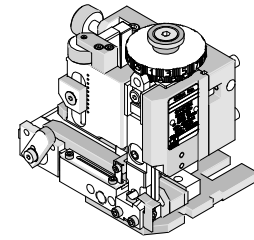




**Mini-Mac  
Applicator**

**Application Tooling  
Specification Sheet**



**Order No. 63891-7000**

**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.

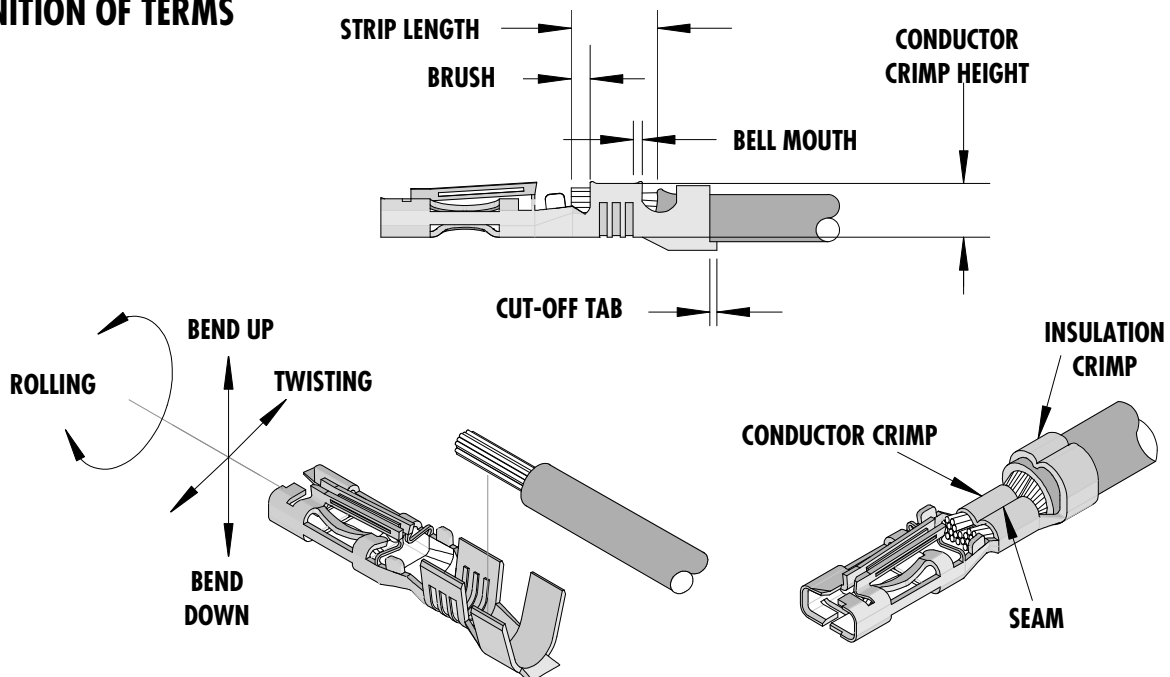
**SCOPE**

Products: Sabre™ Female Flat Blade Crimp Terminal, (2) 18 AWG.

Terminal Series No.	Terminal Order No.	Wire Size		Insulation Diameter		Strip Length	
		AWG	mm <sup>2</sup>	mm	In.	mm	In.
43374	43374-1001	18 (2)	0.80 (2)	2.80 (2)	.110 (2)	3.96-5.54	.156-.218
43375	43375-1001	18 (2)	0.80 (2)	2.80 (2)	.110 (2)	3.96-5.54	.156-.218

This applicator provides a special narrow insulation crimp. For use in 6313, 43275, and 41644-24 housings.  
For standard 4.80mm wide insulation crimp applications, use 63891-6100 applicator.

**DEFINITION OF TERMS**



**CRIMP SPECIFICATIONS**

Terminal Series No.	Bell mouth		Cut-off Tab Max.		Conductor Brush	
	mm	In.	mm	In.	mm	In.
43374	0.20-0.50	.008-.020	0.30	.012	0.76 Max.	.030 Max.
43375	0.20-0.50	.008-.020	0.30	.012	0.76 Max.	.030 Max.

Terminal Series No.	Bend up	Bend down	Twist	Roll	Punch Width (Ref)				Seam
					Conductor		Insulation		
	Degree		Degree		mm	In	mm	In	
43374	3	3	4	8	2.50	.098	3.90	.154	Seam shall not be open and no wire allowed out of the crimping area
43375	3	3	4	8	2.50	.098	3.90	.154	

After crimping, the conductor profile should measure the following.

Terminal Series No.	Wire Size		Conductor Crimp Height		Pull Force Minimum	
	AWG	mm <sup>2</sup>	mm	In.	N	Lb.
43374	18 (2)	0.80 (2)	1.47-1.57	.058-.062	88.9	20
43375	18 (2)	0.80 (2)	1.47-1.57	.058-.062	88.9	20

