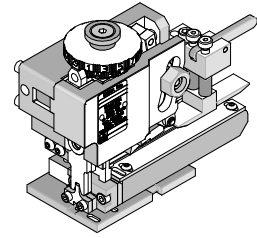


**Mini-Mac
Applicator
Rear Feed**



**Application Tooling
Specification Sheet**



Order No. 63806-2300

FEATURES

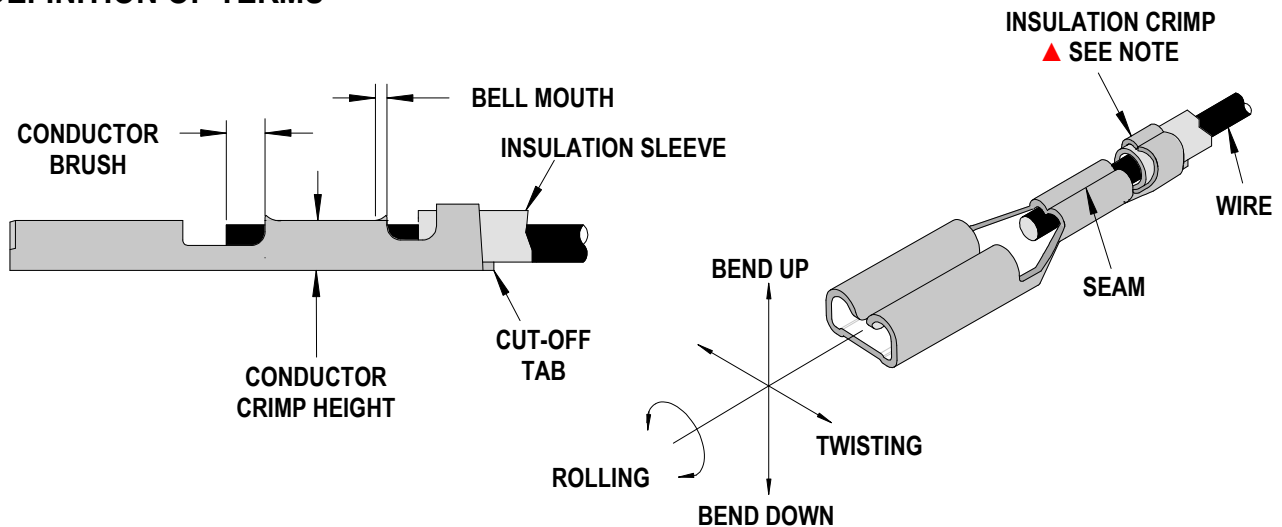
- Quick set-up time; plus the crimp height, track and feed adjustments can be preset in applicator
- Conductor and insulation rings allow quick adjustment for conductor and insulation diameter change
- Applicator designed to industry standard mounting and shut height 135.80mm (5.346")
- Directly adapts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

SCOPE

Products: .110 Receptacle Terminals, 19.0-25.5 AWG Magnet Wires.

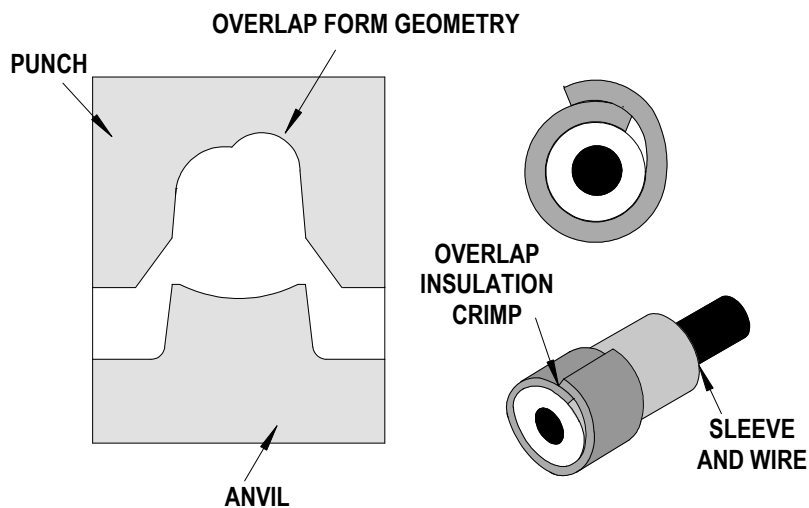
Terminal Series No.	Terminal Order No.	Magnet Wire Size and Type				
		AWG	Bare Wire		Insulated	
			Diameter (mm Approximately)	CMA	Diameter (mm Approximately)	CMA
49748	49748-9001	19.0	0.912	1289	0.970	1459
		20.5	0.767	912	0.823	1050
		22.0	0.643	640	0.693	745
		22.5	0.607	571	0.658	671
		23.5	0.541	454	0.589	538
		25.0	0.455	320	0.500	388
		25.5	0.429	286	0.475	350

DEFINITION OF TERMS



▲ Insulation Crimp Note:

Due to the terminal's insulation grip design and/or insulation diameter range, this tool uses "overlap" form geometry in the insulation punch. This produces an overlap insulation crimp. While the insulation punch profile may appear "lopsided", this is a normal condition for this tool. See figure to the right.



