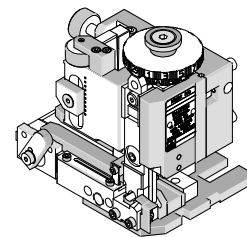


Mini-Mac Applicator

molex®

Application Tooling Specification Sheet


Order No. 63832-6000

FEATURES

- Directly adapts to most automatic wire processing machines
- Applicator designed to industry standard mounting and shut height 135.80mm (5.346")
- Quick setup 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: Male and Female Power Contact Crimp Terminals, 10-12 AWG and 14 AWG Doubles.

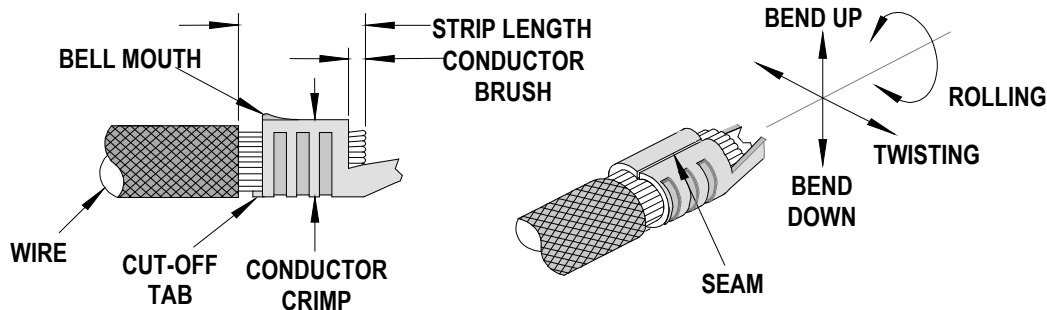
Terminal Series No.	* Terminal Order No.				Wire Size		♦ Insulation Diameter Maximum		Strip Length	
					AWG	mm ²	mm	In.	mm	In.
44262	44262-4302	44262-4432	44262-6310	44262-6321	10-12 14 (2)	5.26-3.31	♦ 4.87	.192	6.35	.250
	44262-4332	44262-4502	44262-6311	44262-6322						
	44262-4402	44262-4532	44262-6320							
173693	173693-4632				10-12 14 (2)	5.26-3.31	♦ 4.87	.192	6.35	.250

63832-6000 applicator is set up to crimp Male terminals. To crimp female terminals, perishable tooling setup needs to be changed.
No additional parts are required.

* See Changeover Parts on page 3 for each terminal listed.

- ♦ For 14 (2) crimps, the maximum wire insulation diameter is 2.66mm each (UL1007 wire or equivalent).
Use of larger O.D. insulation will have a strands out situation.

DEFINITION OF TERMS



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

CRIMP SPECIFICATION

Terminal Series No.	Bell Mouth		Cut-Off Tab Maximum		Conductor Brush	
	mm	In.	mm	In.	mm	In.
44262	0.25-1.25	.010-.049	0.50	.020	0.64-1.90	.025-.075
173693						

Terminal Series No.	Bend Up	Bend Down	Twist	Roll	Punch Width (Ref)				Seam
	Degree		Degree		Conductor		Insulation		
					mm	In.	mm	In.	
44262	3	3	3	3	4.80	.189	N/A	N/A	Seam shall not be open, and no wire allowed out of the crimping area
173693									

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.
44262	10	5.26	3.25-3.35	.128-.132	5.00	.197	356.0	80.0
	12	3.31	3.00-3.10	.118-.122	5.00	.197	311.5	70.0
	14 (2)	2.08	3.17-3.27	.125-.129	5.00	.197	222.6	50.0
173693	10	5.26	3.25-3.35	.128-.132	5.00	.197	356.0	80.0
	12	3.31	3.00-3.10	.118-.122	5.00	.197	311.5	70.0
	14 (2)	2.08	3.17-3.27	.125-.129	5.00	.197	222.6	50.0

*This applicator was qualified to the above specifications with UL 1015 wire.

The above specifications are guidelines to an optimum crimp.

