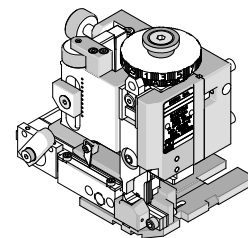


Order Number
63891-4000



Application Tooling Specification



FEATURES

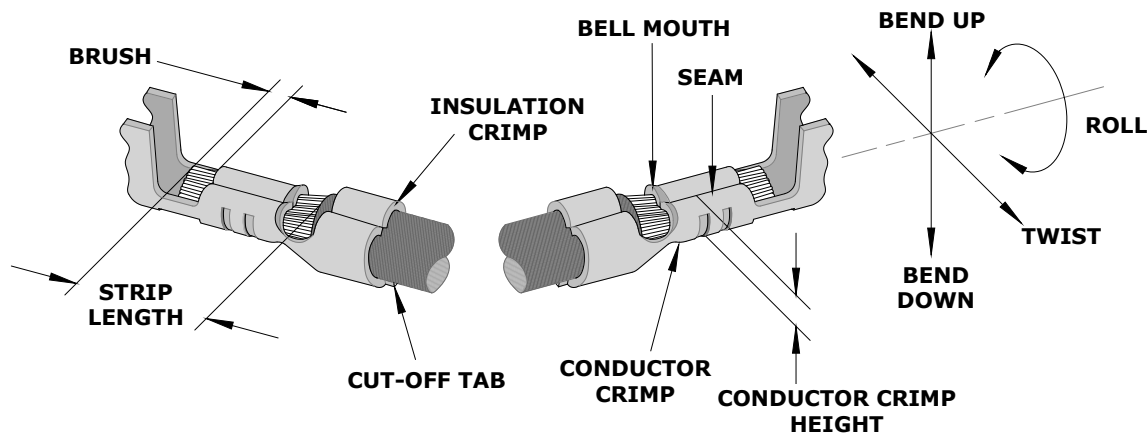
- Directly adapts to most automatic wire processing machines
- Applicator designed to industry standard mounting and shut height 135.80mm (5.346")
- Quick setup time; plus, the crimp height, track and feed adjustments can be set without removing the applicator from the press
- Fine adjustment allows users to achieve target with little effort by adjusting in increments of 0.015mm (.0006") for conductor crimp height and 0.063mm (.0025") for insulation height
- Independent adjustment rings allow users to quickly adjust the conductor or insulation crimp height without affecting each other

SCOPE

Products: 1.57mm (.062") Diameter, Standard .062" Pin and Socket Crimp Terminals, 18-24 AWG.

Terminal Series No.	Terminal Order No.			Wire Size		Insulation Diameter		Strip Length	
				AWG	mm ²	mm	In.	mm	In.
1560	02-06-2101	02-06-6116	39-00-0278	18-24	0.80-0.20	1.52-3.05	.060-.120	3.18-3.96	.125-.156
	02-06-6100	02-06-6118	39-00-0328						
	02-06-6101	04-01-0805	39-00-0329						
	02-06-6105								
1561	02-06-1101	02-06-5105	39-00-0279	18-24	0.80-0.20	1.52-3.05	.060-.120	3.18-3.96	.125-.156
	02-06-1118	02-06-5108	39-00-0332						
	02-06-5100	04-01-0806	39-00-0333						
	02-06-5101								
1786	02-06-2201	02-06-6205		18-24	0.80-0.20	1.52-3.05	.060-.120	3.18-3.96	.125-.156
	02-06-6201	02-06-6211							
1787	02-06-1201	02-06-5201		18-24	0.80-0.20	1.52-3.05	.060-.120	3.18-3.96	.125-.156
	02-06-3200	02-06-5205							
6770	02-06-5142			18-24	0.80-0.20	1.52-3.05	.060-.120	3.18-3.96	.125-.156
6772	02-06-6140			18-24	0.80-0.20	1.52-3.05	.060-.120	3.18-3.96	.125-.156
7291	02-06-1139			18-24	0.80-0.20	1.52-3.05	.060-.120	3.18-3.96	.125-.156

