

**Mini-Mac Applicator
Mechanical Feed
Metal Strip**

**Application Tooling
Specification Sheet**

Order No. 63895-3100

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.

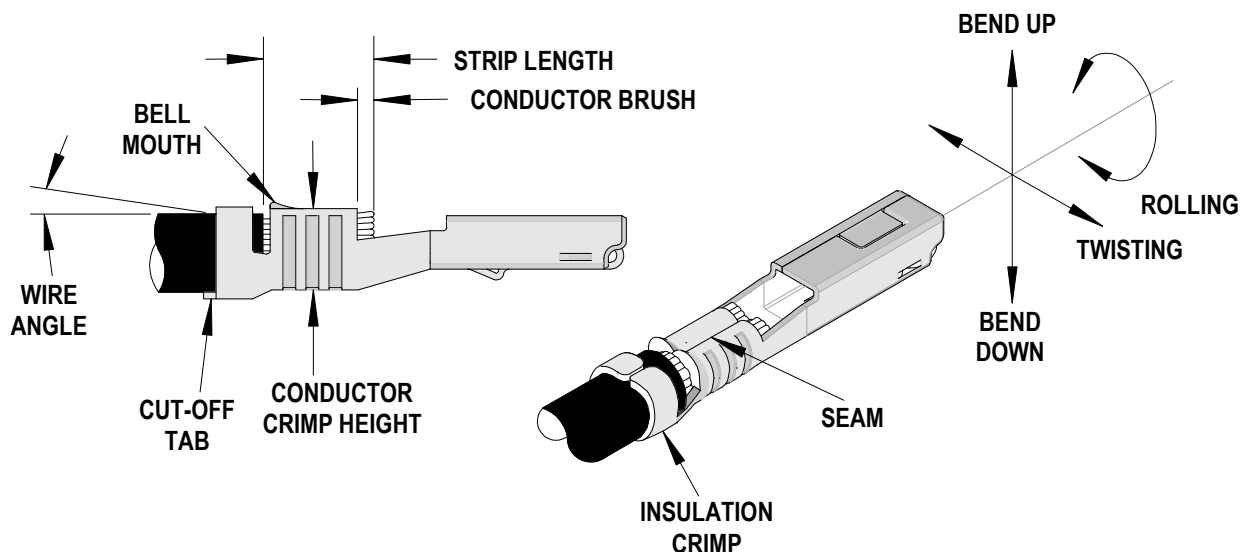
SCOPE

Products: MX150L™ Female Crimp Terminals, TXL 8 AWG wire.

Terminal Series No.	Terminal Order No.	Wire Size		Insulation Diameter		Strip Length	
		AWG	mm ²	mm	In.	mm	In.
19434	19434-0005	8	8.37	4.75-5.00	.187-.197	5.50-6.20	.217-.244

Note: Oiler (63801-7240) required to crimp terminals. See 63880-0000 Mini-Mac Manual.

DEFINITION OF TERMS



CRIMP SPECIFICATION

Terminal Series No.	Bell mouth		Cut-off Tab Maximum		Conductor Brush	
	mm	In.	mm	In.	mm	In.
19434	0.25-1.25	.010-.049	0.50	.020	0.10-1.50	.004-.059

Terminal Series No.	Bend up	Bend down	Twist	Roll	Punch Width (Ref)				Wire Angle	Seam Seam shall not be open and no wire allowed out of the crimping area
	Degree (Max.)		Degree (Max.)		Conductor		Insulation		Degree	
					mm	In	mm	In		
19434	2	3	4	8	4.30	.169	5.20	.205	5° Maximum	

After crimping, the crimp profiles should measure the following:

Terminal Series No.	Wire Size		Conductor				Pull Force Minimum	
	AWG	mm ²	Crimp Height		Crimp Width (Ref.)		N	Lb.
			mm	In.	mm	In.		
19434	8	8.37	3.10-3.20	.122-.126	4.45	.175	400.5	90.0

Terminal Series No.	Wire Size		Insulation			
	AWG	mm ²	Crimp Height (Maximum)		Crimp Width (Ref.)	
			mm	In.	mm	In.
19434	8	8.37	5.10	.201	5.40	.213

Tool Qualification Notes:

1. This applicator was qualified to the above specifications with TXL wire.
2. Pull Force should be measured with no influence from the insulation crimp.
3. The above specifications are guidelines to an optimum crimp.
4. Oiler (63801-7240) required to crimp terminals to improve tooling life. See 63880-0000 Mini-Mac Manual.