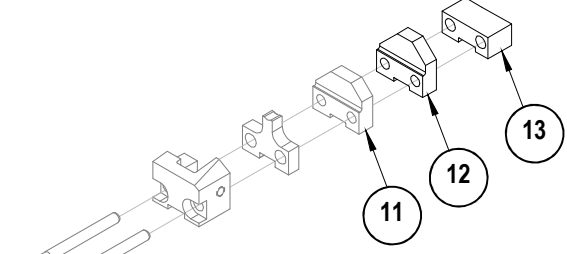
Note:

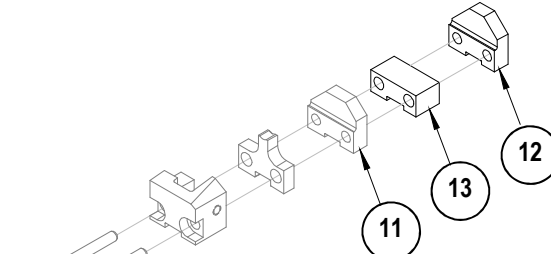
- 63832-6000 applicator is set up to crimp male terminals.
- To crimp female terminals, the perishable tooling setup needs to be changed.
- No additional parts are required.

*See Changeover Parts on page 3 for each terminal listed.

*Changeover Parts

The following charts show the different locations for the spacers when crimping male or female terminals:

Terminal Series No.	Terminal Order No.			
44262 (Male)	44262-6310	44262-6311	44262-6320	44262-6321
	44262-6312	44262-6322		
173693	173693-4632			
Note: To properly crimp these terminals, assemble spacers with cutoff tooling as shown in Figure 1. See also parts list and assembly drawing.				
 Figure 1		Item No.	Order No.	Description
		11	63443-1721	19.10mm Spacer
		12	63443-1734	20.40mm Spacer
		13	63443-2212	12.00mm Spacer

Terminal Series No.	Terminal Order No.			
44262 (Female)	44262-4302	44262-4332	44262-4402	44262-4432
Note: To properly crimp these terminals, assemble spacers with cutoff tooling as shown in Figure 1. See also parts list and assembly drawing.				
 Figure 2		Item No.	Order No.	Description
		11	63443-1721	19.10mm Spacer
		13	63443-2212	12.00mm Spacer
		12	63443-1734	20.40mm Spacer

