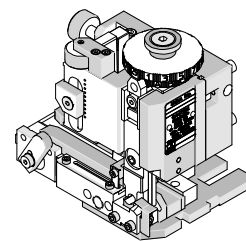


Mini-Mac Applicator Metal Strip

molex

Application Tooling Specification Sheet


Order No. 63895-4100

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.

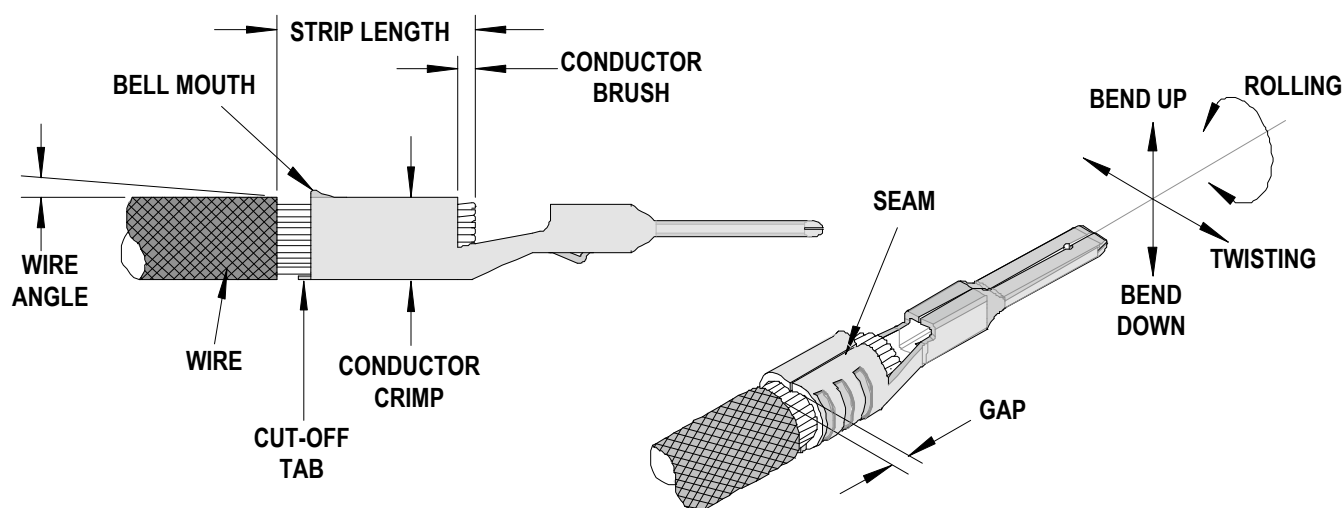
SCOPE

Products: SRC Connector using MX150L Blade Terminals, 8.0mm² FLRY-B wire.

Terminal Series No.	Terminal Order No.	Wire Size		Insulation Diameter		Strip Length	
		Wire Type	mm ²	mm	In.	mm	In.
19431	19431-0015	FLRY-B	8.0	5.20-5.60	.205-.220	5.50-6.00	.217-.236

Terminals were validated using the following wire specifications: ISO 6722-1, Class B

DEFINITION OF TERMS



CRIMP SPECIFICATION

Terminal Series No.	Bell mouth		Cut-off Tab Maximum		Conductor Brush		Gap (Max)	
	mm	In.	mm	In.	mm	In.	mm	In.
19431	0.25-1.25	.010-.049	0.50	.020	0.10-0.50	.004-.020	1.20	.047

Terminal Series No.	Bend up Bend down		Twist Roll		Punch Width (Ref)				Wire Angle	Conductor Seam Seam shall not be open and no wire allowed out of the crimping area
	Degree		Degree		Conductor		Insulation			
					mm	In	mm	In	Degree	
19431	2	3	4	8	4.80	.189	N/A	N/A	5° Max	

After crimping, the crimp profiles should measure the following.

Terminal Series No.	Wire Size		Conductor				Insulation				Pull Force Minimum	
			Crimp Height		Crimp Width		Crimp Height		Crimp Width			
	Wire Type	mm ²	mm	In.	mm	In.	mm	In.	mm	In.	N	Lb.
19431	FLRY-B	8.0	2.60-2.75	.102-.108	4.70-4.90	.185-.193	N/A	N/A	N/A	N/A	350	78.8

