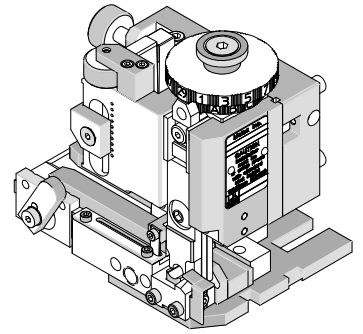




## Mini-Mac Applicator Application Tooling Specification Mechanical Feed-Front Metal Strip Order No. 63895-0900



### 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.

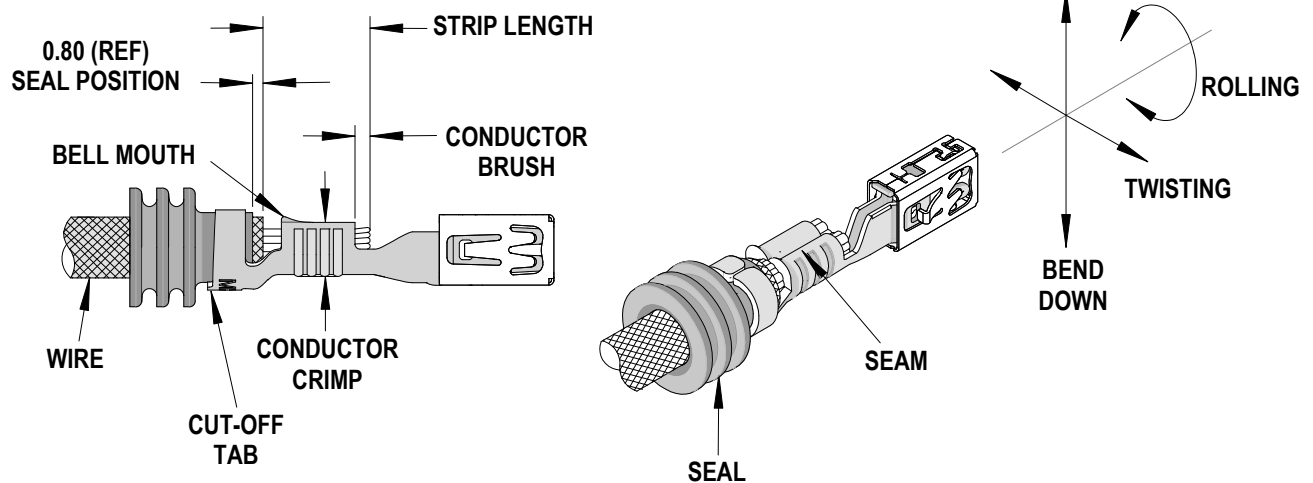
### SCOPE

Products: CP2.8 and CPX2.8 Receptacle Crimp Terminals, >3.0 – 5.0 mm<sup>2</sup> type ID and IR wire.

Terminal Series No.	Terminal Order No.		Wire Size and Type		✗ Insulation Diameter		Strip Length	
			mm <sup>2</sup>	Type	mm	In.	mm	In.
98910	98910-1019	98910-1119	>3.0 – 5.0	ID & IR	3.40 – 4.00	.134 - .157	4.90-5.10	.193-.201
	98910-2019	98910-2119						
64324	64324-1019	64324-1119	>3.0 – 5.0	ID & IR	3.40 – 4.00	.134 - .157	4.90-5.10	.193-.201
	64324-2019	64324-2119						

✗ See crimp specification for the individual Insulation Diameter.  
▶ See Tooling Qualification notes for 5.0mm wire.

### DEFINITION OF TERMS



The above terminal drawing is a generic terminal representation. It is not an image of any terminal listed in the scope.

### CRIMP SPECIFICATION

Terminal Series No.	Bell mouth		Cut-off Tab Maximum		▶ Conductor Brush	
	mm	In.	mm	In.	mm	In.
98910	0.40-0.60	.016-.024	0.30	.012	0.20-0.60	.008-.024
64324	0.40-0.60	.016-.024	0.30	.012	0.20-0.60	.008-.024
▶ Not to exceed above the conductor crimp height.						

