

**Mini-Mac Applicator
Rear Feed**

**Application Tooling
Specification Sheet**

Order No. 63802-7300

FEATURES

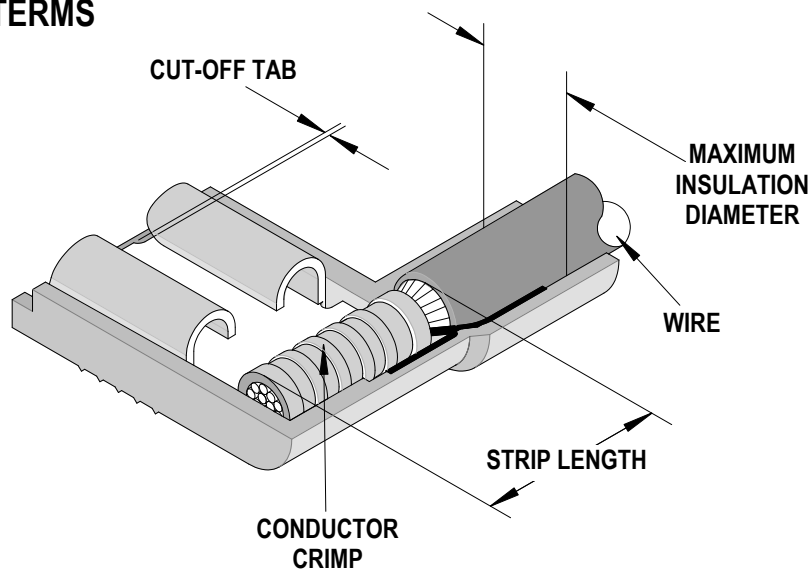
- Directly adapts to most automatic wire processing machines
- Applicator designed to industry standard mounting and shut height 135.80mm (5.346")
- Quick set-up time; plus the crimp height, track and feed adjustments can be set without removing the applicator from the press
- Fine adjustment allows 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: Flag Avikrimp™ Quick Disconnect Female Terminals, 18-22 AWG.

Terminal Order No.	Terminal Eng. No.	Wire Size		Tab Size		Insulation Diameter Maximum		Strip Length	
		AWG	mm ²	mm	In.	mm	In.	mm	In.
19006-0004	AA-5220Z	18-22	0.80-0.35	6.35 by 0.81	.250 by .032	3.81	.150	8.70	.344
19006-0007	AA-5222Z	18-22	0.80-0.35	4.75 by 0.51	.187 by .020	3.81	.150	8.70	.344
19006-0010	AA-5223Z	18-22	0.80-0.35	4.75 by 0.81	.187 by .032	3.81	.150	8.70	.344

DEFINITION OF TERMS



CRIMP SPECIFICATIONS

Terminal Order No.	Terminal Eng. No.	Wire Size		Conductor Crimp Height						Pull Force Minimum	
				Mean		Go		No Go			
		AWG	mm ²	mm	In.	mm	In.	mm	In.	N	Lb.
19006-0004	AA-5220Z	18	0.80	1.98	.078	1.90	.075	2.05	.081	89.0	20.0
		20	0.50	1.98	.078	1.90	.075	2.05	.081	57.9	13.0
		22	0.35	1.98	.078	1.90	.075	2.05	.081	35.6	8.0
19006-0007	BB-5222Z	18	0.80	1.98	.078	1.90	.075	2.05	.081	89.0	20.0
		20	0.50	1.98	.078	1.90	.075	2.05	.081	57.9	13.0
		22	0.35	1.98	.078	1.90	.075	2.05	.081	35.6	8.0
19006-0010	BB-5223Z	18	0.80	1.98	.078	1.90	.075	2.05	.081	89.0	20.0
		20	0.50	1.98	.078	1.90	.075	2.05	.081	57.9	13.0
		22	0.35	1.98	.078	1.90	.075	2.05	.081	35.6	8.0

