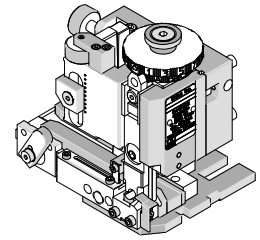




**Mini-Mac Applicator
Mechanical Feed
Metal Strip**

**Application Tooling
Specification Sheet**



Order No. 63895-0400

FEATURES

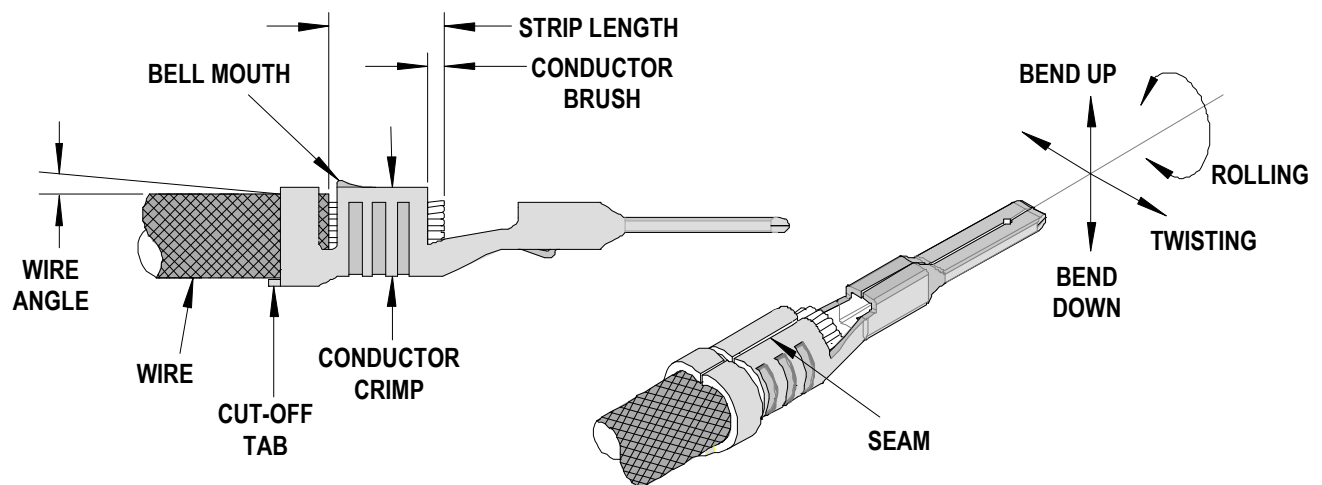
- Directly adapts to most automatic wire processing machines
- Applicator designed to industry standard mounting and shut height 135.80mm (5.346")
- Quick set-up time; plus the crimp height, track and feed adjustments can be set without removing the applicator from the press
- Fine adjustment allows 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: MX150L™ Male and Female Crimp Terminals, 10-12 AWG.

| Terminal Series No. | Terminal Order No. | Wire Size | | Insulation Diameter | | Strip Length | |
|---------------------|--------------------|-----------|-----------------|---------------------|-----------|--------------|-----------|
| | | AWG | mm ² | mm | In. | mm | In. |
| 19431 | 19431-0001 | 10-12 | 5.26-3.31 | 3.90-4.85 | .153-.191 | 5.50-6.20 | .217-.244 |
| 19434 | 19434-0001 | 10-12 | 5.26-3.31 | 3.90-4.85 | .153-.191 | 5.50-6.20 | .217-.244 |

DEFINITION OF TERMS



CRIMP SPECIFICATION

| Terminal Series No. | Bell mouth | | Cut-off Tab Maximum | | Conductor Brush | |
|---------------------|------------|-----------|---------------------|------|-----------------|-----------|
| | mm | In. | mm | In. | mm | In. |
| 19431 | 0.25-1.25 | .010-.049 | 0.50 | .020 | 0.10-0.50 | .004-.020 |
| 19434 | 0.25-1.25 | .010-.049 | 0.50 | .020 | 0.10-0.50 | .004-.020 |

| Terminal Series No. | Bend up | Bend down | Twist | Roll | Punch Width (Ref) | | | | Wire Angle | Seam Seam shall not be open and no wire allowed out of the crimping area |
|---------------------|---------|-----------|--------|------|-------------------|------|------------|------|------------|---|
| | Degree | | Degree | | Conductor | | Insulation | | Degree | |
| | | | | | mm | In | mm | In | | |
| 19431 | 2 | 3 | 4 | 8 | 3.80 | .150 | 5.00 | .197 | 5° Maximum | |
| 19434 | 2 | 3 | 4 | 8 | 3.80 | .150 | 5.00 | .197 | 5° Maximum | |

