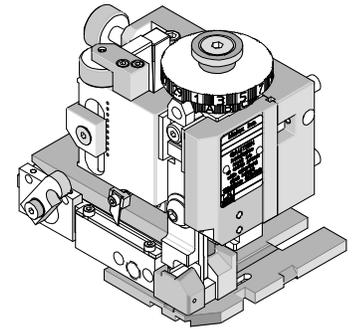




# Mini-Mac Applicator Specification Sheet Order No. 63893-6100



## FEATURES

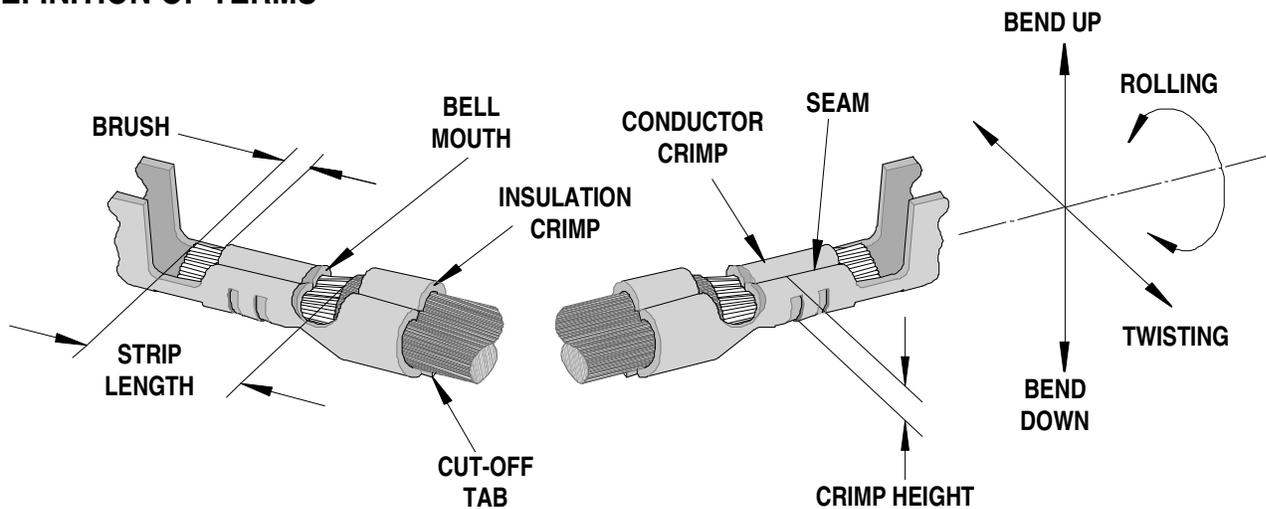
- Directly adapts to most automatic wire processing machines
- Applicator designed to industry standard mounting and shut height 135.80mm (5.346")
- Quick set-up time; plus the crimp height, track and feed adjustments can be set without removing the applicator from the press
- Fine adjustment allows 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: 1.57mm (.062") diameter pin and socket crimp terminals, 24-28 AWG.

Terminal Series No.	Terminal Order No.		Wire Size		Insulation Diameter Maximum		Strip Length	
			AWG	mm <sup>2</sup>	mm	In.	mm	In.
5008	08-70-0003	08-70-1015	24-28	0.20-0.09	2.40	.094	2.70-3.30	.106-.130
5009	08-70-0004	08-70-1017	24-28	0.20-0.09	2.40	.094	2.70-3.30	.106-.130

## DEFINITION OF TERMS



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

## CRIMP SPECIFICATIONS

Terminal Series No.	Bell mouth		Cut-off Tab Maximum		Conductor Brush	
	mm	In.	mm	In.	mm	In.
5008	0.20-0.50	.008-.020	0.30	.012	0.00-1.00	.000-.040
5009	0.20-0.50	.008-.020	0.30	.012	0.00-1.00	.000-.040

Terminal Series No.	Bend up	Bend down	Twist	Roll	Punch Width (Ref)				Seam
					Conductor		Insulation		
	Degree		Degree		mm	In.	mm	In.	
5008	3	3	4	15	1.40	.055	2.51	.099	Seam shall not be open and no wire allowed out of the crimping area
5009	3	3	4	15	1.40	.055	2.51	.099	

**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	
	AWG	mm <sub>2</sub>	Crimp Height		Crimp Width (Ref.)		N	Lb.
			mm	In.	mm	In.		
5008	24	0.20	0.75-0.80	.030-.032	1.40	.055	44.5	10.0
	26	0.13	0.69-0.74	.027-.029	1.40	.055	26.7	6.0
	28	0.09	0.60-0.65	.024-.026	1.40	.055	13.3	3.0
5009	24	0.20	0.75-0.80	.030-.032	1.40	.055	44.5	10.0
	26	0.13	0.69-0.74	.027-.029	1.40	.055	26.7	6.0
	28	0.09	0.60-0.65	.024-.026	1.40	.055	13.3	3.0

