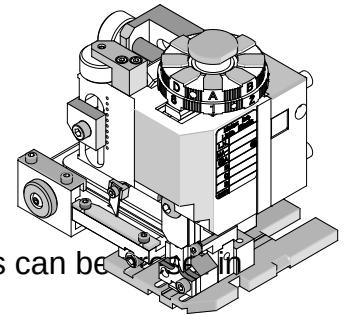




Mini-Mac Applicator Specification Sheet Part No. 11-18-2236 Eng No. MA60803E



FEATURES

- Quick set-up time; plus the crimp height, track and feed adjustments can be made on the 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

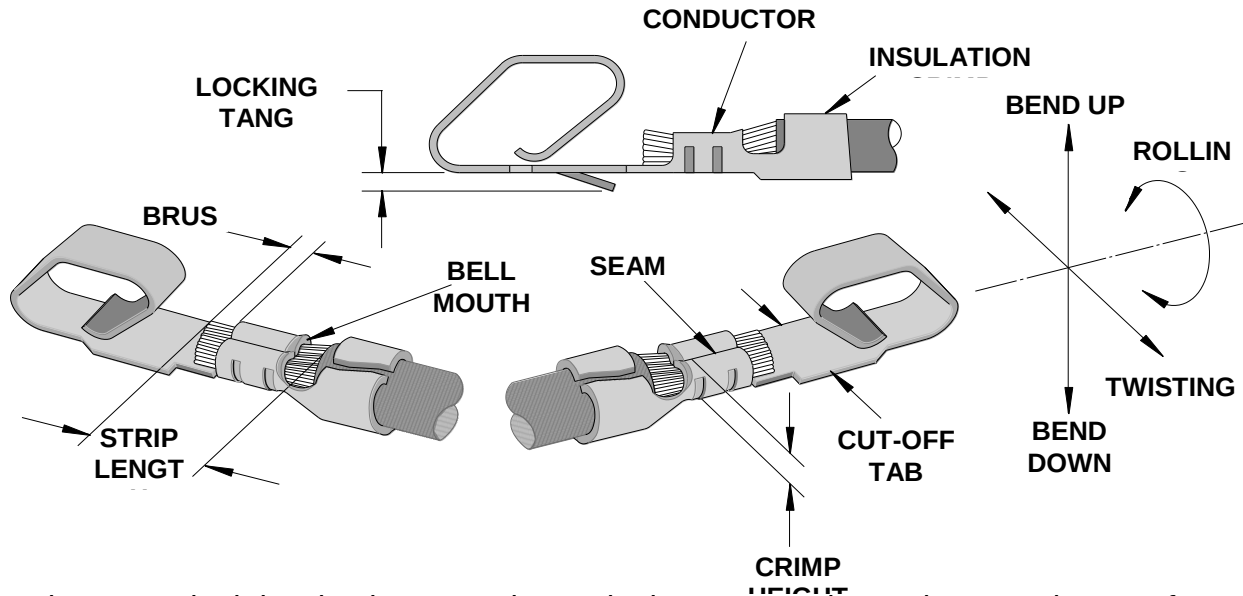
Products: KK® and Trifurcon™, 3.96mm (.156") Pitch Crimp Terminal, 18-24 AWG.

Terminal Series No.	Terminal Order No.			Wire Size		Insulation Diameter		Strip Length	
				AWG	mm ²	mm	In.	mm	In.
2477	08-50-0109	08-56-0113	40-01-1179	18 - 24	0.80-0.20	2.79	.110	2.54-3.18	.100-.125
2478	08-50-0001	08-52-0027	08-58-0114	18 - 24	0.80-0.20	2.79	.110	2.54-3.18	.100-.125
	08-50-0014	08-52-0044	08-58-0121						
	08-50-0015	08-52-0046	08-65-0114						
	08-50-0047	08-52-0071	39-00-0103						
	08-50-0063	08-52-0073	39-00-0133						
	08-50-0073	08-52-0114	39-00-0286						
	08-50-0091	08-52-0811	39-00-0343						
	08-50-0105	08-53-0004	39-00-0345						
	08-50-0119	08-53-0811	39-00-0347						
	08-50-0146	08-55-0103	39-00-0349						
	08-50-0271	08-55-0133	40-01-1118						
	08-50-0281	08-56-0105	50-29-1689						
	08-51-0001	08-56-0153	50-29-1768						
	08-52-0023	08-58-0103							
2878	08-50-0115	08-53-0814	08-65-0118	18 - 20	0.80-0.50	2.79	.110	2.54-3.18	.100-.125
	08-51-0109	08-55-0138							