\* 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 63891-7000</b>				
<b>Item</b>	<b>Order No</b>	<b>Engineering No.</b>	<b>Description</b>	<b>Quantity</b>
<b>Perishable Tooling</b>				
	63891-7070	63891-7070	Tool Kit (All "Y" Items)	REF
1	11-18-5418	60843A106	Conductor Punch	1 Y
2	63445-2562	63445-2562	Conductor Anvil	1 Y
3	11-18-5414	60842A108	Insulation Punch	1 Y
4	63445-3947	63445-3947	Insulation Anvil	1 Y
5	63443-0002	63443-0002	Front Cut-Off Plunger	1 Y
6	63443-0012	63443-0012	Cut-off Plunger Retainer	1 Y
<b>Other Components</b>				
7	11-18-5007	60800D114	Hold Down Plunger Spring	1
8	11-18-5115	60805A119	Wire Stop/Stripper	1
9	11-18-5410	60832A141	Hold Down Block	1
10	11-18-5411	60832A142	Spring Retainer	1
11	11-18-5412	60832A143	Hold Down Plunger	1
12	11-18-5420	60843A111	Anvil Mount	1
13	11-18-5442	60843A123	Front Cover	1
14	11-24-1067	4996-4	Cut-off Plunger Spring	1
15	63443-0009	63443-0009	Scrap Chute	1
16	63443-0021	63443-0021	Lower Tooling Key	1
17	63443-6125	63443-6125	Rear Cover	1
18	63803-5105	63803-5105	Conductor Bushing	1
19	63830-3001	63830-3001	Plunger Striker	1
20	63830-3005	63830-3005	Tooling Washer	1
<b>Frame</b>				
21	63801-3201	63801-3201	Top	1
22	63801-3282	63801-3282	Base	1
23	63801-6550	63801-6550	Track	1
<b>Hardware</b>				
24	N/A	N/A	M3 by 6 Long SHCS	4**
25	N/A	N/A	M4 by 6 Long SHCS	1**
26	N/A	N/A	M4 by 10 Long BHCS	2**
27	N/A	N/A	M4 by 12 Long BHCS	2**
28	N/A	N/A	M4 by 12 Long SHCS	2**
29	N/A	N/A	M4 by 25 Long SHCS	2**
30	N/A	N/A	M5 by 10 Long SHCS	1**
31	N/A	N/A	M8 by 20 Long BHCS	1**
32	N/A	N/A	3MM by 6 Long Roll Pin	1**
** Available from an industrial supply company such as MSC (1-800-645-7270).				

### Assembly Drawing

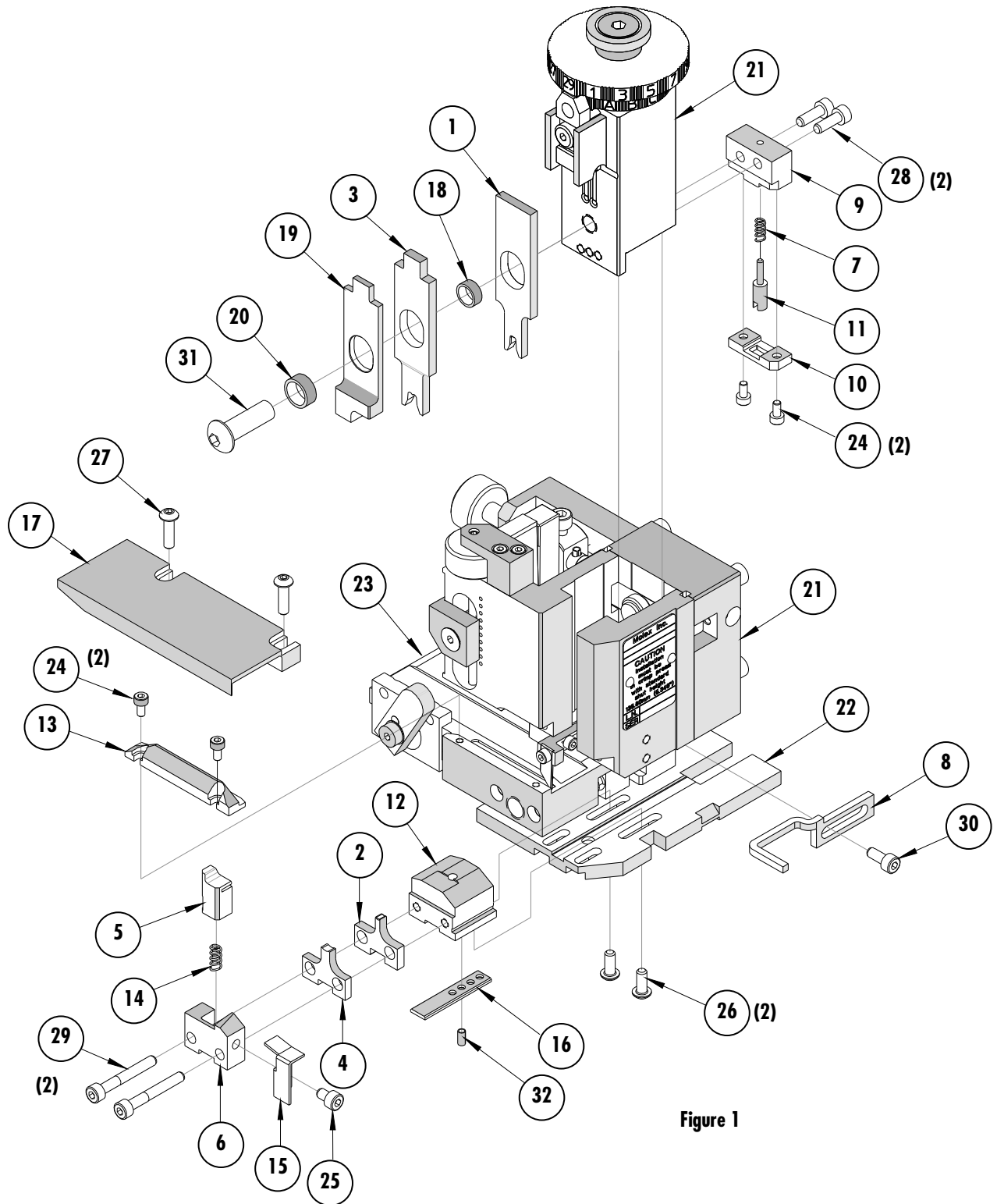


Figure 1

## 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.

Visit our Web site at <http://www.molex.com>

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