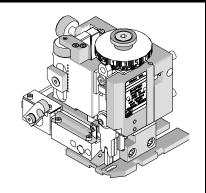


Mini-Mac Applicator **Specification Sheet** Order No. 63892-4100



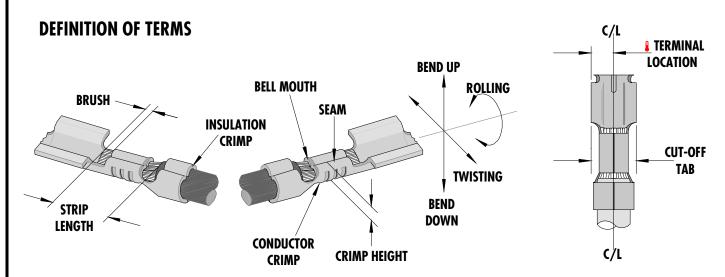
FEATURES

- 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, 24-30 AWG

Terminal Series No.	Terminal Order No.			Wire Size		Insulation Diameter		Strip Length	
				AWG	mm²	mm	In.	mm	ln.
	02-09-1141	39-00-0315	39-00-0321						
1433	02-09-1142	39-00-0317		24-30	0.05-0.20	1.52 Max.	.060 Max.	3.96-5.54	.156218
	02-09-5146	39-00-0319			ĺ				
1434	02-09-2141	02-09-6144	39-00-0325	24-30	0.05-0.20	1.52 Max.	.060 Max.	3.96-5.54	.156218
1434	02-09-2149	39-00-0323		24-30	0.03-0.20	1.JZ Mux.	.000 Mux.	3.70-3.34	.130210



♣ 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.

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CRIMP SPECIFICATIONS

	Terminal Series No.	Bell mouth		↓ Cut-	off Tab	Conductor Brush		
rerminai :	reminal Series No.	mm	ln.	mm	ln.	mm	ln.	
	1433			3.53-3.69	.139145			
	1434			3.53-3.69	.139145			

	Bend up Bend down	Twist Roll	Punch Width (Ref)				C	
Terminal Series No.	bena up dena aown	I WISI KOII	Cond	uctor	Insul	ation	Seam Seam shall not be open	
	Degree	Degree	mm	ln.	mm	ln.	and no wire allowed out	
1433			1.90	.075	1.93	.076	of the crimping area	
1434			1.90	.075	1.93	.076	or me crimping area	

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.

	Wire Size			Pull Force					
Terminal Series No.			Crimp	Height	Crimp Wid	Minimum			
	AWG	mm²	mm	ln.	mm	ln.	N	Lb.	
	l l 22	0.35	0.96-1.02	.038040			53.4	12.00	
	24	0.20	0.86-0.91	.034036			44.5	10.00	
1433	26	0.12	0.74-0.79	.029031			26.7	6.00	
	28	0.08	0.71-0.76	.028030			17.8	4.00	
	30	0.05	0.71-0.76	.028030			13.3	3.00	
	l l 22	0.35	0.96-1.02	.038040			53.4	12.00	
	24	0.20	0.86-0.91	.034036			44.5	10.00	
1434	26	0.12	0.74-0.79	.029031			26.7	6.00	
	28	0.08	0.71-0.76	.028030			17.8	4.00	
	30	0.05	0.71-0.76	.028030			13.3	3.00	
Special Application outside of product specification. Customer to test suitability for their application.									

