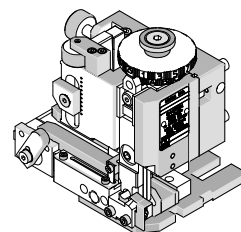


**Mini-Mac  
Applicator**



**Application Tooling  
Specification Sheet**



**Order No. 63892-7300**

**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: 2.36mm (.093") Diameter, Standard .093" Pin and Socket Crimp Terminal, 14-20 AWG.

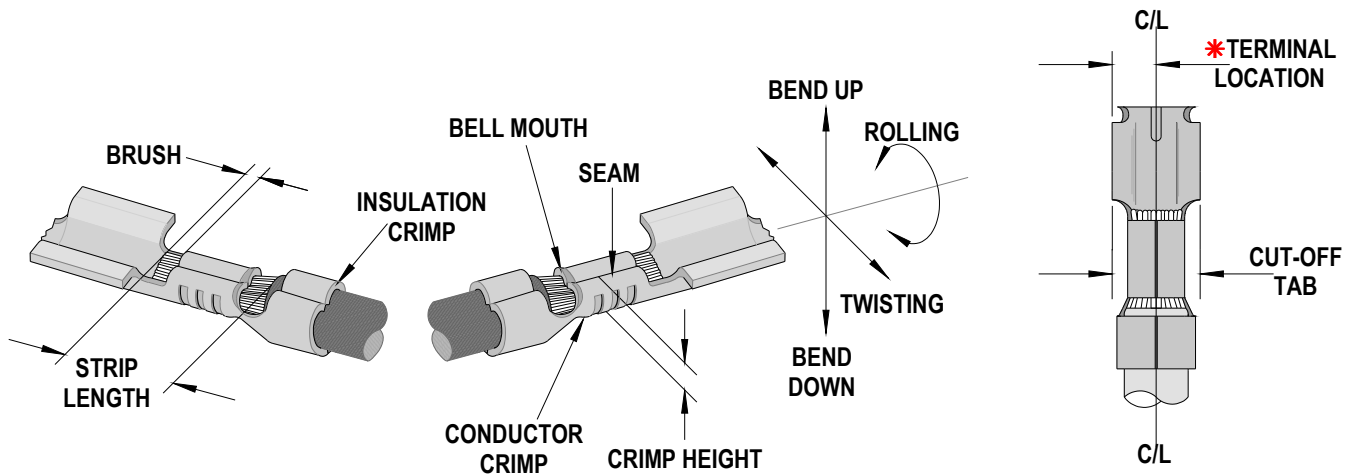
Terminal Series No.	Terminal Order No.			Wire Size		*Insulation Diameter		Strip Length	
				AWG	mm <sup>2</sup>	mm	In.	mm	In.
1189	02-09-1101	02-09-5102	39-00-0290	14-20	2.00-0.50	1.65-4.06	.065-.160	3.96-5.54	.156-.218
	02-09-1102	39-00-0071	39-00-0292						
	02-09-3101	39-00-0135	39-00-0293						
	02-09-3103	39-00-0281	50-29-1617						
	02-09-5100	39-00-0282							
	02-09-1101	02-09-5102	39-00-0290	**18 DBL.	0.80 (2)	1.65-4.06	.065-.160	3.96-5.54	.156-.218
	02-09-1102	39-00-0071	39-00-0292						
	02-09-3101	39-00-0135	39-00-0293						
	02-09-3103	39-00-0281	50-29-1617						
	02-09-5100	39-00-0282							
1190	02-09-2101	02-09-6101	39-00-0298	14-20	2.00-0.50	1.65-4.06	.065-.160	3.96-5.54	.156-.218
	02-09-4101	39-00-0105	39-00-0300						
	02-09-6100	39-00-0296							
	02-09-2101	02-09-6101	39-00-0298	**18 DBL.	0.80 (2)	1.65-4.06	.065-.160	3.96-5.54	.156-.218
	02-09-4101	39-00-0105	39-00-0300						
	02-09-6100	39-00-0296							
1450	02-09-2301	02-09-2302	02-09-2306	14-20	2.00-0.50	1.65-4.06	.065-.160	3.96-5.54	.156-.218
1451	02-09-1301	02-09-1302		14-20	2.00-0.50	1.65-4.06	.065-.160	3.96-5.54	.156-.218
1973-2	02-09-8108			14-18	2.00-0.80	1.65-4.06	.065-.160	3.96-5.54	.156-.218
	02-09-8108			18 DBL.	0.80 (2)	1.65-4.06	.065-.160	3.96-5.54	.156-.218
4550	02-09-1205	02-09-5169	50-29-1618	14-20	2.00-0.50	1.65-4.06	.065-.160	3.96-5.54	.156-.218
6310	02-09-1209	02-09-5205		14-20	2.00-0.50	1.65-4.06	.065-.160	3.96-5.54	.156-.218

\*\* The above application does not conform to the current product specification.