Mini-Mac Applicator "KK" Terminals

	08-52-0126	08-58-0127							
4838	08-50-0131	08-55-0142	08-55-0147	18 - 22	0.80-0.35	2.41	.095	2.54-3.18	.100-.125
	08-55-0125	08-55-0144	08-55-0149						
	08-55-0139	08-55-0145							
6438	08-50-0164	08-52-0813	08-56-0135	18 - 24	0.80-0.20	2.41	.095	2.54-3.18	.100-.125
	08-51-0801	05-53-0813	08-56-0137						
6379	08-52-0101			18 - 24	0.80-0.20	2.79	.110	2.54-3.18	.100-.125
8993	08-50-0111	08-50-0277		18 - 24	0.80-0.20	2.79	.110	2.54-3.18	.100-.125
6838	08-50-0024	08-52-0112	08-58-0118	18 - 20	0.80-0.50	2.79	.110	2.54-3.18	.100-.125
	08-50-0026	08-53-1101	08-58-0131						
	08-50-0028	08-58-0102	08-58-0187						
	08-50-0187	08-58-0105	08-60-0001						
	08-50-0275	08-58-0108							
	08-51-0106	08-58-0110							

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.	Bell mouth		Cut-off Tab		Conductor Brush	
	mm	In.	mm	In.	mm	In.
2477	0.20-0.50	.008-.020	2.72±.13	.107±.005	0.13-0.64	.005-.025
2478	0.20-0.50	.008-.020	2.72±.13	.107±.005	0.13-0.64	.005-.025
2878	0.20-0.50	.008-.020	2.72±.13	.107±.005	0.13-0.64	.005-.025
4838	0.20-0.50	.008-.020	2.72±.13	.107±.005	0.13-0.64	.005-.025
6438	0.20-0.50	.008-.020	2.72±.13	.107±.005	0.13-0.64	.005-.025
6379	0.20-0.50	.008-.020	2.72±.13	.107±.005	0.13-0.64	.005-.025
8993	0.20-0.50	.008-.020	2.72±.13	.107±.005	0.13-0.64	.005-.025
6838	0.20-0.50	.008-.020	2.72±.13	.107±.005	0.13-0.64	.005-.025

Terminal Series No.	Locking Tang Height		Bend up Bend down		Twist Roll		Punch Width (Ref)				Seam
	mm	In	Degree		Degree		Conductor		Insulation		
							mm	In	mm	In	
2477	0.57±.13	.022±.005	3	3	4	8	2.00	.079	2.50	.098	Seam shall not be open and no wire allowed out of the crimping area
2478	0.57±.13	.022±.005	3	3	4	8	2.00	.079	2.50	.098	
2878	0.57±.13	.022±.005	3	3	4	8	2.00	.079	2.50	.098	
4838	0.57±.13	.022±.005	3	3	4	8	2.00	.079	2.50	.098	
6438	0.57±.13	.022±.005	3	3	4	8	2.00	.079	2.50	.098	
6879	0.57±.13	.022±.005	3	3	4	8	2.00	.079	2.50	.098	
8993	0.57±.13	.022±.005	3	3	4	8	2.00	.079	2.50	.098	
6838	0.57±.13	.022±.005	3	3	4	8	2.00	.079	2.50	.098	

After crimping, the conductor profile should measure the following.

