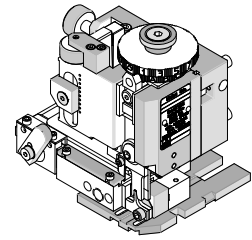




**Mini-Mac  
Applicator**

**Application Tooling  
Specification Sheet**



**Order No. 63888-7000**

**FEATURES**

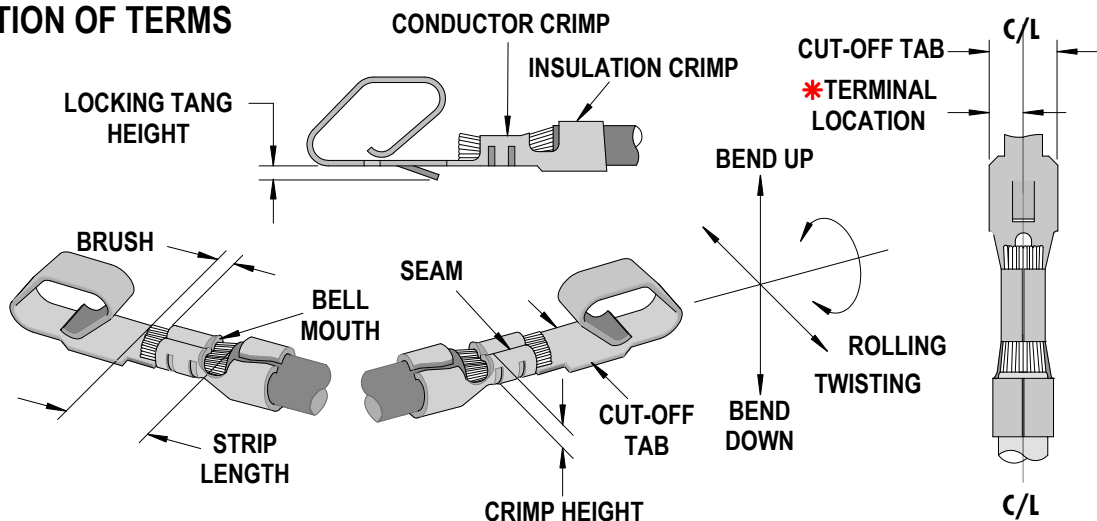
- Directly adapts to most automatic wire processing machines
- Applicator designed to industry standard mounting and shut height 135.80mm (5.346")
- Quick set-up time; plus the crimp height, track and feed adjustments can be set without removing the applicator from the press
- Fine adjustment allows 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: KK® Cat Ear and Anti Fish Hook Crimp Terminals, 22-30 AWG.

Terminal Series No.	Terminal Order No.				Wire Size		Insulation Diameter		Strip Length	
					AWG	mm <sup>2</sup>	mm	In.	mm	In.
4809	08-50-0030	08-50-0031	08-50-0033	08-50-0135	22-30	0.35-0.05	1.12-1.57	.044-.062	2.54-3.18	.100-.125
	08-55-0110	08-55-0112	08-56-0120	08-56-0158						
	40-01-0829	97-00-0450	97-00-0452							
8088	08-52-0103	08-52-0105	08-52-0107	08-65-0105	22-30	0.35-0.05	1.12-1.57	.044-.062	2.54-3.18	.100-.125
	40-07-0812	97-00-0225	97-00-0227							

**DEFINITION OF TERMS**



\* 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.

## CRIMP SPECIFICATIONS

Terminal Series No.	Bell mouth		*Cut-off Tab		Conductor Brush	
	mm	In.	mm	In.	mm	In.
4809			1.85-1.98	.073-.078		
8088			1.85-1.98	.073-.078		

Terminal Series No.	Locking Tang Height		Bend up	Bend down	Twist	Roll	Punch Width (Ref)				Seam  Seam shall not be open and no wire allowed out of the crimping area
	mm	In	Degree	Degree			Conductor		Insulation		
							mm	In	mm	In	
4809	0.64	.025	3	3	4	8	1.60	.063	1.68	.066	
8088	0.64	.025	3	3	4	8	1.60	.063	1.68	.066	

**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 <sup>2</sup>	Crimp Height		Crimp Width (Ref)		N	Lb.
			mm	In.	mm	In.		
4809	22	0.35	0.79-0.84	.031-.033			44.88	10.0
	24	0.20	0.74-0.79	.029-.031			35.59	8.0
	26	0.12	0.68-0.74	.027-.029			26.69	6.0
	28	0.08	0.66-0.71	.026-.028			17.79	4.0
	30	0.05	0.63-0.66	.026-.027			13.34	3.0
8088	22	0.35	0.79-0.84	.031-.033			44.88	10.0
	24	0.20	0.74-0.79	.029-.031			35.59	8.0
	26	0.12	0.68-0.74	.027-.029			26.69	6.0
	28	0.08	0.66-0.71	.026-.028			17.79	4.0
	30	0.05	0.63-0.66	.026-.027			13.34	3.0