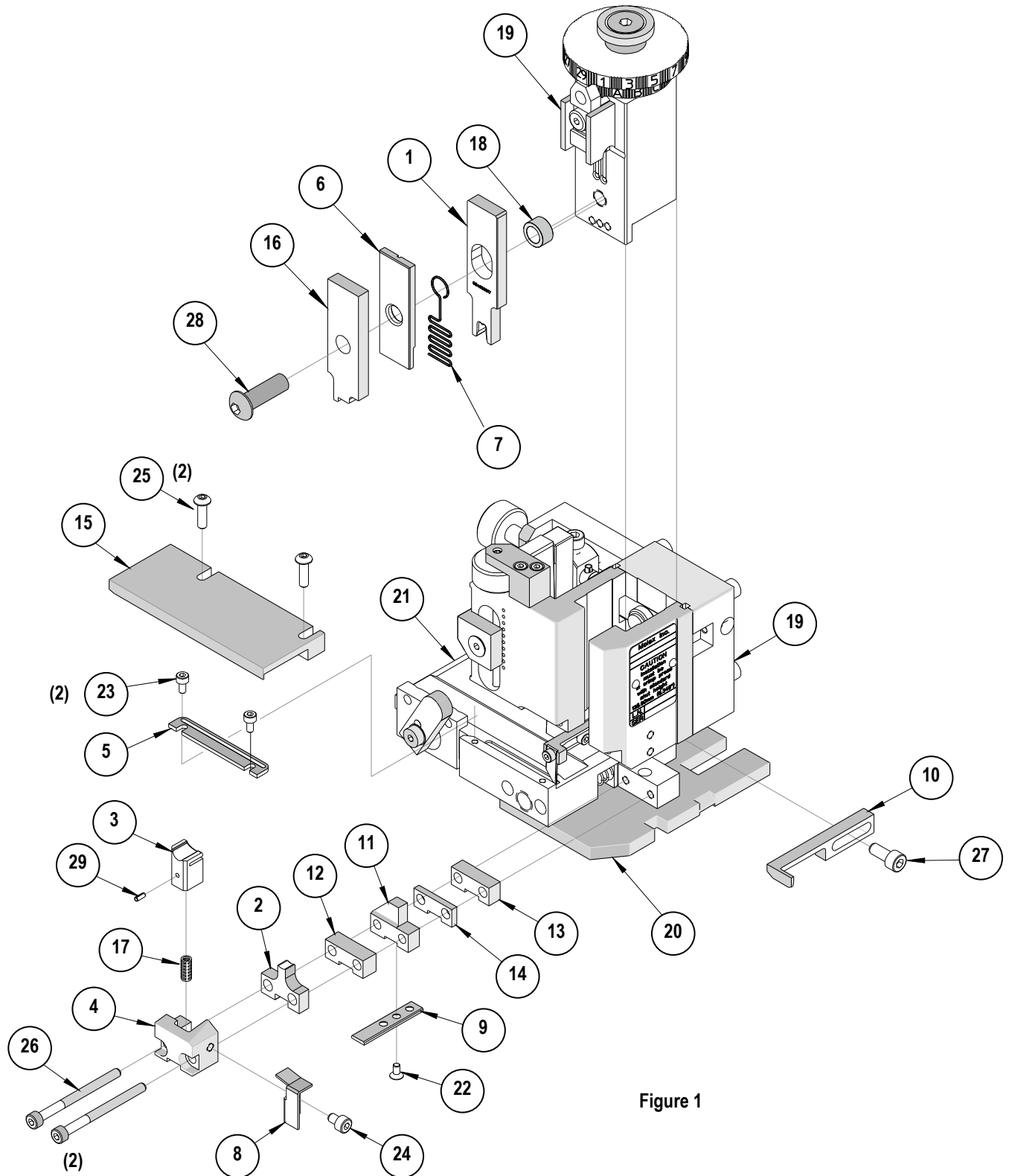
Tool Qualification Notes:

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 63895-4100				
Item	Order No	Engineering No.	Description	Quantity
Perishable Tooling				
	63895-4170	63895-4170	Tool Kit (All "Y" Items)	REF
1	63465-0017	63465-0017	Conductor Punch	1 Y
2	63455-4801	63455-4801	Conductor Anvil	1 Y
3	63443-0037	63443-0037	Cut-off Plunger Front	1 Y
4	63443-0038	63443-0038	Plunger Retainer Front	1 Y
Other Components				
5	11-18-4083	60707-8	Feed Guide	1
6	11-18-4848	60800A123	Wire Hold Down Cover	1
7	11-18-4849	60800A124	Wire Hold Down Spring	1
8	63443-0009	63443-0009	Scrap Chute Front	1
9	63443-0024	63443-0024	Key	1
10	63443-0061	63443-0061	Wire Stop	1
11	63443-1728	63443-1728	Height Spacer (19.80mm)	1
12	63443-2207	63443-2207	Course Spacer (7.00mm)	1
13	63443-2208	63443-2208	Course Spacer (8.00mm)	1
14	63443-2302	63443-2302	Fine Spacer (3.10mm)	1
15	63443-6140	63443-6140	Rear Cover	1
16	63466-0504	63466-0504	Cut-off Plunger Striker Front	1
17	63700-0539	63700-0539	Cut-Off Plunger Spring	1
18	63890-0866	63890-0866	Collar-6.40 Long	2
Frame				
19	63801-3201	63801-3201	Top	1
20	63801-3281	63801-3281	Base	1
21	63801-4650	63801-4650	Track	1
Hardware				
22	N/A	N/A	M3 by 6 Long FHCS	1**
23	N/A	N/A	M3 by 6 Long SHCS	2**
24	N/A	N/A	M4 by 6 Long SHCS	1**
25	N/A	N/A	M4 by 12 Long BHCS	2**
26	N/A	N/A	M4 by 50 Long SHCS	2**
27	N/A	N/A	M5 by 12 Long SHCS	1**
28	N/A	N/A	M8 by 30 Long BHCS	1**
29	N/A	N/A	2mm by 5 Long Roll Pin	1**
** Available from an industrial supply company such as MSC (1-800-645-7270).				

Assembly Drawing



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 Applicator Manual (Document no. 63880-0000).

CAUTION: This applicator must only be used in a press with a shut height of 135.80 mm (5.346"). Tooling damage could result at a lower shut height.

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

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