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|---|---|---|
| Mini-Mac Applicator Air Feed |  |  |
| | Application Tooling Specification Sheet | |

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.
- Molex applicators with air feed require presses equipped with an air valve. Molex presses with air valves include the TM-4000 (63801-7600).

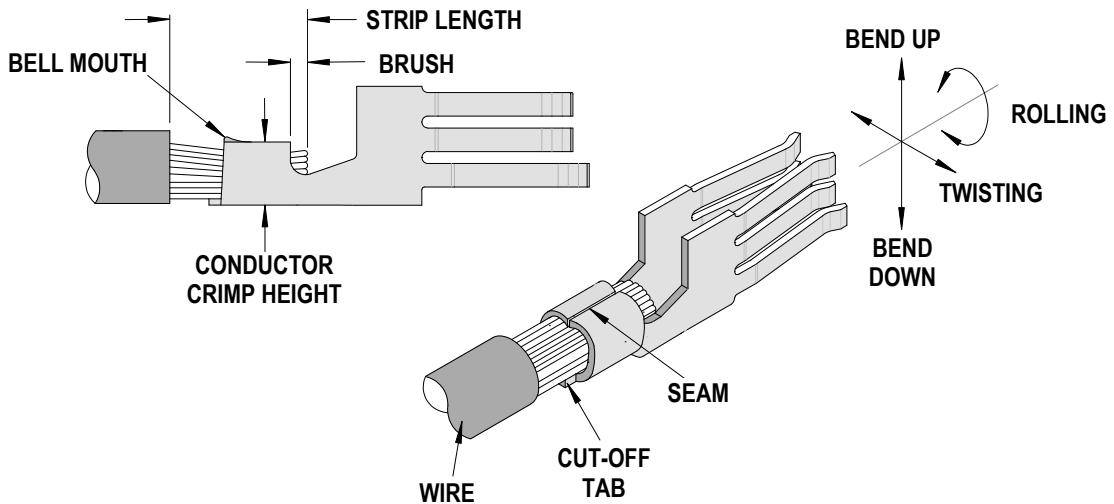
SCOPE

Products: Power 60 Amp Crimp Terminals, 6 AWG.

| Terminal Series No. | Terminal Order No. | Wire Size | | ◆ Insulation Diameter Maximum | | Strip Length | |
|---|--------------------|-----------|-----------------|-------------------------------|------|--------------|-----------|
| | | AWG | mm ² | mm | In. | mm | In. |
| 46819 | 46819-0013 | 6 | 13.30 | 9.00 | .354 | 8.00-9.00 | .315-.354 |
| ◆ Overall insulation OD specification for terminal. | | | | | | | |

Note: The 63832-0600 applicator must be used with TM-4000 (63801-7600) or an equivalent press with no less than 3 tons.

DEFINITION OF TERMS



CRIMP SPECIFICATION

| Terminal Series No. | Bell mouth | | Cut-off Tab Maximum | | Conductor Brush | |
|---------------------|------------|-----------|---------------------|------|-----------------|-----------|
| | mm | In. | mm | In. | mm | In. |
| 46819 | 0.25-1.25 | .010-.049 | 0.35 | .014 | 1.00-2.50 | .039-.098 |

| Terminal Series No. | Bend up Bend down | | Twist | Roll | Punch Width (Ref) | | Seam Seam shall not be open and no wire allowed out of the crimping area |
|---------------------|-------------------|----|-------|------|-------------------|------|---|
| | Degree | | | | Conductor | | |
| | mm | In | mm | In | | | |
| 46819 | 3 | 3 | 3 | 3 | 7.00 | .276 | |

After crimping, the crimp profiles should measure the following.

| Terminal Series No. | Wire Size | | Conductor | | | | Pull Force Minimum | |
|---------------------|-----------|-----------------|--------------|-----------|--------------------|------|--------------------|--------|
| | | | Crimp Height | | Crimp Width (Ref.) | | | |
| | AWG | mm ² | mm | In. | mm | In. | N | Lb. |
| 46819 | 6 | 13.30 | 3.95-4.05 | .155-.159 | 7.10 | .280 | 951.92 | 214.00 |

Tool Qualification Notes:

