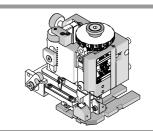
Mini-Mac Applicator



Application Tooling Specification Sheet



Order No. 63891-5100

FEATURES

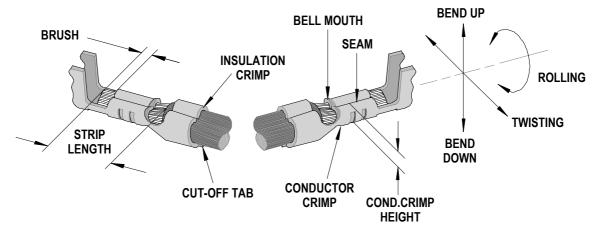
- Directly adapts to most automatic wire processing machines
- Applicator designed to industry standard mounting and shut height 135.80mm (5.346")
- Quick set-up time; plus the crimp height, track and feed adjustments can be set without removing the applicator from the press
- Fine adjustment allows 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: KK® High Pressure Crimp Terminal 22-30 AWG

Terminal Series No.	Terminal Order No.		Wire Size		Insulation Diameter		Strip Length	
Terminal Series No.			AWG	mm²	mm	ln.	mm	ln.
	08-50-0004	50-29-1635						
7879	08-55-0124	50-29-1744	22-30	0.35-0.05	1.57 Max.	.062 Max.	2.54-3.17	.100125
	08-55-0128	50-29-1900						

DEFINITION OF TERMS



The above terminal drawing is a generic terminal representation. It is not an image of a terminal listed in the scope.

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CRIMP SPECIFICATIONS

	Wire Size		Punch Width (Ref)				Seam	
Terminal Series No.			Conductor		Insulation		Seam shall not be	
	AWG	mm²	mm	ln	mm	ln	open and no wire allowed	
7879	22-30	0.35-0.05	1.38	.054	1.65	.065	out of the crimping area	

After crimping, the conductor profile should measure the following.

Terminal Series No.	Wire Size		Conductor C	Pull Force Minimum		
	AWG	mm ²	mm	ln.	N	Lb.
	22	0.35	0.79-0.84	.031033	44.5	10.00
	24	0.20	0.73-0.79	.029031	35.6	8.00
7879	26	0.12	0.71-0.76	.028030	26.7	6.00
	28	0.08	0.68-0.73	.027029	17.8	4.00
	30	0.05	0.66-0.71	.026028	13.3	3.00

Tool Qualification Notes:

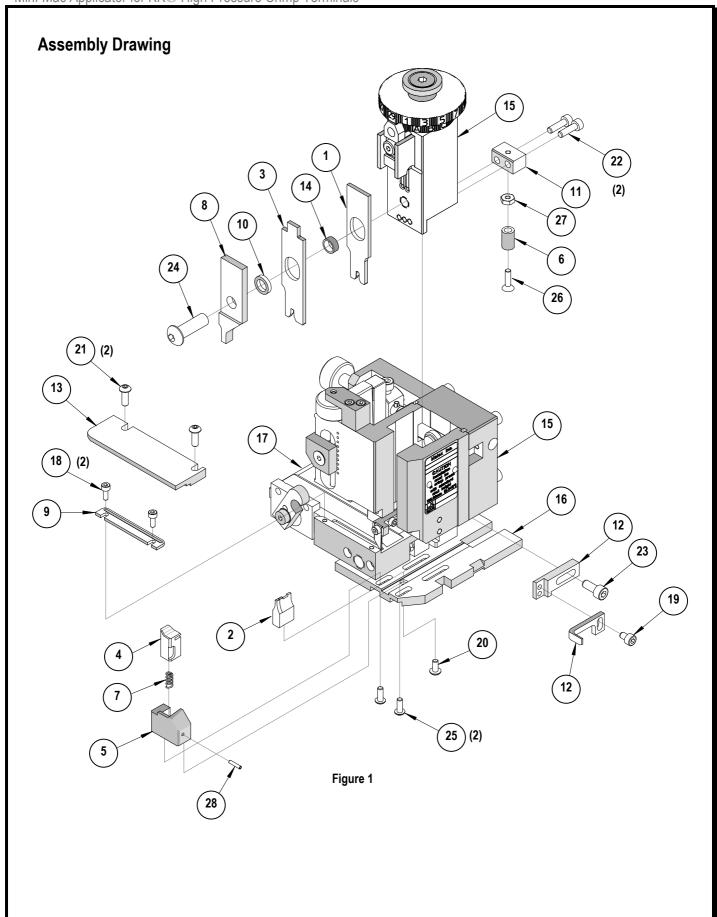
- 1. Pull Force should be measured with no influence from the insulation crimp.
- 2. The above specifications are guidelines to an optimum crimp.

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PARTS LIST

Mini-Mac Applicator 63891-5100									
Item	Order No	Engineering No.	Description	Quantity					
Perishable Tooling									
	63891-5170	63891-5170	Tool Kit (All "Y" Items)	REF					
1	11-18-5256	60713D106	Conductor Punch	1 Y					
2	11-18-5257	60713D107	Combination Anvil	1 Y					
3	11-18-4180	60713-3	Insulation Punch	1 Y					
4	11-18-4018	60704-6	Front Cut-Off Plunger	1 Y					
5	11-18-4015	60704-3	Front Cut-off Plunger Retainer	1 Y					
	Other Components								
6	11-17-2152	7163-14	Hold Down Pad	1					
7	11-17-2863	60633-23	Cut-off Plunger Spring	1					
8	11-18-4021	60704-9	Front Cut-off Striker	1					
9	11-18-4083	60707-8	Feed Guide	1					
10	11-18-4181	60713-4	Tooling Washer	1					
11	11-18-4187	60713-10	Terminal Hold Down Block	1					
12	63443-0090	63443-0090	Wire Stop	1					
13	63443-6111	63443-6111	Rear Cover	1					
14	63803-5124	63803-5124	Conductor Bushing	1					
			Frame						
15	63801-3201	63801-3201	Тор	1					
16	63801-3282	63801-3282	Base	1					
17	63801-6550	63801-6550	Track	1					
	Hardware								
18	N/A	N/A	M3 by 8 Long SHCS	2**					
19	N/A	N/A	M4 by 6 Long SHCS	1**					
20	N/A	N/A	M4 by 8 Long BHCS	1**					
21	N/A	N/A	M4 by 12 Long BHCS	2**					
22	N/A	N/A	M4 by 12 Long SHCS	2**					
23	N/A	N/A	M5 by 10 Long SHCS	1**					
24	N/A	N/A	M8 by 20 Long BHCS	1**					
25	N/A	N/A	#6-32 by 3/8" Long BHCS	2**					
26	N/A	N/A	#6-32 by 1/2" Long FHCS	1**					
27	N/A	N/A	#6-32 Hex Jam Nut	1**					
28	N/A	N/A	.078 Diameter by 3/8" Long Roll Pin	1**					
*	** Available from an industrial supply company such as MSC (1-800-645-7270).								

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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.

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

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