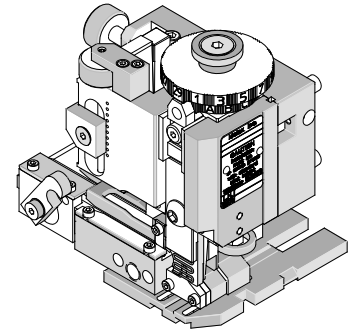




Mini-Mac Applicator Specification Sheet Order No. 63892-7000



FEATURES

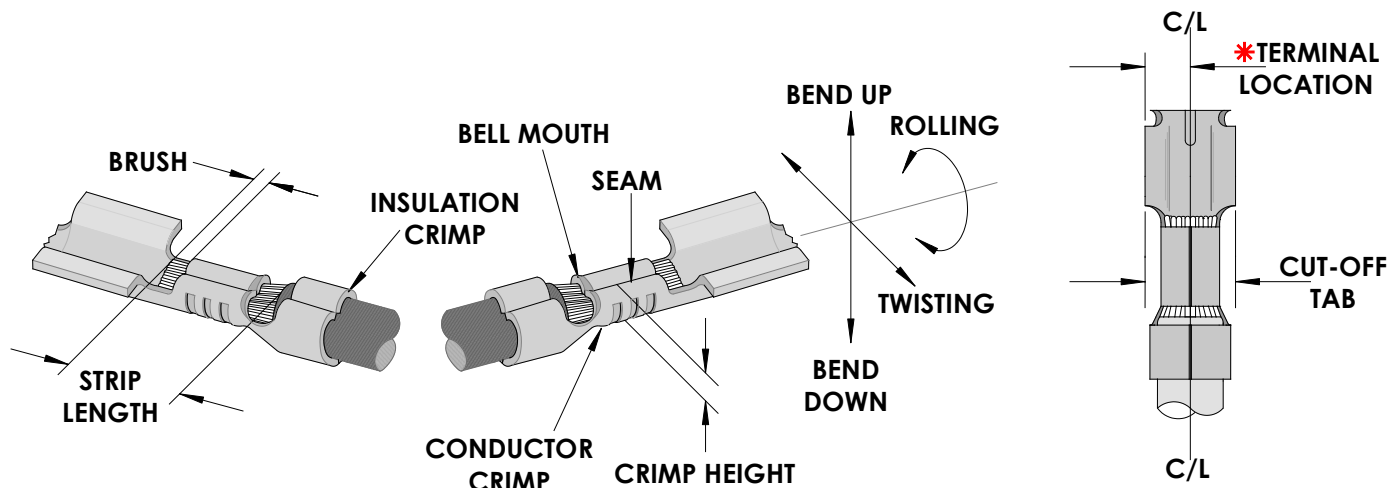
- Directly adapts to most automatic wire processing machines
- Applicator designed to industry standard mounting and shut height 135.80mm (5.346")
- Quick set-up time; plus the crimp height, track and feed adjustments can be set without removing the applicator from the press
- Fine adjustment allows 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: 2.36mm (.093") Diameter, Standard .093" Pin and Socket Crimp Terminal, 18-22 AWG

Terminal Series No.	Terminal Order No.			Wire Size	Insulation Diameter		Strip Length	
				AWG	mm	In.	mm	In.
1380	02-09-2116	02-09-6122	39-00-0303	18-22	3.05 Max.	.120 Max.	3.96-5.54	.156-.218
	02-09-2117	02-09-6125	39-00-0305					
	02-09-2127	39-00-0283	40-01-1139					
1381	02-09-1115	02-09-5130	39-00-0309	18-22	3.05 Max.	.120 Max.	3.96-5.54	.156-.218
	02-09-1116	02-09-5143	39-00-0311					
	02-09-1117	39-00-0284	39-00-0312					
	02-09-1129	39-00-0285	40-01-1192					
2151	02-09-1201	02-09-1203	02-09-5203	18-22	3.05 Max.	.120 Max.	3.96-5.54	.156-.218
2152	02-09-2201	02-09-3202	02-09-6203	18-22	3.05 Max.	.120 Max.	3.96-5.54	.156-.218
2273	02-09-1122	02-09-1135		18-22	3.05 Max.	.120 Max.	3.96-5.54	.156-.218
4272	02-09-1151			18-22	3.05 Max.	.120 Max.	3.96-5.54	.156-.218
6271	02-09-1208			18-22	3.05 Max.	.120 Max.	3.96-5.54	.156-.218

DEFINITION OF TERMS



* Terminal is to be centrally located between the two (2) cut-off tab edges by one half of the total cut-off tab tolerance.

