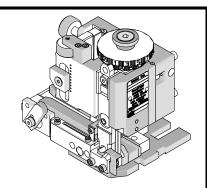


Mini-Mac Applicator Application Tooling Specification Mechanical Feed-Front Metal Strip Order No. 63895-0700



FEATURES

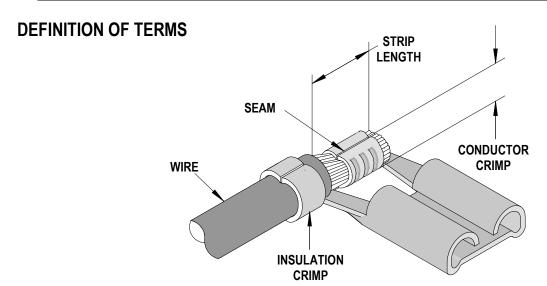
- Directly adapts to most automatic wire processing machines
- Applicator designed to industry standard mounting and shut height 135.80mm (5.346")
- Quick set-up time; plus the crimp height, track and feed adjustments can be set without removing the applicator from the press
- Fine adjustment allows 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: Quick Disconnect, Female, Flag, for 0.50-1.00mm² (18-20 AWG) Wire, Accepts 6.35mm (.250") by 0.81mm (.032") Tab Crimp Terminals.

Terminal	Terminal Order No.		Wire Size		Insulation Diameter				Strip Length		
Series No.					IPC/WHMA-A620◆		Terminal (Max) → →		Strip Length		
Series No.			AWG	mm²	mm	ln.	mm	ln.	mm	ln.	
94030	94030-5000	94030-5001	-	1.00	2.10-2.60	.083102	2.60	.102	6.00-7.00	.236276	
			18	0.80							
			-	0.80							
			20	0.50							
			-	0.50							

- ◆ To achieve optimum IPC-A620 insulation crimps, use this insulation OD range.
- ♦ Overall insulation OD specification for terminal.



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

UNCONTROLLED COPY Doc No: ATS-638950700 Release Date: 10-07-08 Page 1 of 5 Revision Date: 10-07-08

Revision: A

CRIMP SPECIFICATION

After crimping, the crimp profiles should measure the following:

	Wire Size		Conductor					Pull Force				
Terminal Series No.			Crimp Height		Crimp Width Maximum		Crimp Height		Crimp Width Maximum		Minimum	
	AWG	mm ²	mm	ln.	mm	ln.	mm	ln.	mm	ln.	N	Lb.
94030	•	1.00	1.60-1.70	.063067	2.35	.093	3.00-3.10	.118122	3.45	.136	156.9	35.27
	18	0.80	1.50-1.60	.059063	2.35	.093	2.90-3.00	.114118	3.45	.136	117.7	26.46
	ı	0.80	1.50-1.60	.059063	2.35	.093	2.90-3.00	.114118	3.45	.136	117.7	26.46
	20	0.50	1.40-1.50	.055059	2.35	.093	2.80-2.90	.110114	3.45	.136	78.5	17.64
	ı	0.50	1.40-1.50	.055059	2.35	.093	2.80-2.90	.110114	3.45	.136	78.5	17.64

* 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.

UNCONTROLLED COPY Doc No: ATS-638950700 Page 2 of 5 Release Date: 10-07-08 Revision: A