Terminal Series No.	Wire Size		Crimp Height		Pull Force Min.	
	AWG	mm ²	mm	In.	N	Lb.
2477	18	0.80	1.09-1.14	.043-.045	110	25
2477	20	0.50	1.02-1.09	.040-.043	66	15
2477	22	0.35	0.97-1.02	.038-.040	44	10
2477	24	0.20	0.91-0.97	.036-.038	35	8
2478	18	0.80	1.09-1.14	.043-.045	110	25
* 08-52-0071	18	0.81	1.07-1.17	.042-.046	110	25
2478	20	0.50	1.02-1.09	.040-.043	66	15
2478	22	0.35	0.97-1.02	.038-.040	44	10
2478	24	0.20	0.91-0.97	.036-.038	35	8
2878	18	0.80	1.09-1.14	.043-.045	110	25
2878	20	0.50	1.02-1.09	.040-.043	66	15
4838	18	0.80	1.09-1.14	.043-.045	110	25
4838	20	0.50	1.02-1.09	.040-.043	66	15
4838	22	0.35	0.97-1.02	.038-.040	44	10
6438	18	0.80	1.09-1.14	.043-.045	110	25
6438	20	0.50	1.02-1.09	.040-.043	66	15
6438	22	0.35	0.97-1.02	.038-.040	44	10
6438	24	0.20	0.91-0.97	.036-.038	35	8
6379	18	0.80	1.09-1.14	.043-.045	110	25
6379	20	0.50	1.02-1.09	.040-.043	66	15
6379	22	0.35	0.97-1.02	.038-.040	44	10
6379	24	0.20	0.91-0.97	.036-.038	35	8
8993	18	0.80	1.09-1.14	.043-.045	110	25
8993	20	0.50	1.02-1.09	.040-.043	66	15
8993	22	0.35	0.97-1.02	.038-.040	44	10
8993	24	0.20	0.91-0.97	.036-.038	35	8
6838	18	0.80	1.09-1.14	.043-.045	110	25
6838	20	0.50	1.02-1.09	.040-.043	66	15

* Special for use with 18 AWG UL1015, 16 strand (.010") diameter wire only.
0.81mm² .254mm

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

PARTS LIST

Mini-Mac Applicator MA60703E (11-18-2236)				
Item	Order No	Engineering No.	Description	Quantity
Perishable Tooling				
	11-18-3228	K60703E	Tool Kit (All "Y" Items)	REF
1	11-18-5465	60803E101	Conductor Punch	1 Y
2	63445-2043	63445-2043	Conductor Anvil	1 Y
3	11-18-5383	60712G103	Insulation Punch	1 Y
4	63445-2535	63445-2535	Insulation Anvil	1 Y
5	11-18-5384	60712G105	Cut-Off Punch	1 Y
6	63820-0006	63820-0006	Cut-off Die	1 Y
Other Components				
7	11-18-4103	60712-3	Cover Plate	1
8	11-18-5015	60805A122	Front Cover	1
9	11-18-5116	60804A141	Compression Springs	2
10	11-18-5380	60712G124	Tooling Washer	1
11	11-18-5381	60712G127	Mounting Block	1
12	11-18-5397	60803B123	Spring Cover	1
13	63820-0013	63820-0013	Terminal Ramp	1
14	63820-0014	63820-0014	Anvil Mount Block	1
15	63820-0016	63820-0016	Pivot Pin	1
16	63820-0017	63820-0017	Mounting Key	1
17	63820-0018	63820-0018	Wire Stop Mounting Block	1
18	63820-0019	63820-0019	Wire Stop	1
19	63820-0022	63820-0022	Knock-Out Blade	1
Frame				
20	63800-0100	63800-0100	Mini-Mac Applicator Frame	1
21	11-17-1174	4151-21	Terminal Drag Plate Frame	1
22	11-18-4257	60712-2	Terminator Track	1
23	11-18-4978	60805A105	Conductor Cam	1
24	11-18-5385	60712G151	Ram	1
25	11-18-5392	60803B103	Base Plate	1
26	63800-0115	63800-0115	Spacer Tube	1
27	63800-0313	63800-0313	Drag Cam	1
28	63820-0012	63820-0012	Terminal Drag Plate	1
Hardware				
29	N/A	N/A	M3 by 6 Lg. SHCS	2**
30	N/A	N/A	M4 by 8 Lg. BHCS	1**
31	N/A	N/A	M4 by 12 Lg. BHCS	2**
32	N/A	N/A	M4 by 12 Lg. SHCS	2**
33	N/A	N/A	M4 by 16 Lg. SHCS	1**
34	N/A	N/A	M4 by 25 Lg. SHCS	1**
35	N/A	N/A	4mm by 10.0 Lg. Dowel Pin	2**
36	N/A	N/A	#6-32 by 3/16" Lg. SHCS	2**
37	N/A	N/A	M2.5 by 5 Lg. SHCS	2**
38	N/A	N/A	M8 by 20 Lg. BHCS	1**
** Available from an industrial supply company such as MSC (1-800-645-7270).				

