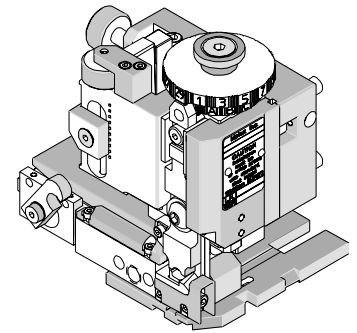




# Mini-Mac Applicator Specification Sheet Order No. 63894-1000



## 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.

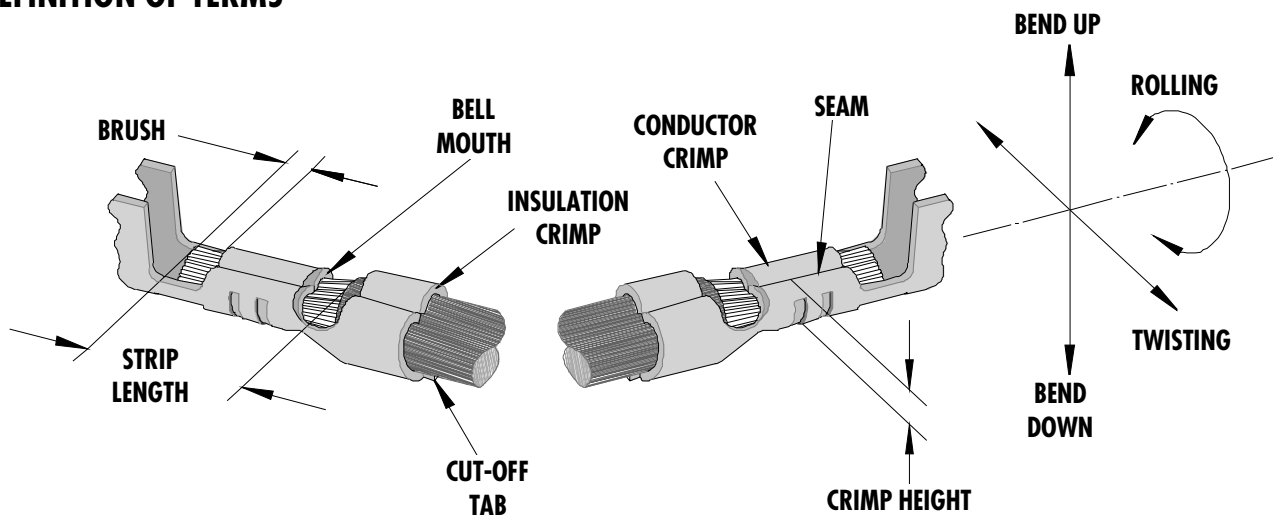
## SCOPE

Products: Flat Blade Crimp Terminals, 16-20 AWG.

Terminal Series No.	Terminal Order No	Wire Size		Insulation Diameter Max.		Strip Length	
		AWG	mm <sup>2</sup>	mm	In.	mm	In.
1508	05-06-0117	16-20	1.30-0.50	3.55	.140	3.96-5.35	.156-.218
2776	Ⓟ	16-20	1.30-0.50	3.55	.140	3.96-5.35	.156-.218

For 14 AWG and double wire crimp applications 63894-1100 is recommended.  
Ⓟ Consult your Molex sales representative for details.

## 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 Max.		Conductor Brush	
	mm	In.	mm	In.	mm	In.
1508						
2776			0.50	.020		

Terminal Series No.	Bend up	Bend down	Twist	Roll	Punch Width (Ref)			
	Degree		Degree		Conductor		Insulation	
					mm	In.	mm	In.
1508					2.30	.091	3.10	.122
2776					2.30	.091	3.10	.122

**Seam**  
Seam shall not be open and no wire allowed out of the crimping area  
16 AWG UL Style 1015 may have pinched strands or an open seam. This condition is normal and does not effect crimp performance. The customer should determine suitability for the end application.

**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	
			Crimp Height		Crimp Width			
	AWG	mm <sup>2</sup>	mm	In.	mm	In.	N	Lb.
1508	16	1.30	1.60-1.70	.063-.067	2.30-2.47	.091-.097	191.3	43.00
	18	0.80	1.47-1.55	.058-.061	2.30-2.45	.091-.096	120.1	27.00
	20	0.50	1.37-1.45	.054-.057	2.30-2.42	.091-.095	89.0	20.00
2776	16	1.30	1.60-1.70	.063-.067	2.30-2.47	.091-.097	191.3	43.00
	18	0.80	1.47-1.55	.058-.061	2.30-2.45	.091-.096	120.1	27.00
	20	0.50	1.37-1.45	.054-.057	2.30-2.42	.091-.095	89.0	20.00