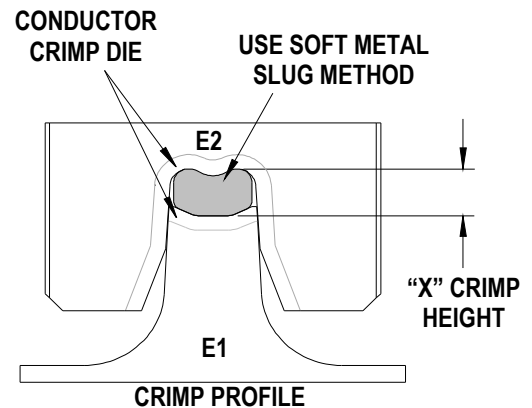
*** Tool Qualification Notes:**

1. Pull Force should be measured with no influence from the insulation crimp.
2. The above specifications are guidelines to an optimum crimp.

Tool Calibration

To recalibrate this applicator, make sure the power is completely shut off on the press.

1. The Applicator must be properly installed in the press.
2. Crimping dies must be properly installed in the Applicator.
3. The recommended method of measuring the crimp height of the conductor dies is the soft metal slug method. See Figure 1.
4. The slug must have a diameter 0.51mm (.020") larger than the "X" No Go dimension before crimping.
5. Place the soft metal slug (solder) into the nest of the bottom die and crimp (by hand cycling the press) similar to a terminal. The crimp height can be measured with a blade type micrometer or dial caliper, (Dimension "X").
6. Adjustment of the crimp height can be accomplished by indexing the conductor cam. The letter "A" gives the loosest position and "K" gives the tightest position. A total adjustment of 0.50mm (.020") can be achieved by adjusting the conductor cam.



Use soft metal slug (solder) method to measure the "X" dimension. Verify tooling crimp height calibration by referring to the Go/No Go dimensions shown in the chart

Figure 1

Note: If the crimp height is too tight on the setting "A", check the shut height of the press. See the Industrial Mini-Mac Applicator Manual Section 2.1 for adjustments.

Molex does not sell gauge pins contact your local industrial supplier.

PARTS LIST

Rear Feed Mini-Mac Applicator 63802-7300				
Item No.	Order No.	Engineering No.	Description	Quantity
Perishable Tooling				
	63802-7370	63802-7370	Tool Kit (All "Y" Items)	REF
1	63801-5515	63801-5515	Conductor Punch (E2 Die)	1 Y
2	19803-5261	19803-5261	Conductor Anvil (E1 Die)	1 Y
3	63801-5613	63801-5613	Insulation Punch (I 2 Die)	1 Y
4	19803-5271	19803-5271	Insulation Anvil (I1 Die)	1 Y
5	19229-0120	23650-43	Cutter Housing	1 Y
6	19229-0121	23650-44	Cutter Plunger	1 Y
Other Components				
7	19229-0095	23650-45	Cutter Back Plate	1
8	19230-0038	24854-08	Feed Finger	1
9	19230-0063	24853	Shoulder Bushing	1
10	19230-0101	24854-09	Guide Rail	1
11	19230-0106	24854-25P	Guide and Hold Down	1
12	19250-0038	24855-23	Compression Spring	1
13	63801-2685	63801-2685	Terminal Drag Assembly	1
14	63801-7701	63801-7701	Cutter Striker	1
15	63803-5133	63803-5133	Conductor Bushing	1
Frame				
16	19230-0084	24854-05	Slide (Terminal Track)	1
17	63801-2600	63801-2600	Rear Feed Frame	1
18	63801-2603	63801-2603	Base	1
Hardware				
19	N/A	N/A	M3 by 10 Long SHCS	2**
20	N/A	N/A	M4 by 8 Long SHCS	6**
21	N/A	N/A	M4 by 8 Long BHCS	1**
22	N/A	N/A	M4 by 10 Long BHCS	1**
23	N/A	N/A	M4 by 12 Long SHCS	3**
24	N/A	N/A	M6 by 10 Long BHCS	6**
25	N/A	N/A	M8 by 20 Long BHCS	1**
26	N/A	N/A	6mm by 10 Long Dowel Pin	4**
** Available from an industrial supply company such as MSC (1-800-645-7270).				