Assembly Drawing

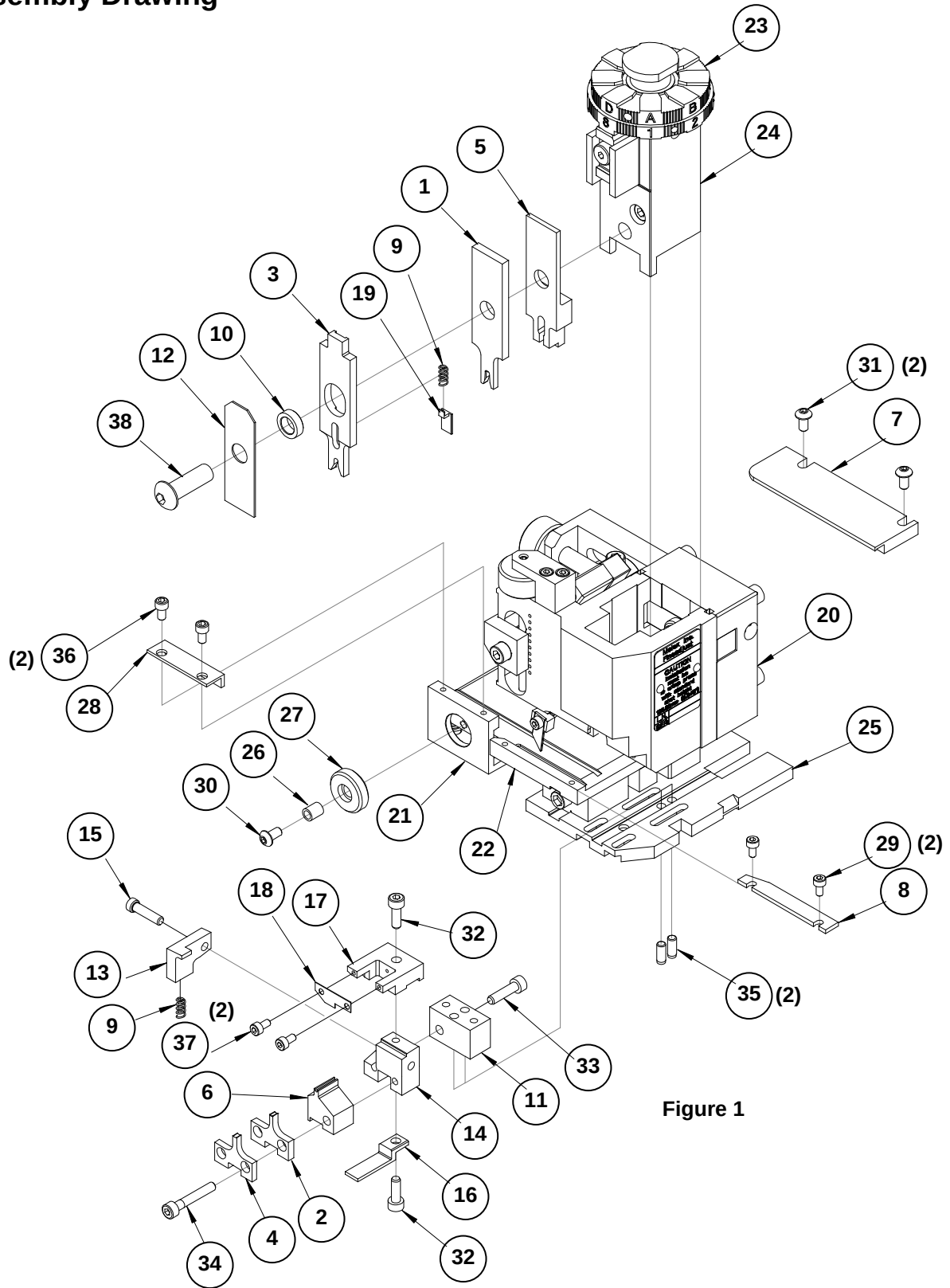


Figure 1

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 MiniMac 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.

Molex Application Tooling Group

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