This illustration is a generic terminal representation and not an exact image of any terminal listed in the scope.

CRIMP SPECIFICATIONS

Terminal Series No.	Bell mouth		* Cut-off Tab		Conductor Brush	
	mm	In.	mm	In.	mm	In.
1380			3.53-3.69	.139-.145		
1381			3.53-3.69	.139-.145		
2151			3.53-3.69	.139-.145		
2152			3.53-3.69	.139-.145		
2273			3.53-3.69	.139-.145		
4272			3.53-3.69	.139-.145		
6271			3.53-3.69	.139-.145		

Terminal Series No.	Bend up	Bend down	Twist	Roll	Punch Width (Ref)				Seam
					Conductor		Insulation		
	Degree		Degree		mm	In.	mm	In.	
1380					1.70	.067	3.10	.122	Seam shall not be open and no wire allowed out of the crimping area
1381					1.70	.067	3.10	.122	
2151					1.70	.067	3.10	.122	
2152					1.70	.067	3.10	.122	
2273					1.70	.067	3.10	.122	
4272					1.70	.067	3.10	.122	
6271					1.70	.067	3.10	.122	

NOTE: Some of the specifications in these charts above are intentionally left blank due to the fact that the information does not currently exist.

After crimping, the conductor profile should measure the following.

Terminal Series No.	Wire Size	Conductor				Pull Force Minimum	
		Crimp Height		Crimp Width (REF)		N	Lb.
	AWG	mm	In.	mm	In.		
1380	18	1.40-1.47	.055-.058			111.2	25.0
	20	1.30-1.37	.051-.054			66.7	15.0
	22	1.22-1.30	.048-.052			44.5	10.0
1381	18	1.40-1.47	.055-.058			111.2	25.0
	20	1.30-1.37	.051-.054			66.7	15.0
	22	1.22-1.30	.048-.052			44.5	10.0
2151	18	1.40-1.47	.055-.058			107.9	24.3
	20	1.30-1.37	.051-.054			58.9	13.2
	22	1.22-1.30	.048-.052			39.2	8.8
2152	18	1.40-1.47	.055-.058			107.9	24.3
	20	1.30-1.37	.051-.054			58.9	13.2
	22	1.22-1.30	.048-.052			39.2	8.8
2273	18	1.40-1.47	.055-.058			111.2	25.0
	20	1.30-1.37	.051-.054			66.7	15.0
	22	1.22-1.30	.048-.052			44.5	10.0
4272	18	1.40-1.47	.055-.058			111.2	25.0
	20	1.30-1.37	.051-.054			66.7	15.0
	22	1.22-1.30	.048-.052			44.5	10.0
6271	18	1.40-1.47	.055-.058			111.2	25.0
	20	1.30-1.37	.051-.054			66.7	15.0
	22	1.22-1.30	.048-.052			44.5	10.0

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 63892-7000				
Item	Order No	Engineering No.	Description	Quantity
Perishable Tooling				
	63892-7070	63892-7070	Tool Kit (All "Y" Items)	REF
1	11-18-5073	60800B106	Conductor Punch	1 Y
2	11-18-5074	60800B107	Conductor Anvil	1 Y
3	11-18-4873	60800A128	Insulation Punch	1 Y
4	11-18-4813	60800A109	Insulation Anvil	1 Y
5	11-18-4817	60800A113	Cut-Off Punch	1 Y
6	11-18-4808	60800A104	Rear Cut-off Die	1 Y
Other Components				
7	11-18-4809	60800A105	Tooling Washer	1
8	11-18-4810	60800A106	Rear Block	1
9	11-18-4811	60800A107	Compression Spring	1
10	11-18-4814	60800A110	Plunger	1
11	11-18-4815	60800A111	Guide Plate	1
12	11-18-4816	60800A112	Terminal Drag Plate	1
13	11-18-4818	60800A114	Mounting Block	1
14	11-18-4829	60800A125	Wire Stop	1
15	11-18-4848	60800A123	Spring Retainer	1
16	11-18-4849	60800A124	Wire Hold Down Spring	1
17	11-18-4894	60800A129	Knockout Blade	1
18	11-18-5005	60800D112	Hold Down Block	1
19	11-18-5006	60800D113	Spring Retainer	1
20	11-18-5007	60800D114	Compression Spring (Hold Down)	1
21	11-18-5008	60800D115	Hold Down Plunger	1
22	11-18-5015	60805A122	Front Cover	1
23	63803-5120	63803-5120	Conductor Bushing	1
Frame				
24	63801-3201	63801-3201	Top	1
25	63801-3282	63801-3282	Base	1
26	63801-6550	63801-6550	Track	1
Hardware				
27	N/A	N/A	M3 by 6 Long SHCS	6**
28	N/A	N/A	M3 by 25 Long SHCS	2**
29	N/A	N/A	M4 by 6 Long BHCS	2**
30	N/A	N/A	M4 by 8 Long BHCS	2**
31	N/A	N/A	M4 by 10 Long BHCS	2**
32	N/A	N/A	M4 by 20 Long SHCS	2**
33	N/A	N/A	M5 by 10 Long SHCS	1**
34	N/A	N/A	M8 by 20 Long BHCS	1**