\* This applicator is for 2.54-4.06 (.100-.160") insulation diameters and double crimp applications.

See applicator 63892-7100 for 1.65-2.79 (.065-.110") insulation diameters.

### 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.
1189			3.53-3.69	.139-.145		
1190			3.53-3.69	.139-.145		
1450			3.53-3.69	.139-.145		
1451			3.53-3.69	.139-.145		
1973-2			3.53-3.69	.139-.145		
4550			3.53-3.69	.139-.145		
6310			3.53-3.69	.139-.145		

Terminal Series No.	Bend up	Bend down	Twist	Roll	Punch Width (Ref)				Seam
					Conductor		Insulation		
	Degree		Degree		mm	In.	mm	In.	
1189					2.30	.091	3.85	.151	Seam shall not be open and no wire allowed out of the crimping area
1190					2.30	.091	3.85	.151	
1450					2.30	.091	3.85	.151	
1451					2.30	.091	3.85	.151	
1973-2					2.30	.091	3.85	.151	
4550					2.30	.091	3.85	.151	
6310					2.30	.091	3.85	.151	

**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.
1189	14	2.00	1.45-1.55	.057-.061			177.9	40.0
	16	1.30	1.35-1.45	.053-.057			155.6	35.0
	18	0.80	1.27-1.35	.050-.053			133.4	30.0
	20	0.50	1.22-1.32	.048-.052			80.0	18.0
	18 DBL.	0.80 (2)	1.42-1.47	.056-.058			133.4	30.0
1190	14	2.00	1.45-1.55	.057-.061			177.9	40.0
	16	1.30	1.35-1.45	.053-.057			155.6	35.0
	18	0.80	1.27-1.35	.050-.053			133.4	30.0
	20	0.50	1.22-1.32	.048-.052			80.0	18.0
	18 DBL.	0.80 (2)	1.42-1.47	.056-.058			133.4	30.0
1450	14	2.00	1.45-1.55	.057-.061			177.9	40.0
	16	1.30	1.35-1.45	.053-.057			155.6	35.0
	18	0.80	1.27-1.35	.050-.053			133.4	30.0
	20	0.50	1.22-1.32	.048-.052			80.0	18.0
1451	14	2.00	1.45-1.55	.057-.061			177.9	40.0
	16	1.30	1.35-1.45	.053-.057			155.6	35.0
	18	0.80	1.27-1.35	.050-.053			133.4	30.0
	20	0.50	1.22-1.32	.048-.052			80.0	18.0
1973-2	14	2.00	1.45-1.55	.057-.061			177.9	40.0
	16	1.30	1.35-1.45	.053-.057			155.6	35.0
	18	0.80	1.27-1.35	.050-.053			133.4	30.0
	18 DBL.	0.80 (2)	1.42-1.47	.056-.058			133.4	30.0
4550	14	2.00	1.45-1.55	.057-.061			177.9	40.0
	16	1.30	1.35-1.45	.053-.057			155.6	35.0
	18	0.80	1.27-1.35	.050-.053			133.4	30.0
	20	0.50	1.22-1.32	.048-.052			80.0	18.0
6310	14	2.00	1.45-1.55	.057-.061			177.9	40.0
	16	1.30	1.35-1.45	.053-.057			155.6	35.0
	18	0.80	1.27-1.35	.050-.053			133.4	30.0
	20	0.50	1.22-1.32	.048-.052			80.0	18.0

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 63892-7300</b>				
<b>Item</b>	<b>Order No</b>	<b>Engineering No.</b>	<b>Description</b>	<b>Quantity</b>
<b>Perishable Tooling</b>				
	63892-7370	63892-7370	Tool Kit (All "Y" Items)	REF
1	11-18-4805	60800A101	Conductor Punch	1 Y
2	11-18-4872	60800A127	Conductor Anvil	1 Y
3	63803-2302	63803-2302	Insulation Punch	1 Y
4	63803-2301	63803-2301	Insulation Anvil	1 Y
5	11-18-4817	60800A113	Cut-Off Punch	1 Y
6	11-18-4808	60800A104	Rear Cut-off Die	1 Y
<b>Other Components</b>				
7	11-18-4809	60800A105	Tooling Washer	1
8	11-18-4810	60800A106	Rear Block	1
9	11-18-4811	60800A107	Compression Spring	1
10	11-18-4814	60800A110	Plunger	1
11	11-18-4815	60800A111	Guide Plate	1
12	11-18-4816	60800A112	Terminal Drag Plate	1
13	11-18-4818	60800A114	Mounting Block	1
14	11-18-4829	60800A125	Wire Stop	1
15	11-18-4848	60800A123	Spring Retainer	1
16	11-18-4894	60800A129	Knockout Blade	1
17	11-18-5005	60800D112	Hold Down Block	1
18	11-18-5006	60800D113	Spring Retainer	1
19	11-18-5007	60800D114	Compression Spring (Hold Down)	1
20	11-18-5008	60800D115	Hold Down Plunger	1
21	11-18-5015	60805A122	Front Cover	1
22	63803-5120	63803-5120	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	M3 by 6 Long SHCS	6**
27	N/A	N/A	M3 by 25 Long SHCS	2**
28	N/A	N/A	M4 by 6 Long BHCS	2**
29	N/A	N/A	M4 by 8 Long BHCS	2**
30	N/A	N/A	M4 by 10 Long BHCS	2**
31	N/A	N/A	M4 by 20 Long SHCS	2**
32	N/A	N/A	M5 by 10 Long SHCS	1**
33	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

