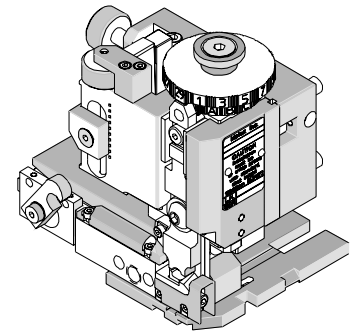




# Mini-Mac Applicator Specification Sheet Order No. 63892-3000



## FEATURES

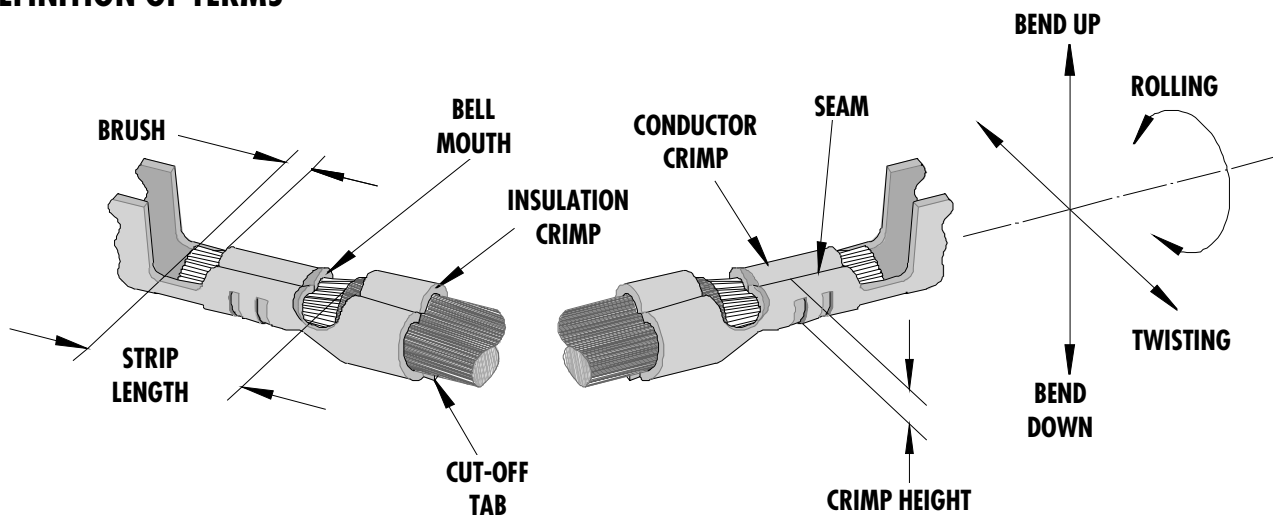
- Directly adapts to most automatic wire processing machines
- Applicator designed to industry standard mounting and shut height 135.80mm (5.346")
- Quick set-up time; plus the crimp height, track and feed adjustments can be set without removing the applicator from the press
- Fine adjustment allows 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: 2.00mm (.079") Diameter Pin and Socket Terminals, 14-20 AWG.

Terminal Series No.	Terminal Order No	Wire Size		Insulation Diameter		Strip Length	
		AWG	mm <sup>2</sup>	mm	In.	mm	In.
35727	35727-0201	14-20	2.00-.050	1.90-3.40	.075-.134	4.70-5.40	.185-.212
35728	35728-0201	14-20	2.00-.050	1.90-3.40	.075-.134	4.70-5.40	.185-.212

## 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		Conductor Brush	
	mm	In.	mm	In.	mm	In.
35727						
35728						

Terminal Series No.	Bend up	Bend down	Twist	Roll	Punch Width (Ref)				Seam Seam shall not be open and no wire allowed out of the crimping area
	Degree		Degree		Conductor		Insulation		
					mm	In.	mm	In.	
35727					2.30	.090	3.87	.152	
35728					2.30	.090	3.87	.152	

**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 (Ref.)			
	AWG	mm <sup>2</sup>	mm	In.	mm	In.	N	Lb.
35727	14	2.00	1.62-1.75	.065-.069			177.9	40.0
	16	1.30	1.42-1.52	.056-.060			160.1	36.0
	18	0.80	1.26-1.33	.0495-.0525			106.8	24.0
	20	0.50	1.18-1.26	.0465-.0495			71.1	16.0
35728	14	2.00	1.62-1.75	.065-.069			177.9	40.0
	16	1.30	1.42-1.52	.056-.060			160.1	36.0
	18	0.80	1.26-1.33	.0495-.0525			106.8	24.0
	20	0.50	1.18-1.26	.0465-.0495			71.1	16.0