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

Assembly Drawing

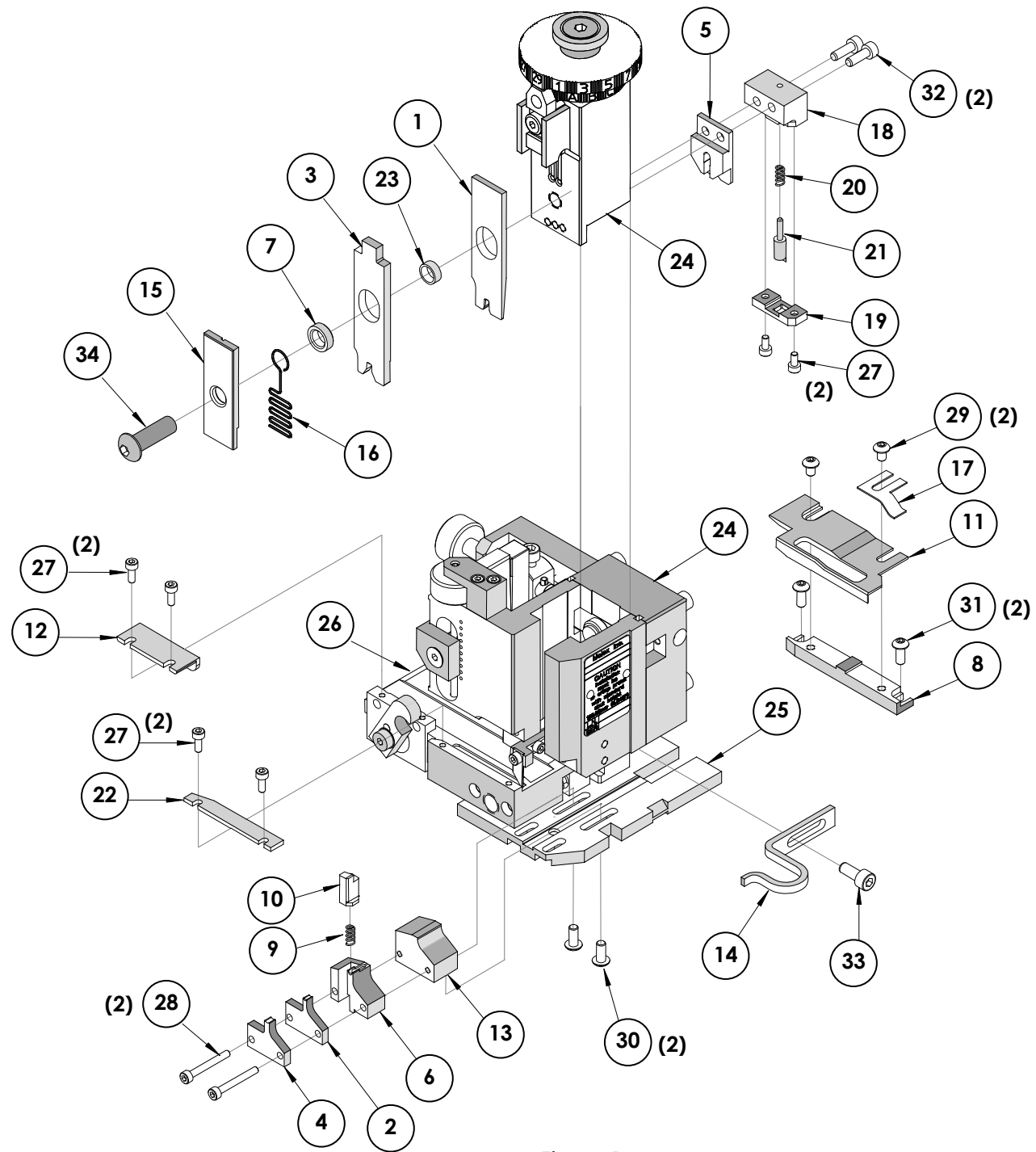


Figure 1

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 Mini-Mac Manual.

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.

Application Tooling Support

Phone: (402) 458-TOOL (8665)

E-Mail: applicationtooling@molex.com

Website: www.molex.com/applicationtooling

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