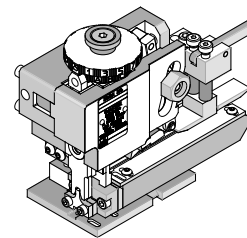


Rear Feed Mini-Mac Applicator

molex®

Application Tooling Specification Sheet


Order No. 63801-9000

FEATURES

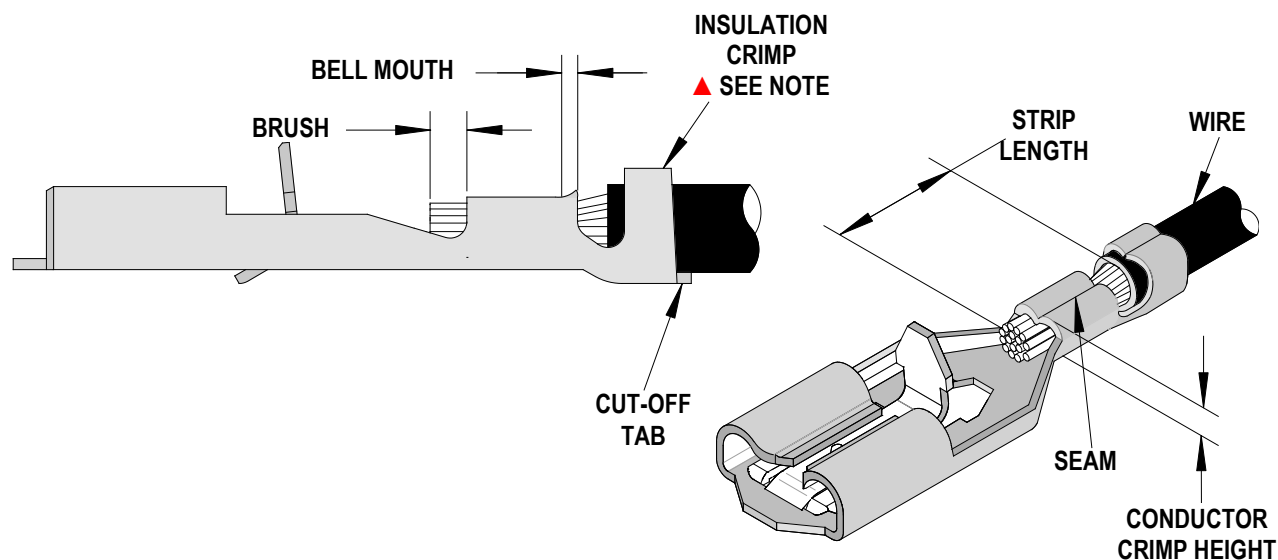
- Quick set-up time; plus the crimp height, track and feed adjustments can be preset in applicator
- Conductor and insulation rings allow quick adjustment for conductor and insulation diameter change
- Applicator designed to industry standard mounting and shut height 135.80mm (5.346")
- Directly adapts 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 | In | |
| 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 | |
|---------------------|-----------|-----------------|--------------|-----------|-------------|-----------|--------------|-----|-------------|-----------|--------------------|------|
| | AWG | mm ² | Crimp Height | | Crimp Width | | Crimp Height | | Crimp Width | | Kg | Lb. |
| | | | mm | In. | mm | In. | mm | In. | mm | In. | | |
| 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

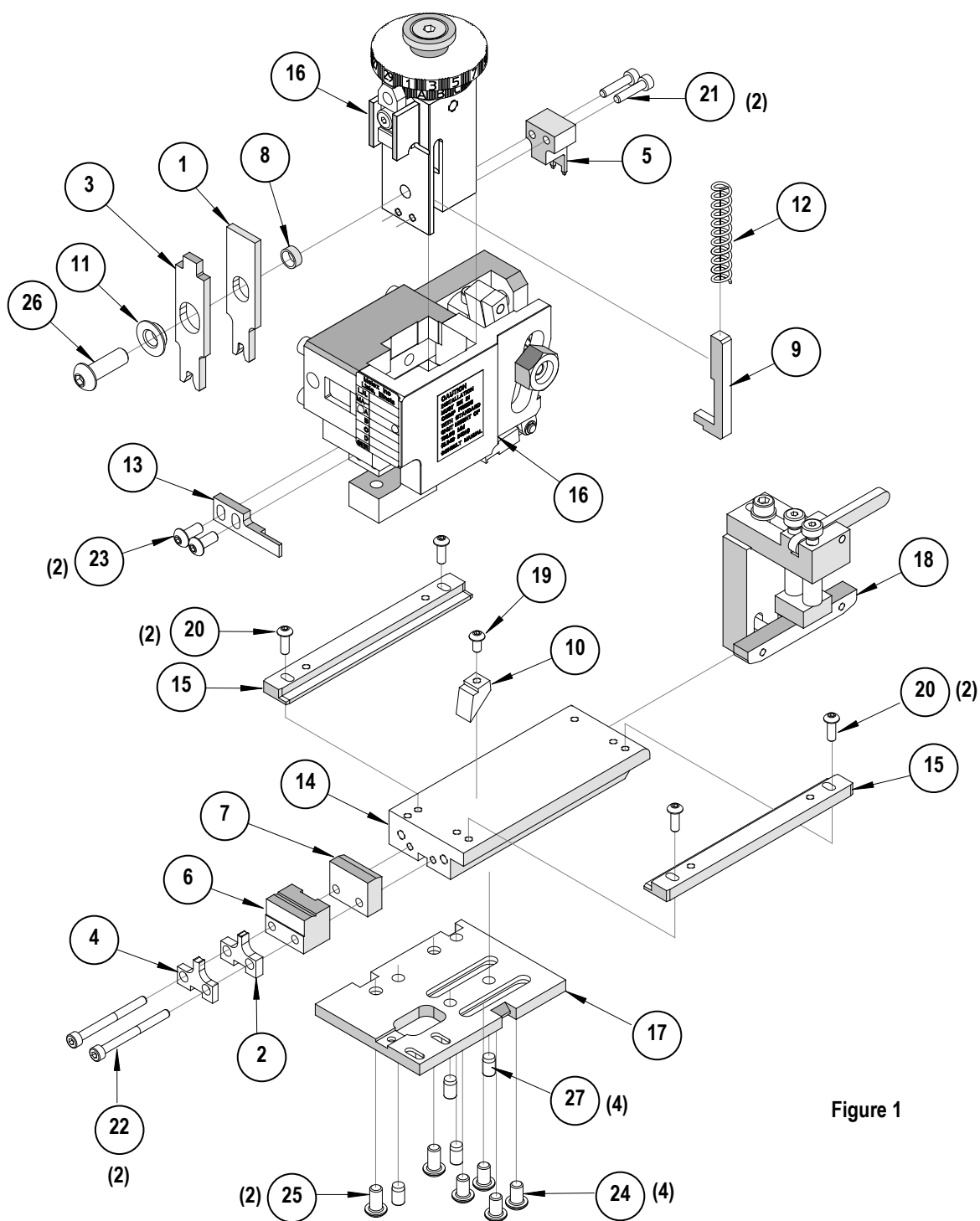


Figure 1

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.

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