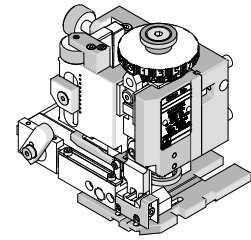




**Mini-Mac  
Applicator**

**Application Tooling  
Specification Sheet**



**Order No. 63894-1200**

**FEATURES**

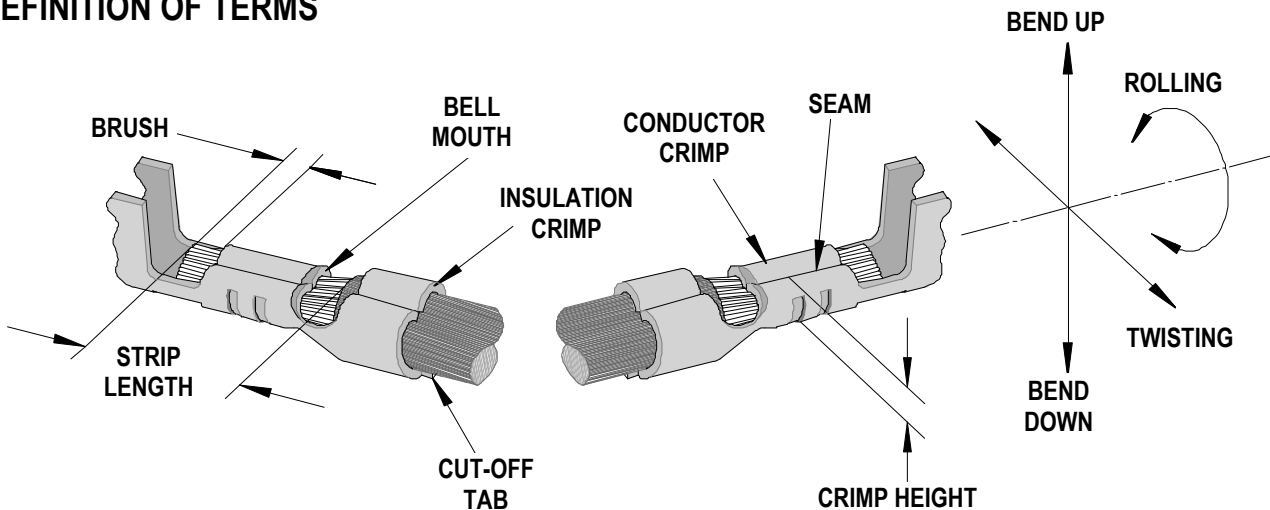
- Directly adapts to most automatic wire processing machines
- Applicator designed to industry standard mounting and shut height 135.80mm (5.346")
- Quick set-up time; plus the crimp height, track and feed adjustments can be set without removing the applicator from the press
- Fine adjustment allows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

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	20 + 20	0.50+ 0.50	3.55	.140	3.96-5.35	.156-.218
For 16-20 AWG single wire applications 63894-1000 is recommended. For 14 AWG and double wire applications 63894-1100 is recommended.							

**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						

Terminal Series No.	Bend up	Bend down	Twist	Roll	Punch Width (Ref)			
	Degree		Degree		Conductor		Insulation	
					mm	In.	mm	In.
1508					2.30	.091	4.25	.167
<b>Seam</b>								
Seam shall not be open and no wire allowed out of the crimping area								

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.
1508	20 + 20	0.50+ 0.50	1.52-1.62	.060-.064	2.32-2.42	.091-.095	57.8	13.00

**NOTE:** Some of the specifications in these charts above are intentionally left blank due to the fact that the information does not currently exist.