1. The above specifications are guidelines to an optimum crimp.

PARTS LIST

| Mini-Mac Applicator 63832-0600 | | | | |
|--|-----------------|------------------------|---------------------------|-----------------|
| Item | Order No | Engineering No. | Description | Quantity |
| Perishable Tooling | | | | |
| | 63832-0670 | 63832-0670 | Tool Kit (All "Y" Items) | REF |
| 1 | 63465-0068 | 63465-0068 | Conductor Punch | 1 Y |
| 2 | 63455-0074 | 63455-0074 | Conductor Anvil | 1 Y |
| 3 | 63443-0095 | 63443-0095 | Front Cut-Off Plunger | 1 Y |
| 4 | 63890-0487 | 63890-0487 | Front Plunger Retainer | 1 Y |
| Other Components | | | | |
| 5 | 11-18-4848 | 60800A123 | Spring Retainer | 1 |
| 6 | 11-18-4849 | 60800A124 | Wire Hold Down Spring | 1 |
| 7 | 63443-0007 | 63443-0007 | Scrap Chute Front | 1 |
| 8 | 63443-0025 | 63443-0025 | Key | 1 |
| 9 | 63443-1225 | 63443-1225 | Wire Stop | 1 |
| 10 | 63443-1715 | 63443-1715 | Height Spacer (18.50mm) | 1 |
| 11 | 63443-2214 | 63443-2214 | Coarse Spacer (14.00mm) | 1 |
| 12 | 63443-2304 | 63443-2304 | Fine Spacer (3.20mm) | 1 |
| 13 | 63466-0512 | 63466-0512 | Striker | 1 |
| 14 | 63700-0539 | 63700-0539 | Compression Spring | 1 |
| 15 | 63801-3511 | 63801-3511 | Feed Finger | 1 |
| 16 | 63821-0012 | 63821-0012 | Feed Guide | 1 |
| 17 | 63832-0602 | 63832-0602 | Rear Cover | 1 |
| 18 | 63890-0866 | 63890-0866 | Bushing-Punch (Conductor) | 1 |
| Frame | | | | |
| 19 | 63801-3301 | 63801-3301 | Top | 1 |
| 20 | 63801-3281 | 63801-3281 | Base | 1 |
| 21 | 63801-4650 | 63801-4650 | Track | 1 |
| 22 | 63801-3501 | 63801-3501 | Air-Feed Assembly | 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 | 1** |
| 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

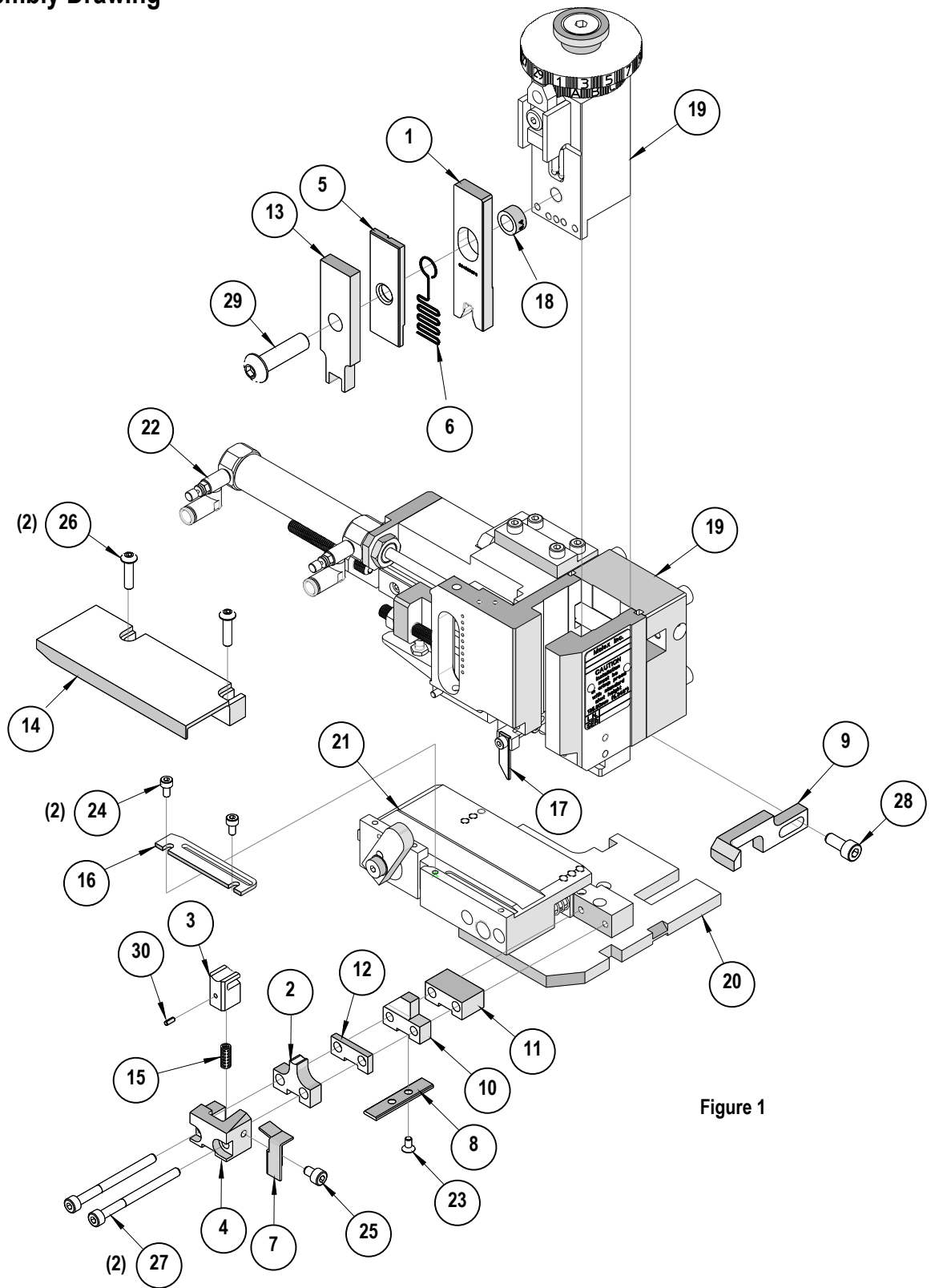


Figure 1

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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