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.	Wire Size		Bell Mouth		Cut-Off Tab Maximum		Conductor Brush	
	AWG	mm ²	mm	In.	mm	In.	mm	In.
1560	18-24	0.80-0.20	0.10-0.60	.004-.024	0.13	.005	.25-1.00	.010-.039
1561	18-24	0.80-0.20	0.10-0.60	.004-.024	0.13	.005	.25-1.00	.010-.039
1786	18-24	0.80-0.20	0.10-0.60	.004-.024	0.13	.005	.25-1.00	.010-.039
1787	18-24	0.80-0.20	0.10-0.60	.004-.024	0.13	.005	.25-1.00	.010-.039
6770	18-24	0.80-0.20	0.10-0.60	.004-.024	0.13	.005	.25-1.00	.010-.039
6772	18-24	0.80-0.20	0.10-0.60	.004-.024	0.13	.005	.25-1.00	.010-.039
7291	18-24	0.80-0.20	0.10-0.60	.004-.024	0.13	.005	.25-1.00	.010-.039

Terminal Series No.	Wire Size		Bend Up	Bend Down	Twist	Roll	Punch Width mm (Ref)			
	AWG	mm ²	Degree		Degree		Conductor		Insulation	
1560	18-24	0.80-0.20	3	3	5	10	1.90	.075	2.83	.111
1561	18-24	0.80-0.20	3	3	5	10	1.90	.075	2.83	.111
1786	18-24	0.80-0.20	3	3	5	10	1.90	.075	2.83	.111
1787	18-24	0.80-0.20	3	3	5	10	1.90	.075	2.83	.111
6770	18-24	0.80-0.20	3	3	5	10	1.90	.075	2.83	.111
6772	18-24	0.80-0.20	3	3	5	10	1.90	.075	2.83	.111
7291	18-24	0.80-0.20	3	3	5	10	1.90	.075	2.83	.111
Seam Seam shall not be open and no wire allowed out of the crimping area. *18 AWG UL Style 1015 may have pinched strands or an open seam. This condition is normal and does not affect crimp performance. Customers should determine suitability for the end application.										

After crimping, the conductor profile should measure the following:

Terminal Series No.	Wire Size		Conductor				Pull Force Minimum	
			Crimp Height		Crimp Width			
	AWG	mm²	mm	In.	mm	In.	N	Lb.
1560	18	0.80	1.04-1.07	.041-.042	1.90-2.00	.075-.079	89.0	20.00
	20	0.50	0.96-1.02	.038-.040	1.90-2.00	.075-.079	66.7	15.00
	22	0.35	0.91-0.96	.036-.038	1.90-2.00	.075-.079	44.5	10.00
	24	0.20	0.86-0.91	.034-.036	1.90-2.00	.075-.079	35.6	8.00
1561	18	0.80	1.04-1.07	.041-.042	1.90-2.00	.075-.079	89.0	20.00
	20	0.50	0.96-1.02	.038-.040	1.90-2.00	.075-.079	66.7	15.00
	22	0.35	0.91-0.96	.036-.038	1.90-2.00	.075-.079	44.5	10.00
	24	0.20	0.86-0.91	.034-.036	1.90-2.00	.075-.079	35.6	8.00
1786	18	0.80	1.04-1.07	.041-.042	1.90-2.00	.075-.079	89.0	20.00
	20	0.50	0.96-1.02	.038-.040	1.90-2.00	.075-.079	66.7	15.00
	22	0.35	0.91-0.96	.036-.038	1.90-2.00	.075-.079	44.5	10.00
	24	0.20	0.86-0.91	.034-.036	1.90-2.00	.075-.079	35.6	8.00
1787	18	0.80	1.04-1.07	.041-.042	1.90-2.00	.075-.079	89.0	20.00
	20	0.50	0.96-1.02	.038-.040	1.90-2.00	.075-.079	66.7	15.00
	22	0.35	0.91-0.96	.036-.038	1.90-2.00	.075-.079	44.5	10.00
	24	0.20	0.86-0.91	.034-.036	1.90-2.00	.075-.079	35.6	8.00
6770	18	0.80	1.04-1.07	.041-.042	1.90-2.00	.075-.079	89.0	20.00
	20	0.50	0.96-1.02	.038-.040	1.90-2.00	.075-.079	66.7	15.00
	22	0.35	0.91-0.96	.036-.038	1.90-2.00	.075-.079	44.5	10.00
	24	0.20	0.86-0.91	.034-.036	1.90-2.00	.075-.079	35.6	8.00
6772	18	0.80	1.04-1.07	.041-.042	1.90-2.00	.075-.079	89.0	20.00
	20	0.50	0.96-1.02	.038-.040	1.90-2.00	.075-.079	66.7	15.00
	22	0.35	0.91-0.96	.036-.038	1.90-2.00	.075-.079	44.5	10.00
	24	0.20	0.86-0.91	.034-.036	1.90-2.00	.075-.079	35.6	8.00
7291	18	0.80	1.04-1.07	.041-.042	1.90-2.00	.075-.079	89.0	20.00
	20	0.50	0.96-1.02	.038-.040	1.90-2.00	.075-.079	66.7	15.00
	22	0.35	0.91-0.96	.036-.038	1.90-2.00	.075-.079	44.5	10.00
	24	0.20	0.86-0.91	.034-.036	1.90-2.00	.075-.079	35.6	8.00