CRIMP SPECIFICATIONS

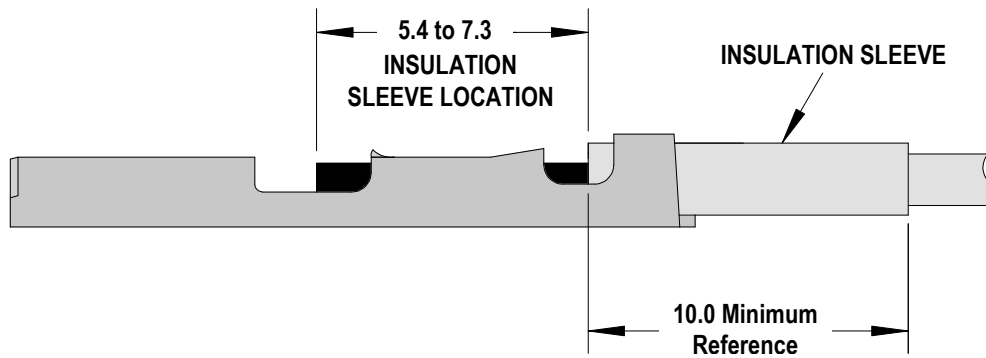
Terminal Series No.	Bell mouth		Cut-off Tab Maximum		Conductor Brush	
	mm	In.	mm	In.	mm	In.
49748	0.30-0.80	.012-.031	0.50	.020	0.50-1.80	.020-.071

Terminal Series No.	Bend up	Bend down	Twist	Roll	Punch Width (Ref)				Seam Seam shall not be open and no wire allowed out of the crimping area
					Conductor		Insulation		
	Degree	Degree	mm	In	mm	In			
49748	5	5	3	5	1.80	.071	2.60	.102	

After crimping, the crimp profiles should measure the following:

Terminal Series No.	Wire Size AWG	Conductor Crimp				Insulation Crimp				Pull Force Minimum	
		Height		Width		Height		Width		N	Lb.
		mm	In.	mm	In.	mm	In.	mm	In.		
49748	19.0	1.13-1.17	.044-.046	1.82-1.88	.072-.074	2.00-2.10	.079-.083	2.60-2.70	.102-.106	103.0	23.2
	20.5	1.06-1.10	.042-.043			2.00-2.10	.079-.083			94.1	21.2
	22.0	1.04-1.08	.041-.043			1.55-1.95	.061-.077			53.9	12.1
	22.5	1.00-1.04	.039-.041			1.55-1.95	.061-.077			44.1	9.9
	23.5	0.98-1.02	.039-.040			1.55-1.95	.061-.077			37.3	8.4
	25.0	0.93-0.97	.037-.038			1.55-1.95	.061-.077			24.5	5.5
	25.5	0.88-0.92	.035-.036			1.55-1.95	.061-.077			19.6	4.4

Terminal Series No.	Wire Size AWG	Material	Insulation Sleeve			
			Diameter (Ref)		Length (Ref)	
	mm		In.	mm	In.	
49748	19.0	Teflon Tubing TFS-19 ~ 21	0.970	.038	10.0 Min	.394 Min.
	20.5		0.823	.032		
	22.0		0.693	.027		
	22.5		0.658	.026		
	23.5		0.589	.023		
	25.0		0.500	.020		
	25.5		0.475	.019		



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.
3. Insulation tube should not come out of crimped terminal and Insulation crimp must provide strain relief.

PARTS LIST

Mini-Mac Applicator 63806-2300				
Item	Order No.	Engineering No.	Description	Quantity
Perishable Tooling				
	63806-2370	63806-2370	Tool Kit (All "Y" Items)	REF
1	63806-2301	63806-2301	Conductor Punch	1 Y
2	63455-0112	63455-0112	Conductor Anvil	1 Y
3	63806-2303	63806-2303	Insulation Punch	1 Y
4	63445-2673	63445-2673	Insulation Anvil	1 Y
5	11-18-4398	60729-3	Die Cut-off Blade-Rear	1 Y
6	63470-0023	63470-0023	Die Cut-off Blade-Front	1 Y
7	63470-0024	63470-0024	Cut-off Blade	1 Y
Other Components				
8	63470-0019	63470-0019	Tooling Washer	1
9	63470-0026	63470-0026	Spacer for Cut-off Blade	1
10	63700-4411	63700-4411	Compression Spring	1
11	63801-7151	63801-7151	Terminal Track	1
12	63803-5139	63803-5139	Conductor Bushing	1
13	63806-2304	63806-2304	Wire Stop	1
14	63806-2305	63806-2305	Hold Down Blade	1
15	63806-2306	63806-2306	Terminal Straightener	1
16	63806-2307	63806-2307	Feed Finger	1
17	63806-2308	63806-2308	Guide	2
Frame				
18	63801-2600	63801-2600	Rear Feed Applicator Frame Head	1
19	63801-2603	63801-2603	Base	1
20	63801-7160	63801-7160	Terminal Drag Assembly	1
Hardware				
21	N/A	N/A	M4 by 8 Long BHCS	3**
22	N/A	N/A	M4 by 12 Long BHCS	1**
23	N/A	N/A	M4 by 10 Long SHCS	2**
24	N/A	N/A	M4 by 16 Long SHCS	2**
25	N/A	N/A	M5 by 12 Long BHCS	2**
26	N/A	N/A	M5 by 20 Long SHCS	2**
27	N/A	N/A	M6 by 10 Long BHCS	4**
28	N/A	N/A	M8 by 20 Long BHCS	1**
29	N/A	N/A	4mm by 8 Long Dowel Pin	1**
** Available from an industrial supply company such as MSC (1-800-645-7270).				

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 135.8mm (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.

<http://www.molex.com>