### 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.

**PARTS LIST**

<b>Mini-Mac Applicator 63888-7000</b>				
<b>Item</b>	<b>Order No</b>	<b>Engineering No.</b>	<b>Description</b>	<b>Quantity</b>
<b>Perishable Tooling</b>				
	63888-7070	63888-7070	Tool Kit (All "Y" Items)	REF
1	11-18-4684	60756A101	Conductor Punch	1 Y
2	11-18-4685	60756A102	Conductor Anvil	1 Y
3	11-18-4686	60756A103	Insulation Punch	1 Y
4	11-18-4687	60756A104	Insulation Anvil	1 Y
5	11-18-4688	60756A105	Cut-Off Insert	1 Y
6	11-18-4689	60756A106	Cut-off Punch	1 Y
<b>Other Components</b>				
7	11-18-4003	60703-5	Front Cover	1
8	11-18-4348	60722A108	Tooling Washer	1
9	11-18-4469	60703-20	Retainer Block	1
10	11-18-4678	60756A111	Wire Stop	1
11	11-18-4754	60756A118	Terminal Stop and Scrap Shield	1
12	63803-5105	63803-5105	Conductor Bushing	1
13	63820-0012	63820-0012	Cover-Drag Frame	1
14	63888-7001	63888-7001	Cover Plate	1
<b>Frame</b>				
15	63801-3201	63801-3201	Top	1
16	63801-3283	63801-3283	Base	1
17	63443-6204	63443-6204	Track	1
<b>Hardware</b>				
18	N/A	N/A	M3 by 6 Long SHCS	2**
19	N/A	N/A	M3 by 8 Long SHCS	2**
20	N/A	N/A	M4 by 8 Long SHCS	2**
21	N/A	N/A	M4 by 12 Long BHCS	2**
22	N/A	N/A	M5 by 10 Long SHCS	1**
23	N/A	N/A	M8 by 20 Long BHCS	1**
24	N/A	N/A	#6-32 by 1/2" Long BHCS	2**
25	N/A	N/A	#10-32 by 1-1/4" Long SHCS	1**
** Available from an industrial supply company such as MSC (1-800-645-7270).				

### Assembly Drawing

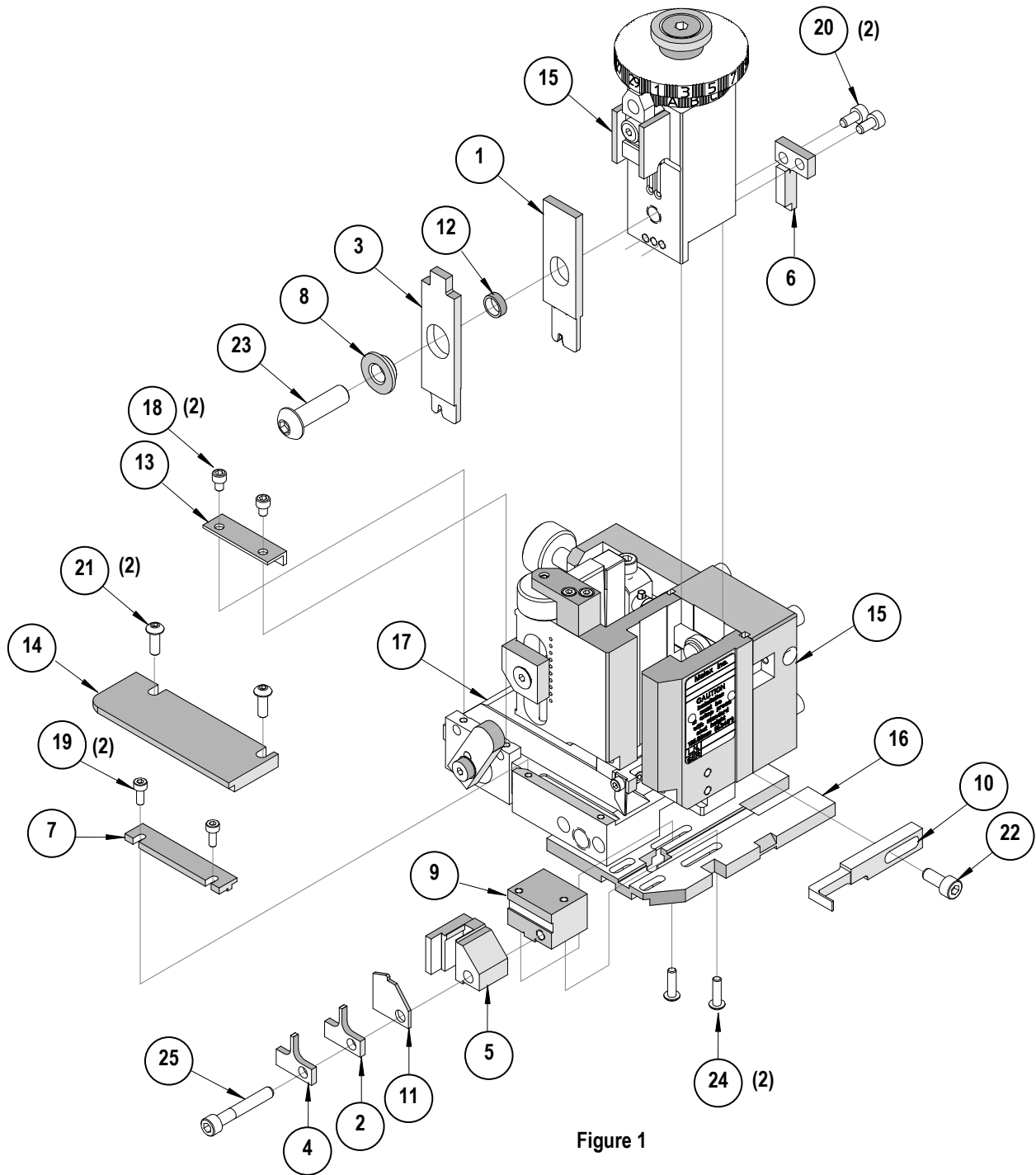


Figure 1

## 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 135.8 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.

<http://www.molex.com>