Tool Qualification Notes

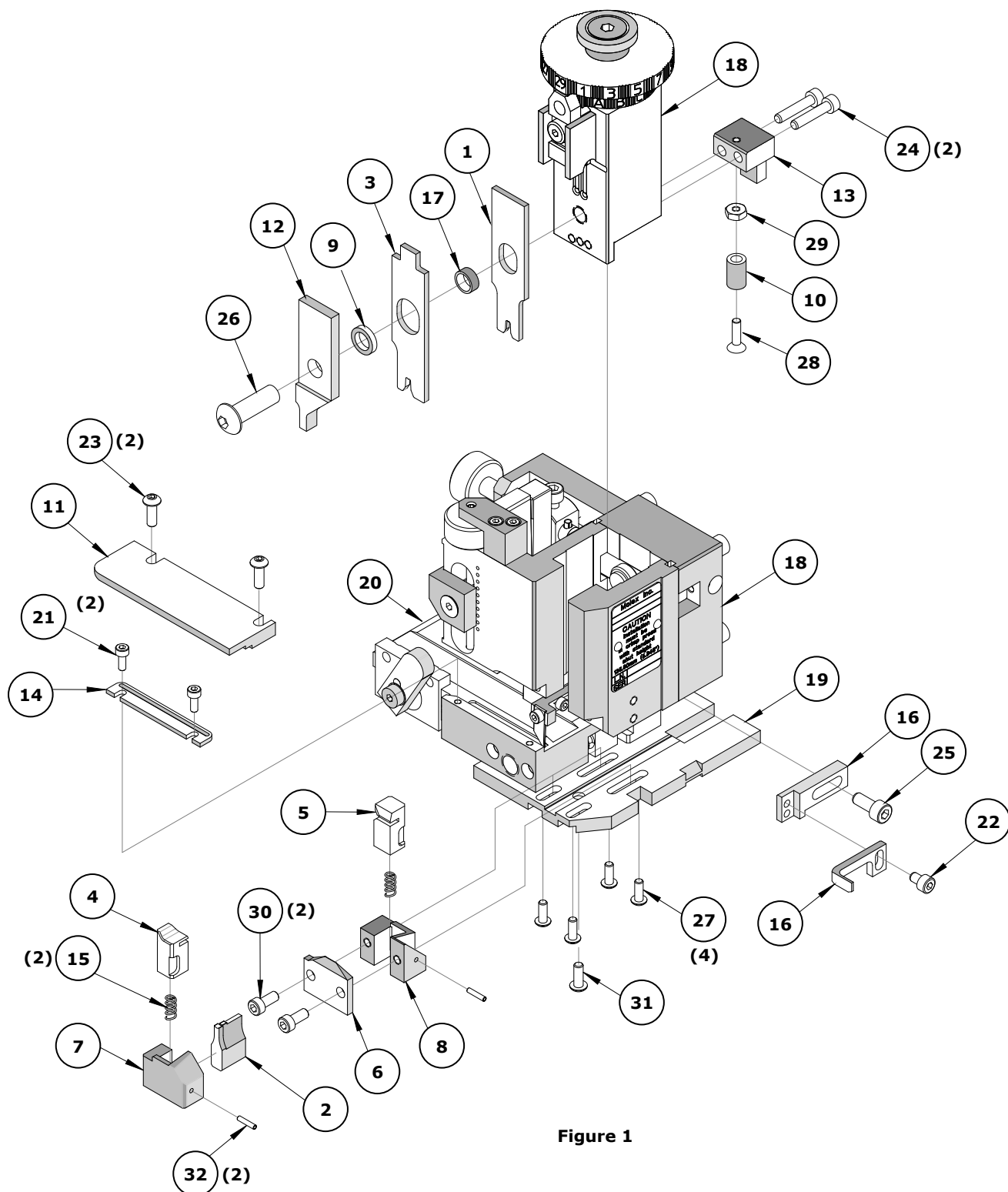
1. Pull force should be measured with no influence from the insulation crimp.
2. The above specifications are guidelines to an optimum crimp.

