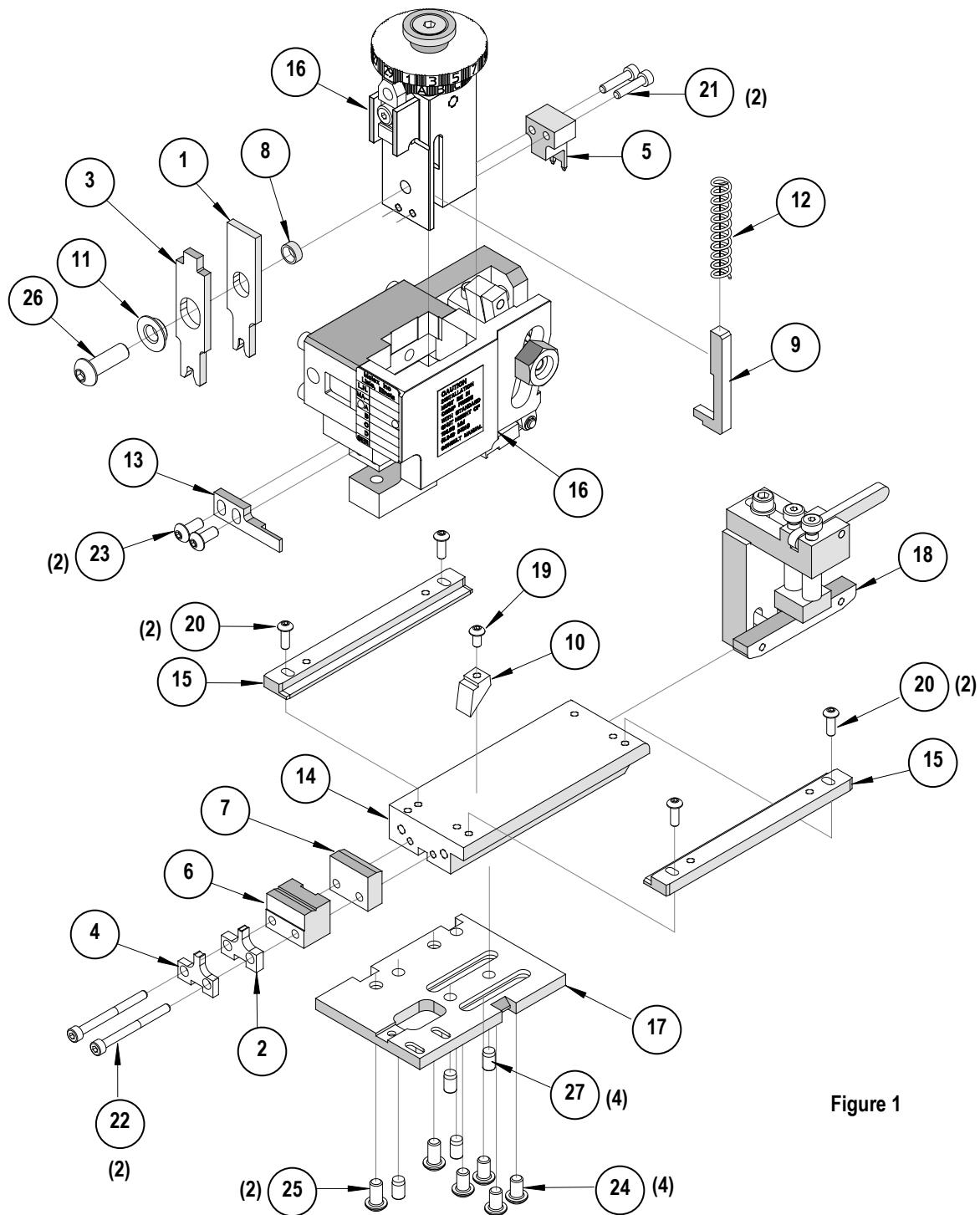


Figure 1

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 135.8 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.

Visit our Web site at <http://www.molex.com>