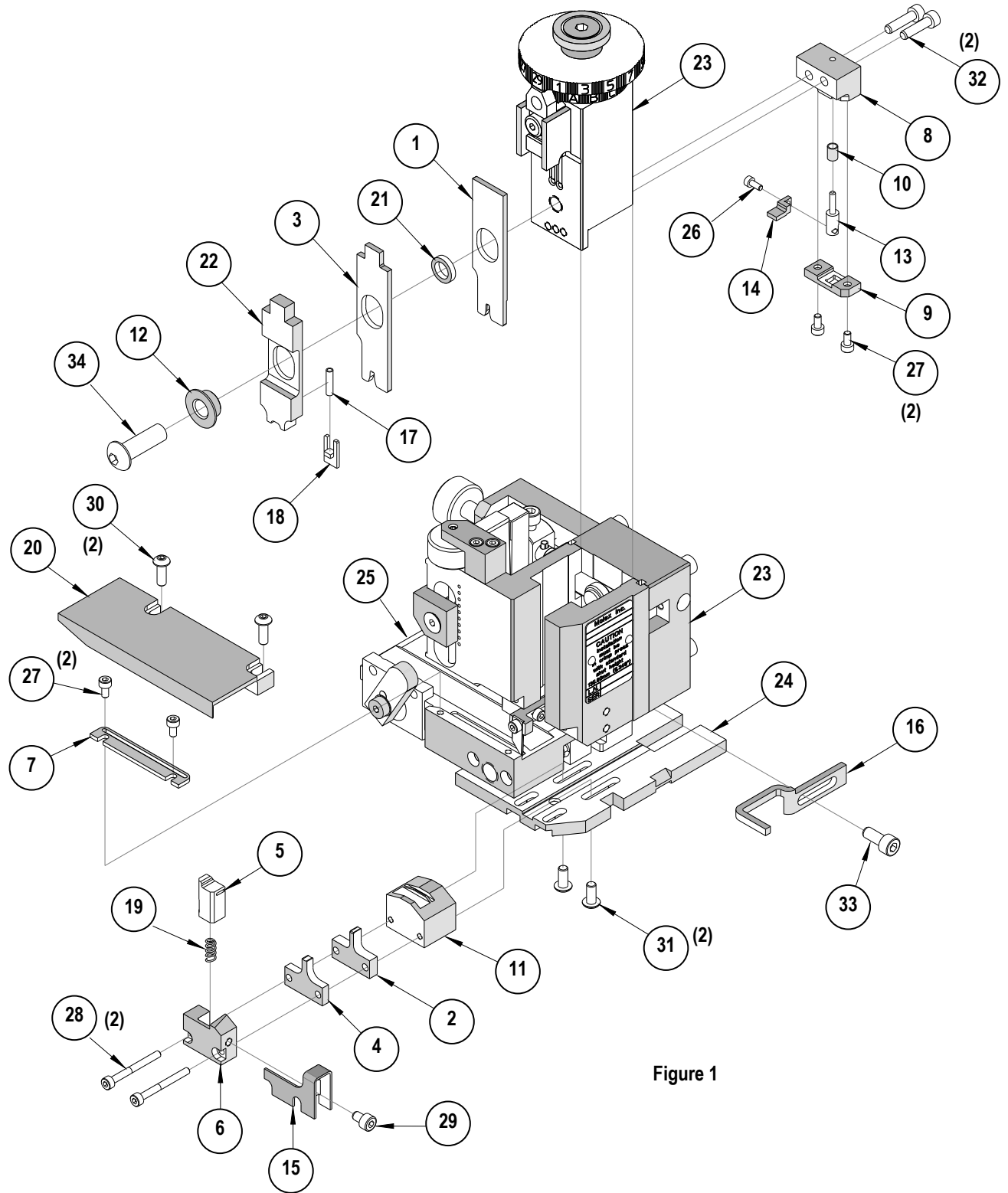
Tool Qualification Notes:

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 63894-1200</b>				
<b>Item</b>	<b>Order No</b>	<b>Engineering No.</b>	<b>Description</b>	<b>Quantity</b>
<b>Perishable Tooling</b>				
	63894-1270	63894-1270	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	11-18-5071	60811B108	Insulation Punch	1 Y
4	11-18-5072	60811B109	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	11-18-4083	60707-8	Feed Guide	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	11-18-5064	60811A111	Anvil Mount	1
12	11-18-5065	60811A115	Tooling Washer	1
13	11-18-5067	60811A121	Hold Down Plunger	1
14	11-18-5068	60811A122	Hold Down 1508 Terminal	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	11-18-5374	60804F142	Knockout Blade	1
19	11-24-1067	4996-4	Cut Off Plunger Spring	1
20	63443-6125	63443-6125	Rear Cover	1
21	63803-5118	63803-5118	Conductor Bushing	1
22	63894-1101	63894-1101	Front Plunger Striker	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	4**
28	N/A	N/A	M3 by 20 Long SHCS	2**
29	N/A	N/A	M4 by 6 Long SHCS	1**
30	N/A	N/A	M4 by 8 Long BHCS	2**
31	N/A	N/A	M4 by 12 Long BHCS	2**
32	N/A	N/A	M4 by 16 Long SHCS	2**
33	N/A	N/A	M5 by 14 Long SHCS	1**
34	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.

<http://www.molex.com>

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