After crimping, the crimp profiles should measure the following:

| Terminal Series No. | Wire Size | | Conductor | | | | Pull Force Minimum | |
|---------------------|-----------|-----------------|--------------|-----------|--------------------|---------------|--------------------|------|
| | | | Crimp Height | | Crimp Width (Ref.) | | N | Lb. |
| | AWG | mm ² | mm | In. | mm | In. | | |
| 19431 | 10 | 5.26 | 2.45-2.55 | .096-.100 | 3.80 +/- .10 | .150 +/- .004 | 356.0 | 80.0 |
| | 12 | 3.31 | 2.05-2.15 | .081-.085 | 3.80 +/- .10 | .150 +/- .004 | 311.5 | 70.0 |
| 19434 | 10 | 5.26 | 2.45-2.55 | .096-.100 | 3.80 +/- .10 | .150 +/- .004 | 356.0 | 80.0 |
| | 12 | 3.31 | 2.05-2.15 | .081-.085 | 3.80 +/- .10 | .150 +/- .004 | 311.5 | 70.0 |

| Terminal Series No. | Wire Size | | Insulation | | | |
|---------------------|-----------|-----------------|--------------|----------|--------------------|---------------|
| | | | Crimp Height | | Crimp Width (Ref.) | |
| | AWG | mm ² | mm | In. | mm | In. |
| 19431 | 10 | 5.26 | 5.00 Max | .197 Max | 5.20 +/- .10 | .205 +/- .004 |
| | 12 | 3.31 | 4.50 Max | .177 Max | 5.10 +/- .10 | .201 +/- .004 |
| 19434 | 10 | 5.26 | 5.00 Max | .197 Max | 5.20 +/- .10 | .205 +/- .004 |
| | 12 | 3.31 | 4.50 Max | .177 Max | 5.10 +/- .10 | .201 +/- .004 |

Tool Qualification Notes:

1. This applicator was qualified to the above specifications with UL1015 wire.
2. Pull Force should be measured with no influence from the insulation crimp.
3. The above specifications are guidelines to an optimum crimp.

PARTS LIST

| Mini-Mac Applicator 63895-0400 | | | | |
|--|-----------------|------------------------|-------------------------------|-----------------|
| Item | Order No | Engineering No. | Description | Quantity |
| Perishable Tooling | | | | |
| | 63895-0470 | 63895-0470 | Tool Kit (All "Y" Items) | REF |
| 1 | 63465-0042 | 63465-0042 | Conductor Punch | 1 Y |
| 2 | 63455-0029 | 63455-0029 | Conductor Anvil | 1 Y |
| 3 | 63472-0002 | 63472-0002 | Insulation Punch | 1 Y |
| 4 | 63445-5007 | 63445-5007 | Insulation Anvil | 1 Y |
| 5 | 63443-0037 | 63443-0037 | Cut-off Plunger Front | 1 Y |
| 6 | 63443-0038 | 63443-0038 | Plunger Retainer Front | 1 Y |
| Other Components | | | | |
| 7 | 11-18-4083 | 60707-8 | Feed Guide | 1 |
| 8 | 11-24-1067 | 4996-4 | Cut-Off Plunger Spring | 1 |
| 9 | 63443-0009 | 63443-0009 | Scrap Chute Front | 1 |
| 10 | 63443-0024 | 63443-0024 | Key | 1 |
| 11 | 63443-0090 | 63443-0090 | Wire Stop | 1 |
| 12 | 63443-1728 | 63443-1728 | Height Spacer (19.80mm) | 1 |
| 13 | 63443-2207 | 63443-2207 | Course Spacer (7.00mm) | 1 |
| 14 | 63443-2208 | 63443-2208 | Course Spacer (8.00mm) | 1 |
| 15 | 63443-2314 | 63443-2314 | Fine Spacer (3.70mm) | 1 |
| 16 | 63443-6140 | 63443-6140 | Rear Cover | 1 |
| 17 | 63466-0508 | 63466-0508 | Cut-off Plunger Striker Front | 1 |
| 18 | 63890-0866 | 63890-0866 | Collar-6.40 Long | 1 |
| 19 | 63890-0995 | 63890-0995 | Collar-4.05 Long | 1 |
| Frame | | | | |
| 20 | 63801-3201 | 63801-3201 | Top | 1 |
| 21 | 63801-3281 | 63801-3281 | Base | 1 |
| 22 | 63801-4650 | 63801-4650 | Track | 1 |
| Hardware | | | | |
| 23 | N/A | N/A | M3 by 6 Long FHCS | 1** |
| 24 | N/A | N/A | M3 by 6 Long SHCS | 2** |
| 25 | N/A | N/A | M4 by 6 Long SHCS | 2** |
| 26 | N/A | N/A | M4 by 12 Long BHCS | 2** |
| 27 | N/A | N/A | M4 by 50 Long SHCS | 2** |
| 28 | N/A | N/A | M5 by 12 Long SHCS | 1** |
| 29 | N/A | N/A | M8 by 30 Long BHCS | 1** |
| 30 | N/A | N/A | 2mm by 5 Long Roll Pin | 1** |
| ** Available from an industrial supply company such as MSC (1-800-645-7270). | | | | |