Assembly Drawing

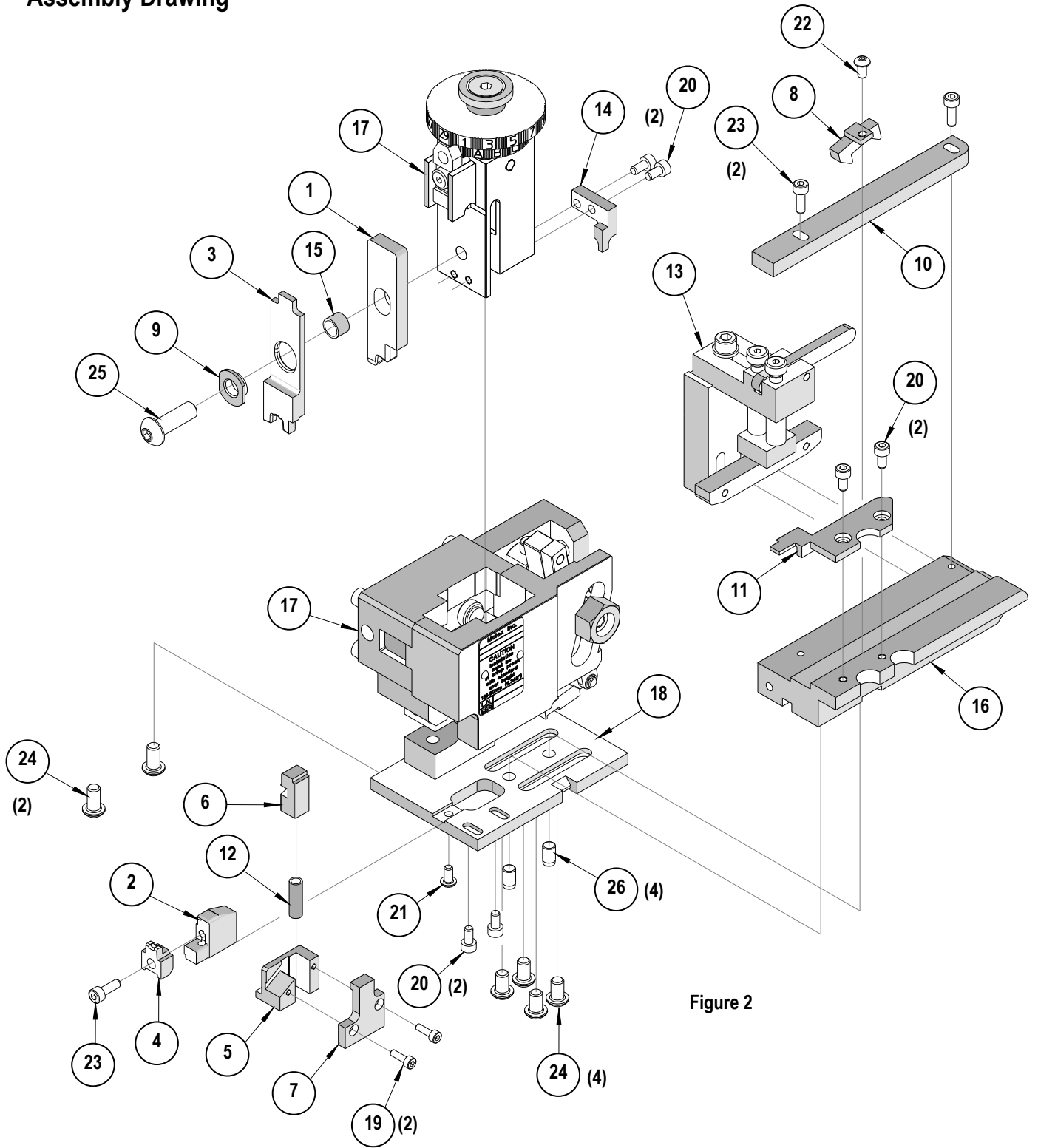


Figure 2

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.

Wear Safety Glasses At All Times.

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