PARTS LIST

Mini-Mac Applicator 63891-4000				
Item	Order No.	Engineering No.	Description	Quantity
Perishable Tooling				
	63891-4070	63891-4070	Tool Kit (All “Y” Items)	REF
1	63891-4001	63891-4001	Conductor Punch	1 Y
2	11-18-4078	60707-3	Combination Anvil	1 Y
3	11-18-4077	60707-2	Insulation Punch	1 Y
4	11-17-3076	7163-30	Front Cut-Off Plunger	1 Y
5	11-17-3079	7163-33	Rear Cut-Off Plunger	1 Y
6	11-17-2136	7163-4	Rear Cut-Off Die Blade	1 Y
7	11-18-4246	60707-18	Front Cut-off Plunger Retainer	1 Y
8	11-18-4247	60707-19	Rear Cut-off Plunger Retainer	1 Y
Other Components				
9	11-17-2140	7163-8	Insulation Punch Spacer	1
10	11-17-2152	7163-14	Hold Down Pad	1
11	11-18-4079	60707-4	Cover Plate	1
12	11-18-4081	60707-6	Front Plunger Striker	1
13	11-18-4082	60707-7	Rear Plunger Striker	1
14	11-18-4083	60707-8	Feed Guide	1
15	11-18-5060	60707-21	Cut-Off Plunger Spring	2
16	63443-0090	63443-0090	Wire Stop	1
17	63803-5124	63803-5124	Conductor Bushing	1
Frame				
18	63801-3201	63801-3201	Top	1
19	63801-3282	63801-3282	Base	1
20	63801-6550	63801-6550	Track	1
Hardware				
21	—	—	M3 by 8 Long SHCS	2*
22	—	—	M4 by 6 Long SHCS	1*
23	—	—	M4 by 12 Long BHCS	2*
24	—	—	M4 by 20 Long SHCS	2*
25	—	—	M5 by 14 Long SHCS	1*
26	—	—	M8 by 20 Long BHCS	1*
27	—	—	#6-32 by 3/8” Long BHCS	4*
28	—	—	#6-32 by 1/2” Long FHCS	1*
29	—	—	#6-32 Hex Jam Nut	1*
30	—	—	#8-32 by 1/4” Long SHCS	2*
31	—	—	#8-32 by 3/8” Long BHCS	1*
32	—	—	5/64 by 3/8” Long Roll Pin	2*

* Available from an industrial supply company.

ASSEMBLY DRAWING



NOTES

1. Molex recommends that 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 the 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 135.8mm (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.

Application Tooling Support

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E-Mail: applicationtooling@molex.com
Website: www.molex.com/applicationtooling

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