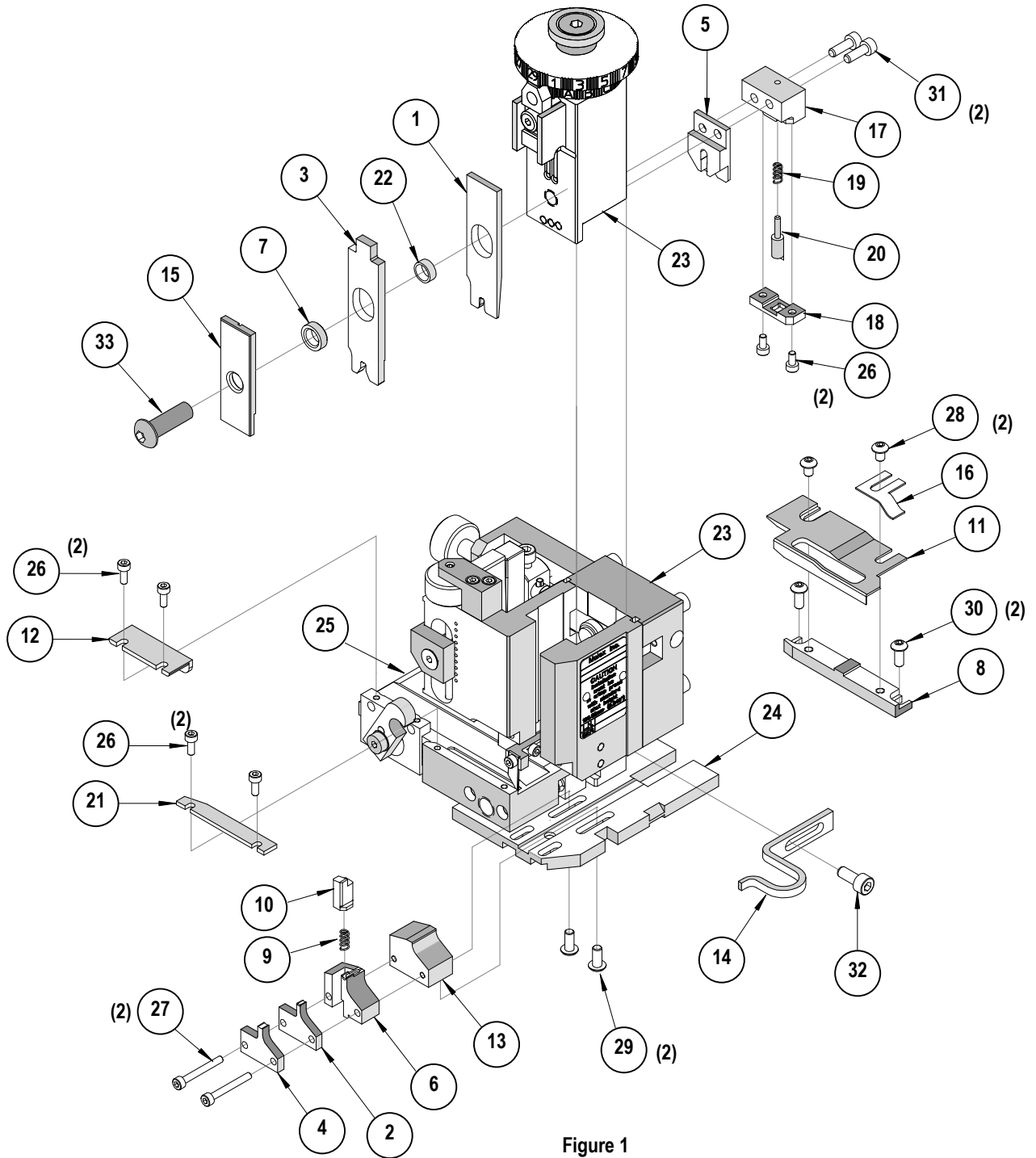


Figure 1

## 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 135.80mm (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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