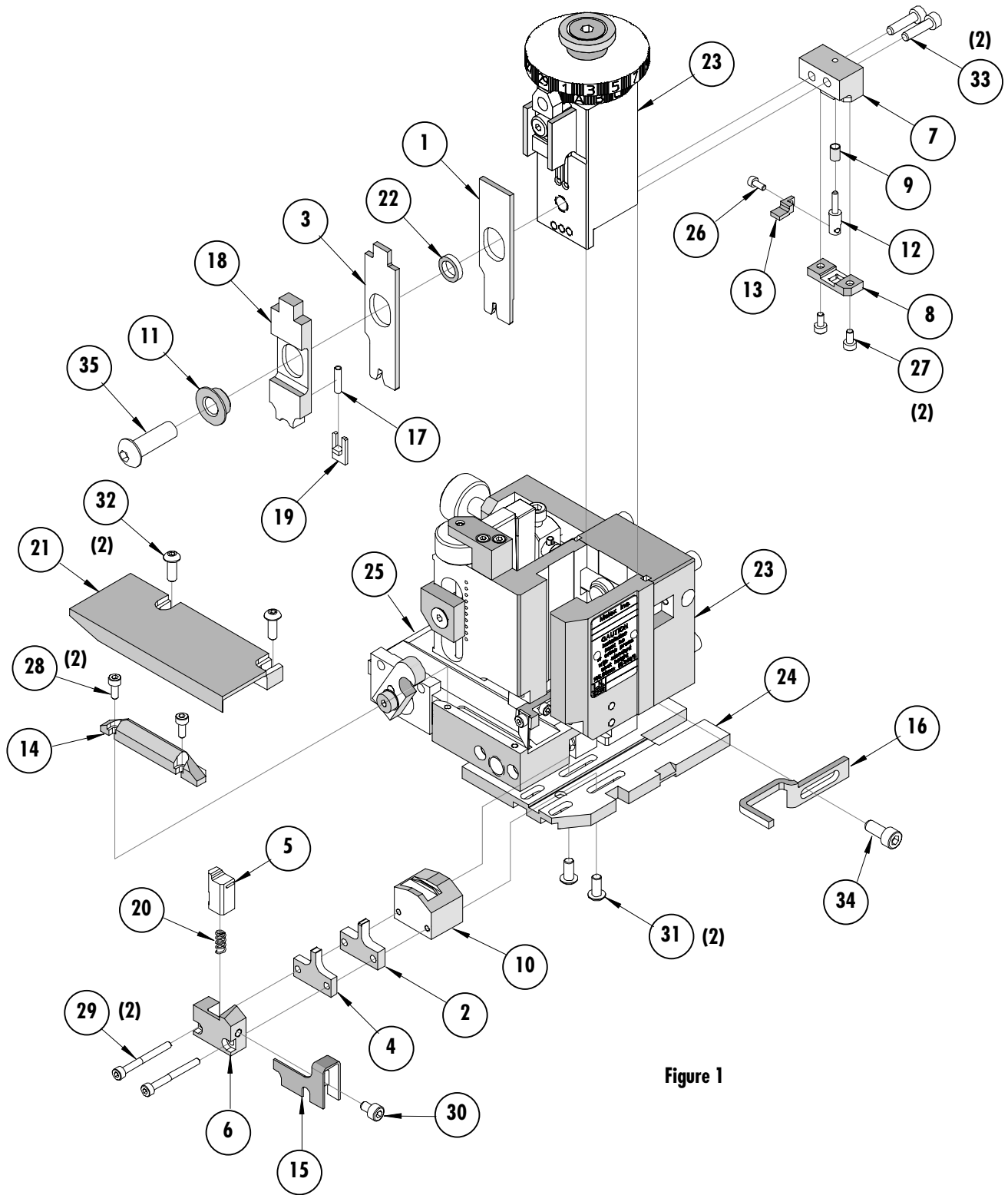
Pull Force should be measured with no influence from the insulation crimp.

The above specifications are guidelines to an optimum crimp.

**PARTS LIST**

<b>Mini-Mac Applicator 63894-1000</b>				
<b>Item</b>	<b>Order No</b>	<b>Engineering No.</b>	<b>Description</b>	<b>Quantity</b>
<b>Perishable Tooling</b>				
	63894-1070	63894-1070	Tool Kit (All "Y" Items)	REF
1	11-18-5061	60811A106	Conductor Punch	1 Y
2	11-18-4896	60804A102	Conductor Anvil	1 Y
3	11-18-5062	60811A108	Insulation Punch	1 Y
4	11-18-5063	60811A109	Insulation Anvil	1 Y
5	11-18-5376	60804F144	Front Cut-Off Plunger	1 Y
6	11-18-5375	60804F143	Front Cut-off Plunger Retainer	1 Y
<b>Other Components (941050)</b>				
7	11-18-5005	60800D112	Hold Down Block	1
8	11-18-5006	60800D113	Spring Retainer	1
9	11-18-5007	60800D114	Compression Spring (Hold Down)	1
10	11-18-5064	60811A111	Anvil Mount	1
11	11-18-5065	60811A115	Tooling Washer	1
12	11-18-5067	60811A121	Hold Down Plunger	1
13	11-18-5068	60811A122	Hold Down 1508 Terminal	1
14	11-18-5110	60804A129	Front Cover	1
15	11-18-5114	60804A130	Scrap Deflector	1
16	11-18-5115	60805A119	Wire Stop	1
17	11-18-5116	60804A141	Compression Spring (Knock out)	1
18	11-18-5352	60804D140	Front Plunger Striker	1
19	11-18-5374	60804F142	Knockout Blade	1
20	11-24-1067	4996-4	Cut Off Plunger Spring	1
21	63443-6125	63443-6125	Rear Cover	1
22	63803-5118	63803-5118	Conductor Bushing	1
<b>Frame</b>				
23	63801-3201	63801-3201	Top	1
24	63801-3282	63801-3282	Base	1
25	63801-6550	63801-6550	Track	1
<b>Hardware</b>				
26	N/A	N/A	M2.5 by 6 Long SHCS	1**
27	N/A	N/A	M3 by 6 Long SHCS	2**
28	N/A	N/A	M3 by 8 Long SHCS	2**
29	N/A	N/A	M3 by 20 Long SHCS	2**
30	N/A	N/A	M4 by 6 Long SHCS	1**
31	N/A	N/A	M4 by 8 Long BHCS	2**
32	N/A	N/A	M4 by 12 Long BHCS	2**
33	N/A	N/A	M4 by 16 Long SHCS	2**
34	N/A	N/A	M5 by 14 Long SHCS	1**
35	N/A	N/A	M8 by 20 Long BHCS	1**
** Available from an industrial supply company such as MSC (1-800-645-7270).				

### Assembly Drawing



## 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.

### 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>