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

**PARTS LIST**

<b>Mini-Mac Applicator 63893-6100</b>				
<b>Item</b>	<b>Order No</b>	<b>Engineering No.</b>	<b>Description</b>	<b>Quantity</b>
<b>Perishable Tooling</b>				
	63893-6170	63893-6170	Tool Kit (All "Y" Items)	REF
1	11-18-4879	60762B101	Conductor Punch	1 Y
2	11-18-4877	60762B102	Combination Anvil	1 Y
3	11-18-4878	60762B103	Insulation Punch	1 Y
4	11-18-4652	60758A107	Front Cut-Off Plunger	1 Y
5	11-18-4653	60758A108	Front Plunger Retainer	1 Y
<b>Other Components (REF 936150)</b>				
6	11-18-4022	60704-10	Terminal Hold Down Adapter	1
7	11-18-4034	60705A108	Front Plunger Striker	1
8	11-18-4083	60707-8	Feed Gude	1
9	11-18-5318	60832A115	Tooling Washer	1
10	11-18-4741	60762A108	Spacer	1
11	11-18-4778	60762A113	Hold Down Pad	1
12	11-24-1067	4996-4	Cut-off Plunger Spring	1
13	63443-0090	63443-0090	Wire Stop	1
14	63443-6116	63443-6116	Rear Cover	1
15	63803-5132	63803-5132	Conductor Bushing	1
<b>Frame</b>				
16	63801-3201	63801-3201	Top	1
17	63801-3282	63801-3282	Base	1
18	63801-6550	63801-6550	Track	1
<b>Hardware</b>				
19	N/A	N/A	M3 by 8 Long SHCS	2**
20	N/A	N/A	M4 by 6 Long SHCS	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 12 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	1**
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	#8-32 by 3/8" Long BHCS	4**
** Available from an industrial supply company such as MSC (1-800-645-7270).				

### Assembly Drawing

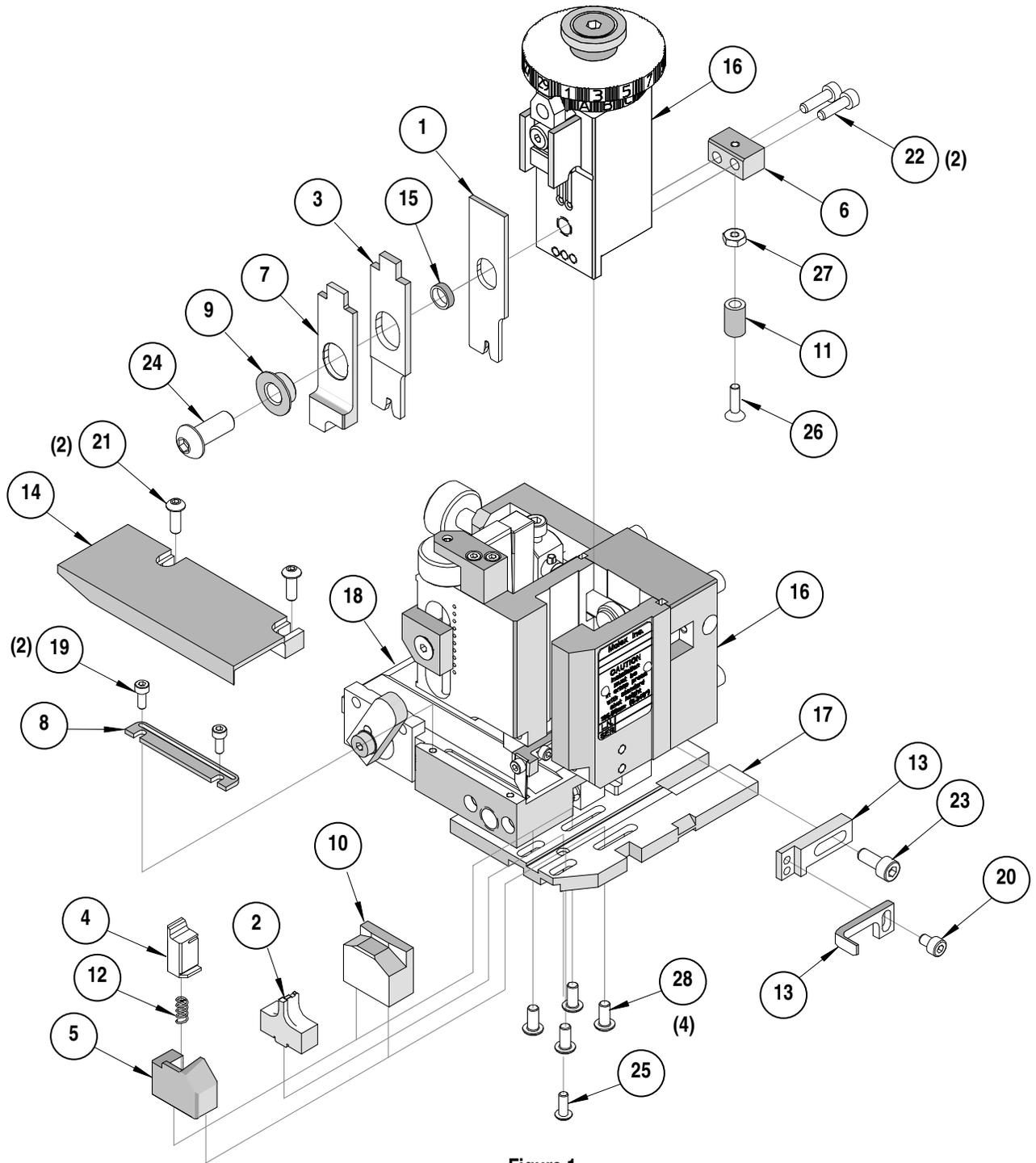


Figure 1

## 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.

## Contact Information

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

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