

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

**Application Tooling
Specification Sheet**

Order No. 63895-0400

FEATURES

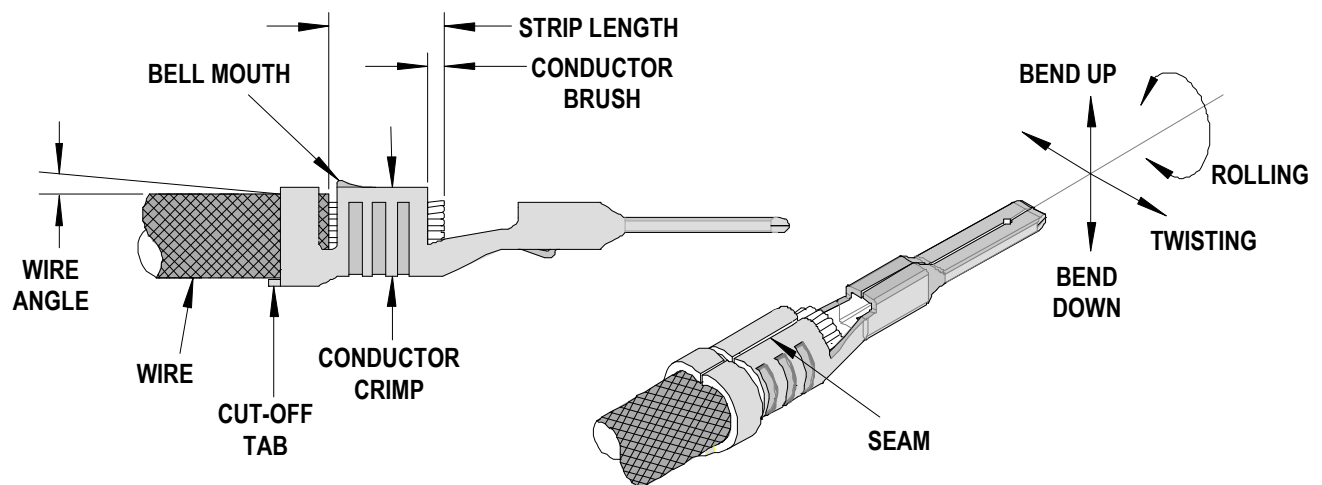
- Directly adapts to most automatic wire processing machines
- Applicator designed to industry standard mounting and shut height 135.80mm (5.346")
- Quick set-up time; plus the crimp height, track and feed adjustments can be set without removing the applicator from the press
- Fine adjustment allows 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™ Male and Female Crimp Terminals, 10-12 AWG.

Terminal Series No.	Terminal Order No.	Wire Size		Insulation Diameter		Strip Length	
		AWG	mm ²	mm	In.	mm	In.
19431	19431-0001	10-12	5.26-3.31	3.90-4.85	.153-.191	5.50-6.20	.217-.244
19434	19434-0001	10-12	5.26-3.31	3.90-4.85	.153-.191	5.50-6.20	.217-.244

DEFINITION OF TERMS



CRIMP SPECIFICATION

Terminal Series No.	Bell mouth		Cut-off Tab Maximum		Conductor Brush	
	mm	In.	mm	In.	mm	In.
19431	0.25-1.25	.010-.049	0.50	.020	0.10-0.50	.004-.020
19434	0.25-1.25	.010-.049	0.50	.020	0.10-0.50	.004-.020

Terminal Series No.	Bend up Bend down		Twist	Roll	Punch Width (Ref)				Wire Angle Degree	Seam Seam shall not be open and no wire allowed out of the crimping area
	Degree				Degree		Conductor			
	mm	In	mm	In	mm	In	mm	In		
19431	2	3	4	8	3.80	.150	5.00	.197	5° Maximum	
19434	2	3	4	8	3.80	.150	5.00	.197	5° Maximum	

After crimping, the crimp profiles should measure the following:

Terminal Series No.	Wire Size		Conductor				Pull Force Minimum	
			Crimp Height		Crimp Width (Ref.)			
	AWG	mm ²	mm	In.	mm	In.	N	Lb.
19431	10	5.26	2.45-2.55	.096-.100	3.80 +/- .10	.150 +/- .004	356.0	80.0
	12	3.31	2.05-2.15	.081-.085	3.80 +/- .10	.150 +/- .004	311.5	70.0
19434	10	5.26	2.45-2.55	.096-.100	3.80 +/- .10	.150 +/- .004	356.0	80.0
	12	3.31	2.05-2.15	.081-.085	3.80 +/- .10	.150 +/- .004	311.5	70.0

Terminal Series No.	Wire Size		Insulation			
			Crimp Height		Crimp Width (Ref.)	
	AWG	mm ²	mm	In.	mm	In.
19431	10	5.26	5.00 Max	.197 Max	5.20 +/- .10	.205 +/- .004
	12	3.31	4.50 Max	.177 Max	5.10 +/- .10	.201 +/- .004
19434	10	5.26	5.00 Max	.197 Max	5.20 +/- .10	.205 +/- .004
	12	3.31	4.50 Max	.177 Max	5.10 +/- .10	.201 +/- .004

Tool Qualification Notes:

1. This applicator was qualified to the above specifications with UL1015 wire.
2. Pull Force should be measured with no influence from the insulation crimp.
3. The above specifications are guidelines to an optimum crimp.