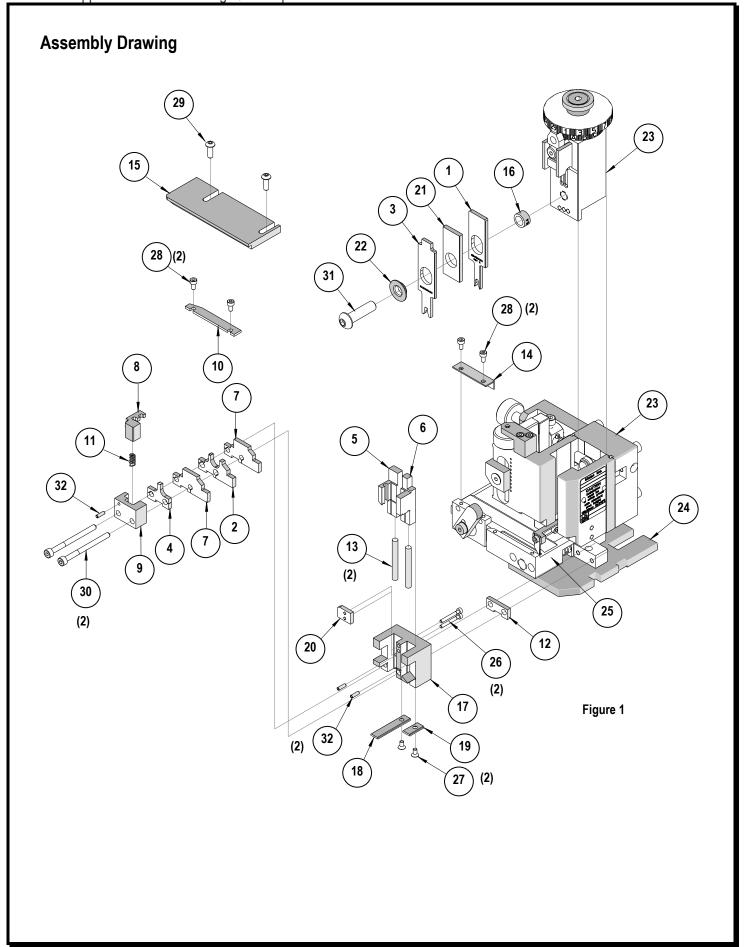
Revision Date: 10-07-08

PARTS LIST

Mini-Mac Applicator 63895-0700										
Item	Order No	Engineering No.	Description	Quantity						
Perishable Tooling										
	63895-0770	63895-0770	Tool Kit (All "Y" Items)	REF						
1	63475-0002	63475-0002	Conductor Punch-2.20pw	1 Y						
2	63895-0702	63895-0702	Anvil	1 Y						
3	63476-0002	63476-0002	Insulation Punch-3.20pw	1 Y						
4	63445-3242	63445-3242	Insulation Anvil	1 Y						
5	63895-0705	63895-0705	Cut Punch Left	1 Y						
6	63895-0706	63895-0706	Cut Punch Right	1 Y						
7	63895-0703	63895-0703	Cut-Off Die-Front	2 Y						
8	63895-0735	63895-0735	Lifter	1 Y						
9	63895-0734	63895-0734	Retainer Lifter	1 Y						
Other Components (Ref. 50750)										
10	11-18-5015	60805A122	Front Cover	1						
11	11-24-1067	4996-4	Cut Off Plunger Spring	1						
12	63443-2310	63443-2310	3.50mm Spacer	1						
13	63600-2995	63600-2995	Compression Spring	2						
14	63890-0042	63890-0042	Terminal Drag Cover	1						
15	63890-0046	63890-0046	Rear Cover	1						
16	63890-0866	63890-0866	Collar-6.40 Long	1						
17	63895-0731	63895-0731	Guide Cut Punch	1						
18	63895-0732	63895-0732	Key 37	1						
19	63895-0733	63895-0733	Key 16	1						
20	63895-0736	63895-0736	Wire Stop	1						
21	63895-0737	63895-0737	Punch Spacer 3.65	1						
22	63895-0738	63895-0738	Tooling Washer	1						
		Fran	ne							
23	63801-3201	63801-3201	Тор	1						
24	63801-3281	63801-3281	Base	1						
25	63801-4650	63801-4650	Track	1						
		Hardv	vare							
26	N/A	N/A	M2.5 by 20 Long SHCS	2**						
27	N/A	N/A	M3 by 6 Long FHCS	2**						
28	N/A	N/A	M3 by 6 Long SHCS	4**						
29	N/A	N/A	M4 by 12 Long BHCS	2**						
30	N/A	N/A	M4 by 50 Long SHCS	2**						
31	N/A	N/A	M8 by 35 Long BHCS	1**						
32	N/A	N/A	2.5mm by 8 Lg Roll Pin	3**						
** Available from an industrial supply company such as MSC (1-800-645-7270).										

UNCONTROLLED COPY Doc No: ATS-638950700 Page 3 of 5 Release Date: 10-07-08 Revision: A

Revision Date: 10-07-08



Doc No: ATS-638950700 Revision: A Release Date: 10-07-08 Revision Date: 10-07-08

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.

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UNCONTROLLED COPY Doc No: ATS-638950700 Release Date: 10-07-08 Page 5 of 5 Revision Date: 10-07-08 Revision: A