Assembly Drawing

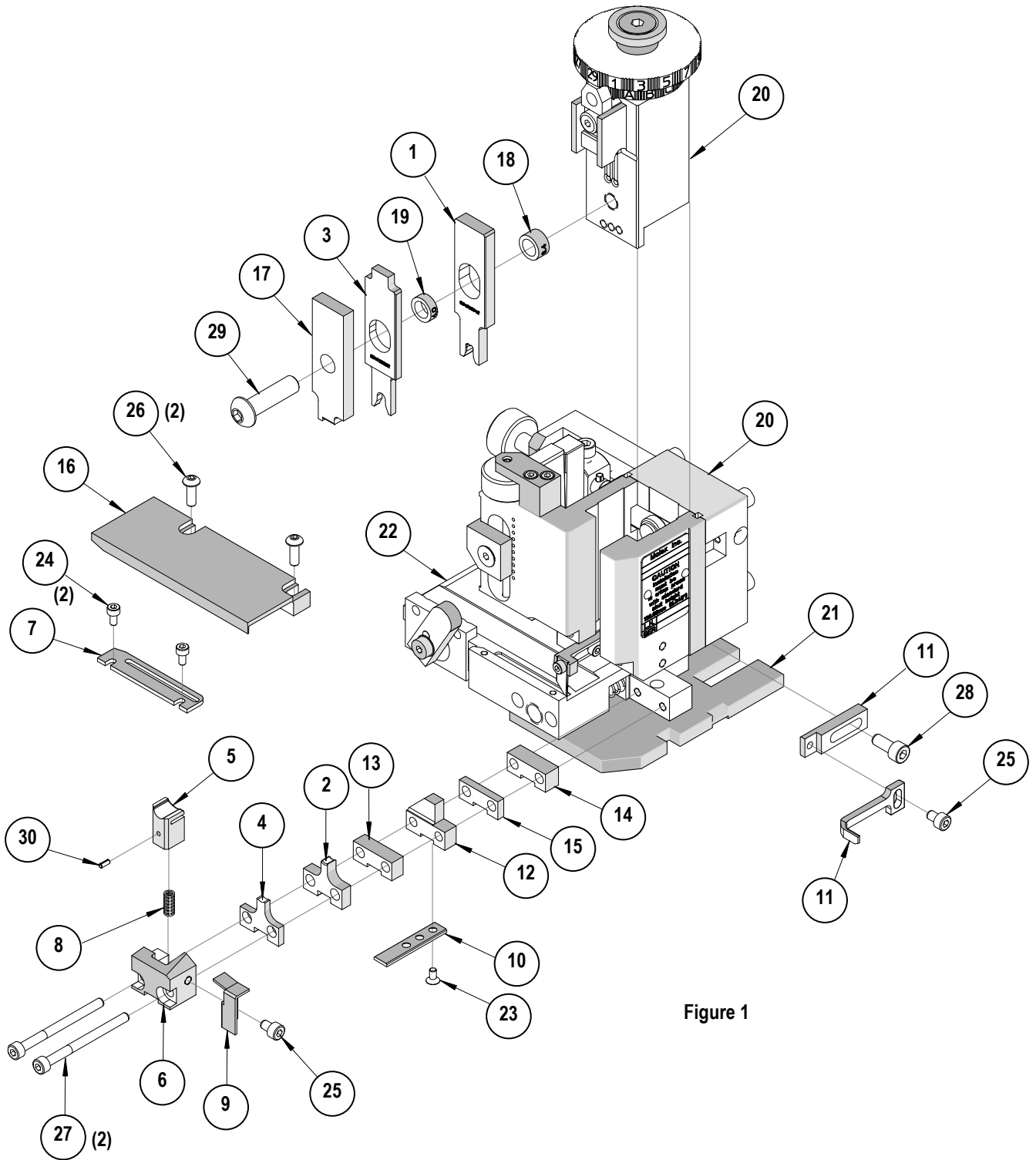


Figure 1

NOTES

1. Molex recommends an extra perishable tooling kit be maintained at your facility.
2. Verify tooling alignment by manually cycling the press with 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 Applicator Manual (Document no. 63880-0000).

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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