PARTS LIST

Mini-Mac Applicator 63895-0400				
Item	Order No	Engineering No.	Description	Quantity
Perishable Tooling				
	63895-0470	63895-0470	Tool Kit (All "Y" Items)	REF
1	63465-0042	63465-0042	Conductor Punch	1 Y
2	63455-0029	63455-0029	Conductor Anvil	1 Y
3	63472-0002	63472-0002	Insulation Punch	1 Y
4	63445-5007	63445-5007	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	11-24-1067	4996-4	Cut-Off Plunger Spring	1
9	63443-0009	63443-0009	Scrap Chute Front	1
10	63443-0024	63443-0024	Key	1
11	63443-0090	63443-0090	Wire Stop	1
12	63443-1728	63443-1728	Height Spacer (19.80mm)	1
13	63443-2207	63443-2207	Course Spacer (7.00mm)	1
14	63443-2208	63443-2208	Course Spacer (8.00mm)	1
15	63443-2314	63443-2314	Fine Spacer (3.70mm)	1
16	63443-6140	63443-6140	Rear Cover	1
17	63466-0508	63466-0508	Cut-off Plunger Striker Front	1
18	63890-0866	63890-0866	Collar-6.40 Long	1
19	63890-0995	63890-0995	Collar-4.05 Long	1
Frame				
20	63801-3201	63801-3201	Top	1
21	63801-3281	63801-3281	Base	1
22	63801-4650	63801-4650	Track	1
Hardware				
23	N/A	N/A	M3 by 6 Long FHCS	1**
24	N/A	N/A	M3 by 6 Long SHCS	2**
25	N/A	N/A	M4 by 6 Long SHCS	2**
26	N/A	N/A	M4 by 12 Long BHCS	2**
27	N/A	N/A	M4 by 50 Long SHCS	2**
28	N/A	N/A	M5 by 12 Long SHCS	1**
29	N/A	N/A	M8 by 30 Long BHCS	1**
30	N/A	N/A	2mm by 5 Long Roll Pin	1**
** Available from an industrial supply company such as MSC (1-800-645-7270).				

Assembly Drawing

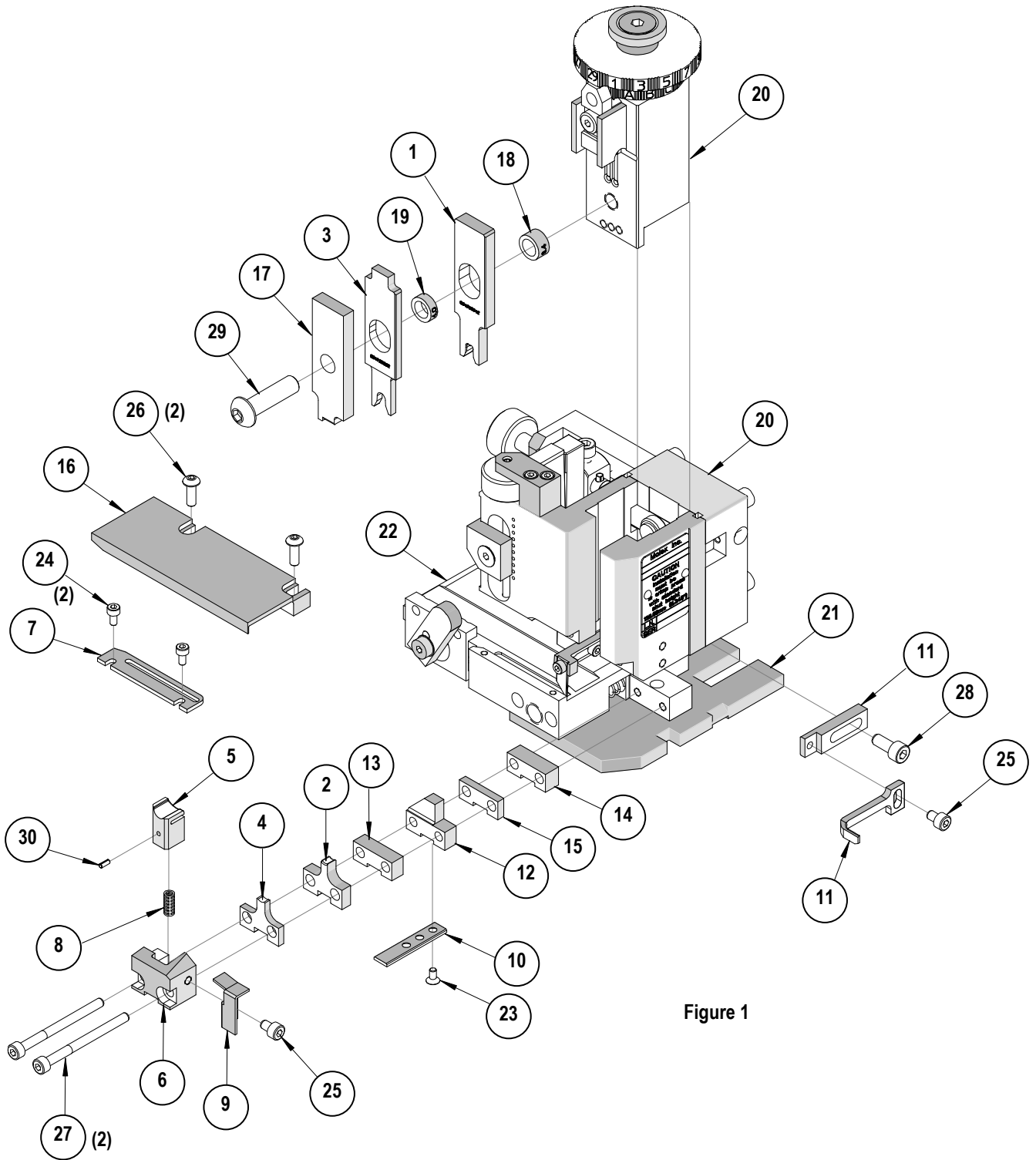


Figure 1

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>