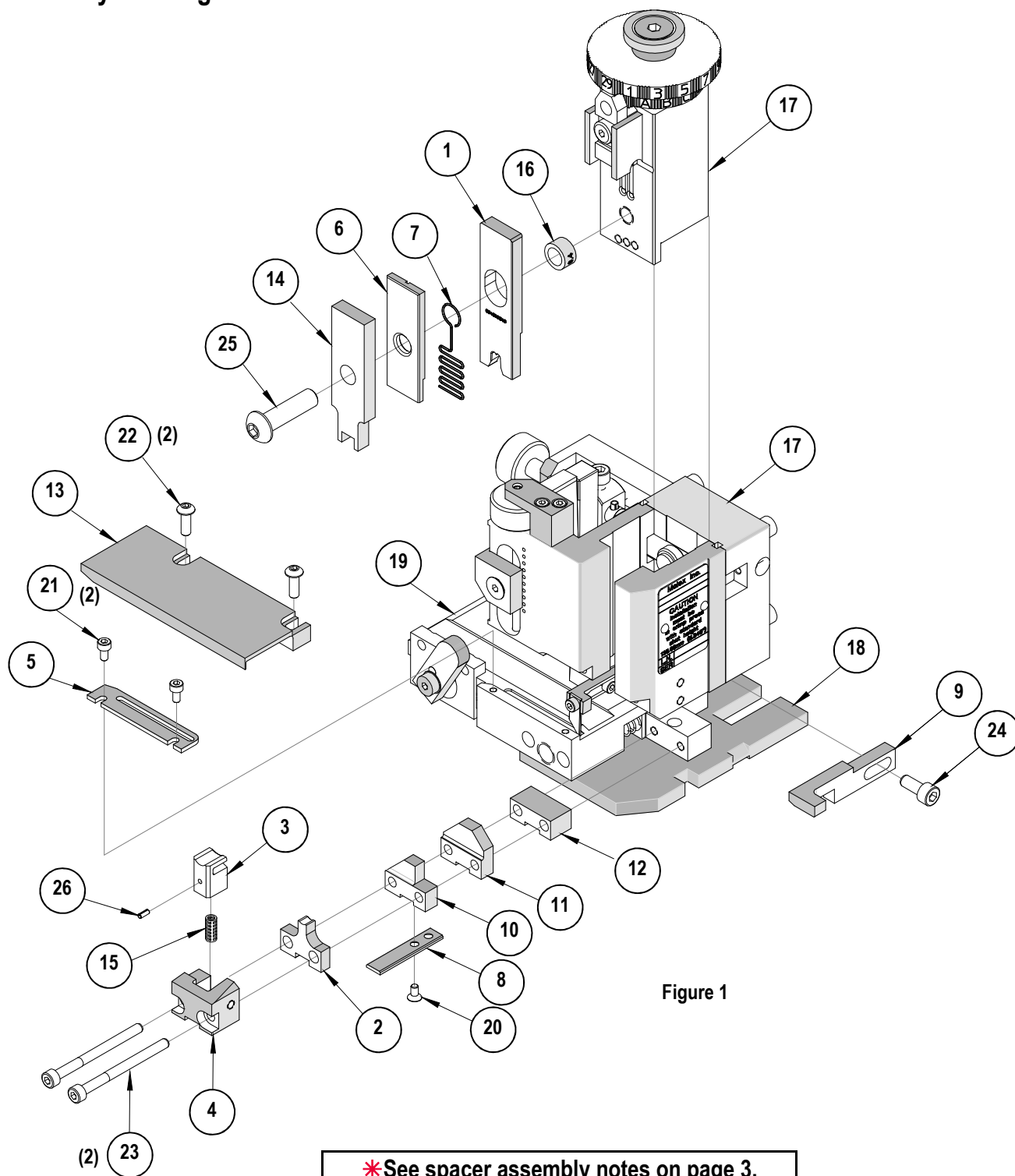
PARTS LIST

Mini-Mac Applicator 63832-6000				
Item	Order No.	Engineering No.	Description	Quantity
Perishable Tooling				
	63832-6070	63832-6070	Tool Kit (All "Y" Items)	REF
1	63465-0048	63465-0048	Conductor Punch	1 Y
2	63455-0037	63455-0037	Conductor Anvil	1 Y
3	63443-0095	63443-0095	Front Cut-Off Plunger	1 Y
4	63890-0487	63890-0487	Front Plunger Retainer	1 Y
Other Components (REF 326150)				
5	63821-0012	63821-0012	Feed Guide	1
6	11-18-4848	60800A123	Spring Retainer	1
7	63443-7330	63443-7330	Wire Hold Down Spring	1
8	63443-0025	63443-0025	Key	1
9	63821-0015	63821-0015	Wire Stop	1
10	*63443-1721	63443-1721	19.10mm Spacer	1
11	*63443-1734	63443-1734	20.40mm Spacer	1
12	*63443-2212	63443-2212	12.00mm Spacer	1
13	63443-6130	63443-6130	Rear Cover	1
14	63466-0509	63466-0509	Striker-Flat Bottom	1
15	63700-0539	63700-0539	Compression Spring	1
16	63890-0866	63890-0866	Bushing-Punch (Conductor)	1
Frame				
17	63801-3201	63801-3201	Top	1
18	63801-3281	63801-3281	Base	1
19	63801-4650	63801-4650	Track	1
Hardware				
20	N/A	N/A	M3 by 6 Long FHCS	1**
21	N/A	N/A	M3 by 6 Long SHCS	2**
22	N/A	N/A	M4 by 12 Long BHCS	2**
23	N/A	N/A	M4 by 50 Long SHCS	2**
24	N/A	N/A	M5 by 12 Long SHCS	1**
25	N/A	N/A	M8 by 30 Long BHCS	1**
26	N/A	N/A	2mm by 5 Long Roll Pin	1**

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

***See spacer assembly notes on page 3.**

Assembly Drawing



NOTES

1. Molex recommends that an extra perishable tooling kit be maintained at your facility.
2. Verify tooling alignment by manually cycling the press with the 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.

Application Tooling Support

Phone: (402) 458-TOOL (8665)

E-Mail: applicationtooling@molex.com

Website: www.molex.com/applicationtooling

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