PARTS LIST

Mini-Mac Applicator 63895-3100				
Item	Order No	Engineering No.	Description	Quantity
Perishable Tooling				
	63895-3170	63895-3170	Tool Kit (All "Y" Items)	REF
1	63895-3108	63895-3108	Conductor Punch	1 Y
2	63895-3105	63895-3105	Conductor Anvil	1 Y
3	63895-3104	63895-3104	Insulation Punch	1 Y
4	63456-0097	63456-0097	Insulation Anvil	1 Y
5	63443-0037	63443-0037	Cut-off Plunger Front	1 Y
6	63443-0038	63443-0038	Plunger Retainer Front	1 Y
Other Components				
7	11-18-4083	60707-8	Feed Guide	1
8	11-18-4848	60800A123	Spring Retainer	1
9	11-18-4849	60800A124	Wire Hold Down Spring	1
10	63443-0009	63443-0009	Scrap Chute Front	1
11	63443-0024	63443-0024	Key	1
12	63443-0090	63443-0090	Wire Stop	1
13	63443-1726	63443-1726	Height Spacer 19.60mm	1
14	63443-2206	63443-2206	Course Spacer (6.00mm)	1
15	63443-2208	63443-2208	Course Spacer (8.00mm)	1
16	63443-2314	63443-2314	Fine Spacer (3.70mm)	1
17	63443-6140	63443-6140	Rear Cover	1
18	63466-0504	63466-0504	Cut-off Plunger Striker Front	1
19	63700-6099	63700-6099	Terminal Hold Down Spring	1
20	637000539	637000539	Cut-Off Plunger Spring	1
21	63803-5146	63803-5146	Collar-6.40 Long	1
22	63890-0017	63890-0017	Terminal Hold Down	1
23	63890-0059	63890-0059	Terminal Hold Down Holder	1
24	63890-0995	63890-0995	Collar-4.05 Long	1
Frame				
25	63801-3201	63801-3201	Top	1
26	63801-3281	63801-3281	Base	1
27	63801-4650	63801-4650	Track	1
Hardware				
28	N/A	N/A	M3 by 6 Long FHCS	1**
29	N/A	N/A	M3 by 6 Long SHCS	2**
30	N/A	N/A	M4 by 6 Long SHCS	2**
31	N/A	N/A	M4 by 12 Long BHCS	2**
32	N/A	N/A	M4 by 16 Long SHCS	2**
33	N/A	N/A	M4 by 50 Long SHCS	2**
34	N/A	N/A	M5 by 12 Long SHCS	1**
35	N/A	N/A	M8 by 30 Long BHCS	1**
36	N/A	N/A	2mm by 5 Long Roll Pin	1**
37	N/A	N/A	3mm by 12 Long Roll Pin	1**

** Available from an industrial supply company such as MSC (1-800-645-7270).

Assembly Drawing

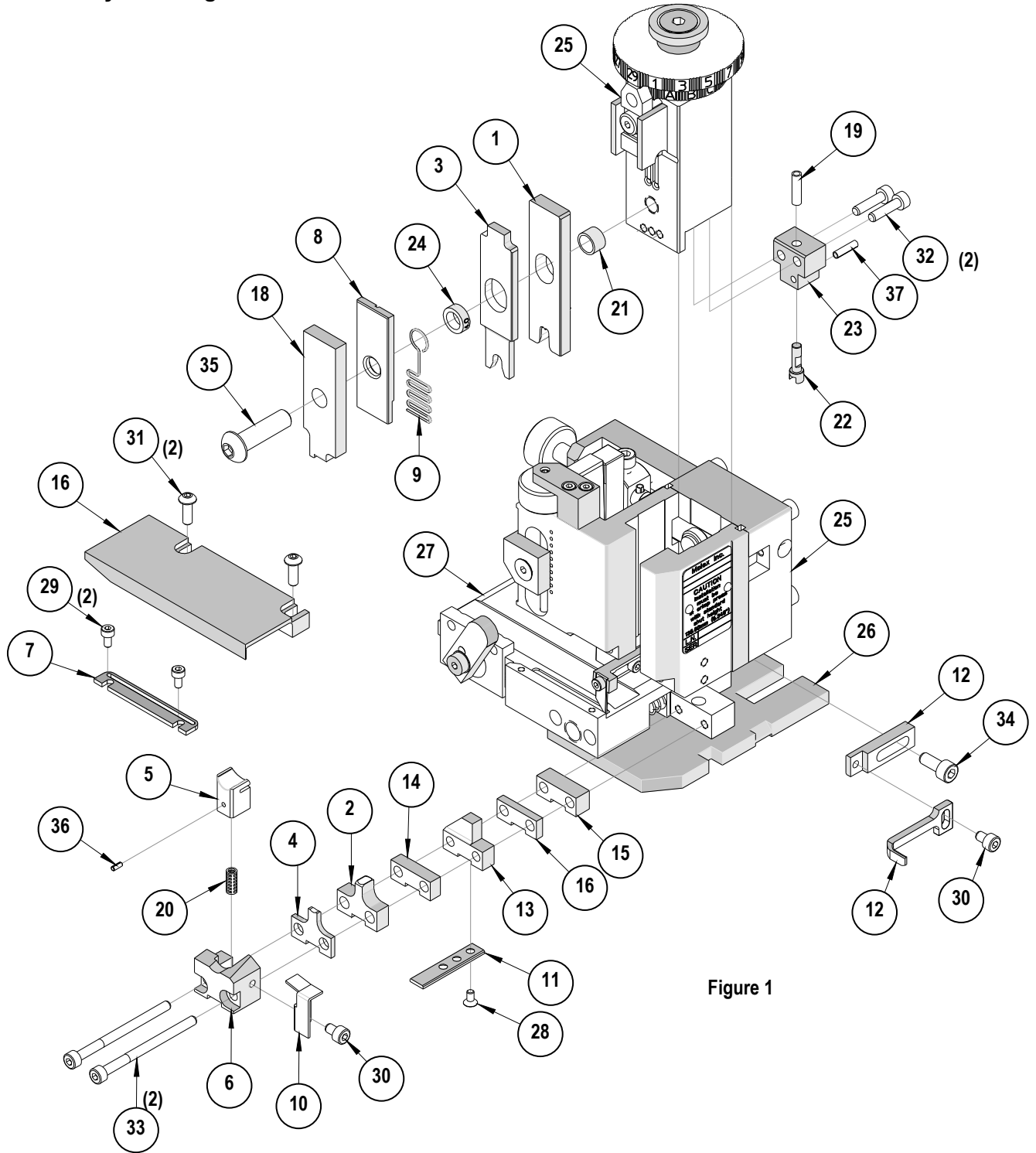


Figure 1

NOTES

1. Molex recommends an extra perishable tooling kit be maintained at your facility.
2. Verify tooling alignment by manually cycling the press with 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 should only be used in a press with a shut height of 135.80 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.

Contact Information

For more information on Molex application tooling please contact Molex at 1-800-786-6539.

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