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 63892-3000</b>				
<b>Item</b>	<b>Order No</b>	<b>Engineering No.</b>	<b>Description</b>	<b>Quantity</b>
<b>Perishable Tooling</b>				
	63892-3070	63892-3070	Tool Kit (All "Y" Items)	REF
1	11-18-5000	60825A106	Conductor Punch	1 Y
2	11-18-5204	60825A107	Conductor Anvil	1 Y
3	11-18-5205	60825A108	Insulation Punch	1 Y
4	11-18-5206	60825A109	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</b>				
7	11-18-4898	60804A104	Anvil Mount	1
8	11-18-5005	60800D112	Hold Down Block	1
9	11-18-5006	60800D113	Spring Retainer	1
10	11-18-5007	60800D114	Compression Spring (Hold Down)	1
11	11-18-5008	60800D115	Hold Down Plunger	1
12	11-18-5111	60804A140	Knock-Out Blade	1
13	11-18-5114	60804A130	Scrap Deflector	1
14	11-18-5115	60805A119	Wire Stop	1
15	11-18-5116	60804A141	Compression Spring (Knock-Out)	1
16	11-18-5207	60825A115	Tooling Washer	1
17	11-18-5352	60804D140	Front Plunger Striker	1
18	11-18-5442	60843A123	Front Cover	1
19	11-24-1067	4996-4	Cut-off Plunger Spring	1
20	63443-6121	63443-6121	Rear Cover	1
21	63803-5115	63803-5115	Conductor Bushing	1
<b>Frame</b>				
22	63801-3201	63801-3201	Top	1
23	63801-3282	63801-3282	Base	1
24	63801-6550	63801-6550	Track	1
<b>Hardware</b>				
25	N/A	N/A	M3 by 6 Long SHCS	4**
26	N/A	N/A	M3 by 20 Long SHCS	2**
27	N/A	N/A	M4 by 6 Long SHCS	1**
28	N/A	N/A	M4 by 8 Long BHCS	2**
29	N/A	N/A	M4 by 12 Long BHCS	2**
30	N/A	N/A	M4 by 16 Long SHCS	2**
31	N/A	N/A	M5 by 12 Long SHCS	1**
32	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

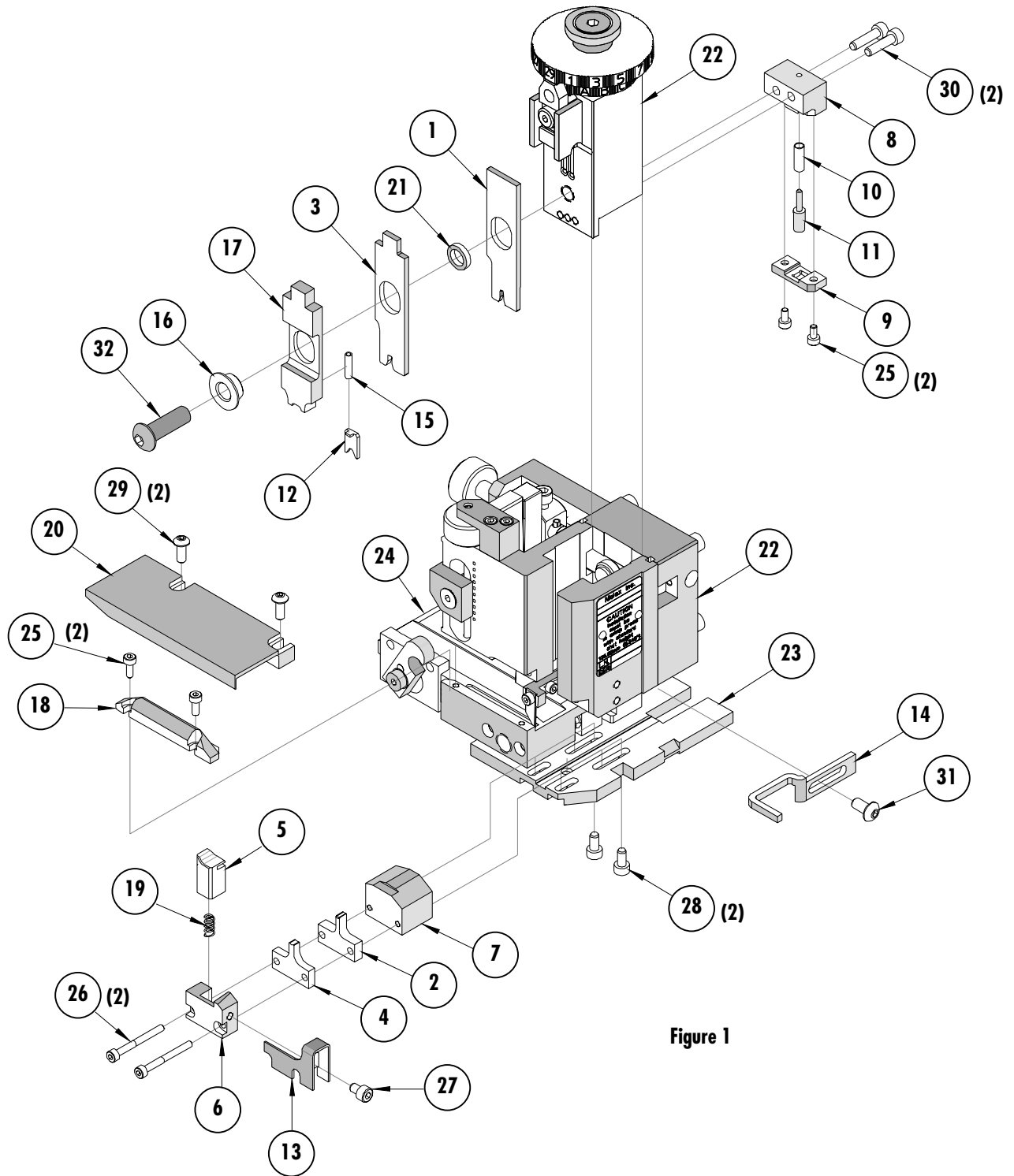


Figure 1

## 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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