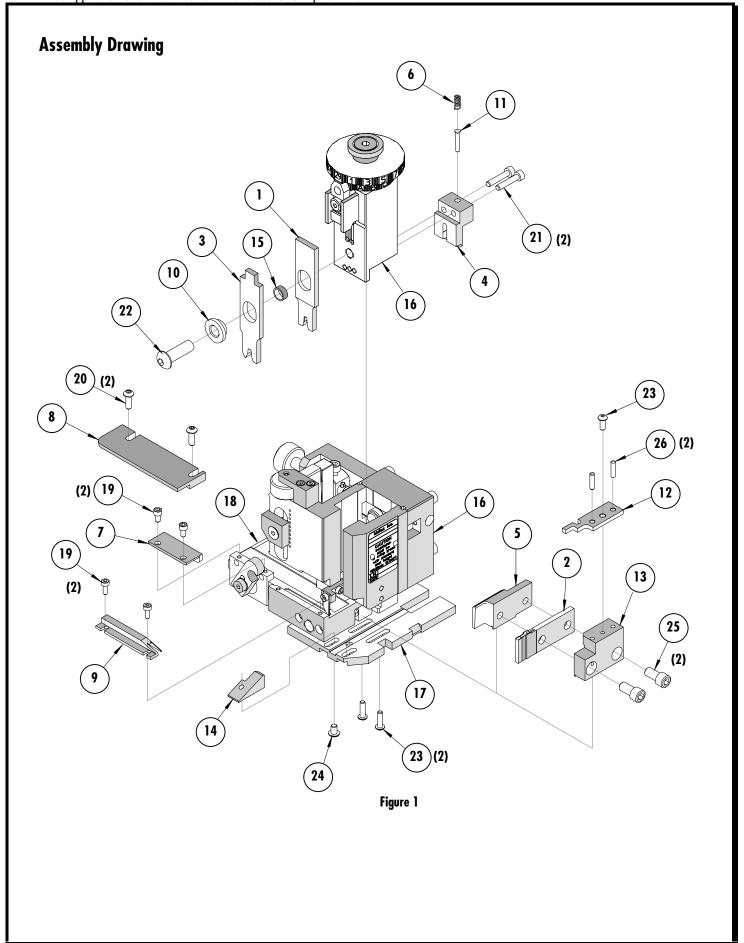
Pull Force should be measured with no influence from the insulation crimp. The above specifications are guidelines to an optimum crimp.

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PARTS LIST

Mini-Mac Applicator 63892-4100										
Item	Order No	Engineering No.	Description	Quantity						
Perishable Tooling										
	63892-4170	63892-4170	Tool Kit (All "Y" Items)	REF						
1	11-18-4053	60706-15	Conductor Punch	1 Y						
2	11-18-4055	60706-17	Combination Anvil	1 Y						
3	11-18-4054	60706-16	Insulation Punch	1 Y						
4	11-18-4447	60706-31	Cut-Off Punch	1 Y						
5	11-18-4044	60706-6	Cut-off Die Plate	1 Y						
		Oth	er Components							
6	11-17-0094	1739-37	Compression Spring	1						
7	11-17-1172	4151-20	Terminal Drag Plate	1						
8	11-18-4040	60706-2	Cover Plate	1						
9	11-18-4042	60706-4	Terminal Guide	1						
10	11-18-4043	60706-5	Insulation Punch Holder	1						
11	11-18-4422	60706-28	Hold Down Plunger	1						
12	11-18-4423	60706-29	Stripper and Wire Stop	1						
13	11-18-4446	60706-30	Stripper and Wire Stop Holder	1						
14	11-18-4562	60700-15	Slug Ramp	1						
15	63803-5105	63803-5105	Conductor Bushing	1						
Frame										
16	63801-3201	63801-3201	Тор	1						
17	63801-3282	63801-3282	Base	1						
18	63801-6550	63801-6550	Track	1						
		H	ardware							
19	N/A	N/A	M3 by 8 Long SHCS	4**						
20	N/A	N/A	M4 by 12 Long BHCS	2**						
21	N/A	N/A	M4 by 16 Long SHCS	2**						
22	N/A	N/A	M8 by 20 Long BHCS	1**						
23	N/A	N/A	#6-32 by 3/8" Long BHCS	3**						
24	N/A	N/A	#8-32 by 1/4" Long BHCS 1**							
25	N/A	N/A	#1/4-20 by 1/2" Long SHCS 2**							
26	N/A	N/A	1/8 Diameter by 3/8" Long Roll Pin	2**						
	** Available from an industrial supply company such as MSC (1-800-645-7270).									

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NOTES

- Molex recommends an extra perishable tooling kit be maintained at your facility.
- Verify tooling alignment by manually cycling the press and applicator before crimping under power. Check that all screws are tight.
- 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.

Contact Information

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

Americas Headquarters Lisle, Illinois 60532 U.S.A. 1-800-78MOLEX amerinfo@molex.com

Far East North Headquarters Yamato, Kanagawa, Japan 81-462-65-2324 feninfo@molex.com

Far East South Headquarters Jurong, Singapore 65-6-268-6868 fesinfo@molex.com

European Headquarters Munich, Germany 49-89-413092-0 eurinfo@molex.com

Corporate Headquarters 2222 Wellington Ct. Lisle, IL 60532 U.S.A. 630-969-4550

Fax: 630-969-1352

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

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