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		Degree		Conductor		Insulation		
					mm	In	mm	In	
98910	2	2	2	3	3.40	.134	4.85	.191	
64324	2	2	2	3	3.40	.134	4.85	.191	

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.
		mm	In.	mm	In.		
98910	4.00	2.00-2.10	.079-.083	3.49	.137	320.0	72.0
	5.00	2.10-2.20	.083-.087	3.50	.138	*360.0	81.0
64324	4.00	2.00-2.10	.079-.083	3.49	.137	320.0	72.0
	5.00	2.10-2.20	.083-.087	3.50	.138	*360.0	81.0

Terminal Series No.	Wire Size	✗ Insulation Diameter		Single Wire Seal		Insulation			
		mm	In.	Order No.	Color	Crimp Height		Crimp Width (Ref.)	
						mm	In.	mm	In.
98910	4.00	3.40-3.70	.134-.146	0643251196	Blue	5.05-5.25	.199-.207	5.05	.199
	4.00	3.70-3.90	.146-.154			5.15-5.35	.203-.211	5.06	.199
	5.00	3.70-4.00	.146-.157			5.25-5.45	.207-.215	5.07	.200
64324	4.00	3.40-3.70	.134-.146	0643251196	Blue	5.05-5.25	.199-.207	5.05	.199
	4.00	3.70-3.90	.146-.154			5.15-5.35	.203-.211	5.06	.199
	5.00	3.70-4.00	.146-.157			5.25-5.45	.207-.215	5.07	.200

▶ 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 63895-0900</b>				
<b>Item</b>	<b>Order No</b>	<b>Engineering No.</b>	<b>Description</b>	<b>Quantity</b>
<b>Perishable Tooling</b>				
	63895-0970	63895-0970	Tool Kit (All "Y" Items)	REF
1	63465-0057	63465-0057	Conductor Punch	1 Y
2	63455-0058	63455-0058	Conductor Anvil	1 Y
3	63463-0038	63463-0038	Insulation Punch	1 Y
4	63456-0055	63456-0055	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
<b>Other Components</b>				
7	11-18-4094	60709A111	Feed Guide	1
8	63443-0009	63443-0009	Scrap Chute Front	1
9	63443-0024	63443-0024	Key	1
10	63443-0090	63443-0090	Wire Stop	1
11	63443-1712	63443-1712	18.20mm Height Spacer	1
12	63443-2201	63443-2201	1.00mm Course Spacer	1
13	63443-2214	63443-2214	14.00mm Course Spacer	1
14	63443-2312	63443-2312	3.60mm Fine Spacer	1
15	63443-6121	63443-6121	Rear Cover	1
16	63443-3701	63443-3701	Striker Screw	1
17	63443-3801	63443-3801	Front Plunger Striker	1
18	63700-0225	63700-0225	Compression Spring	1
19	63700-0539	63700-0539	Cut-Off Plunger Spring	1
20	63890-0063	63890-0063	Terminal Hold Down	1
21	63890-0067	63890-0067	Holder Front	1
22	63890-0068	63890-0068	Holder Rear	1
23	63890-0866	63890-0866	Collar-6.40 Long	2
<b>Frame</b>				
24	63801-3201	63801-3201	Top	1
25	63801-3281	63801-3281	Base	1
26	63801-4650	63801-4650	Track	1
<b>Hardware</b>				
27	N/A	N/A	M3 by 5 Long Flat Point SSS	2**
28	N/A	N/A	M3 by 6 Long FHCS	1**
29	N/A	N/A	M3 by 6 Long SHCS	2**
30	N/A	N/A	M3 by 10 Long SHCS	1**
31	N/A	N/A	M4 by 6 Long SHCS	2**
32	N/A	N/A	M4 by 12 Long BHCS	2**
33	N/A	N/A	M4 by 16 Long SHCS	2**
34	N/A	N/A	M4 by 55 Long SHCS	2**
35	N/A	N/A	M5 by 12 Long SHCS	1**
36	N/A	N/A	M8 by 30 Long BHCS	1**
37	N/A	N/A	2mm by 8 Long Dowel Pin	1**
** Available from an industrial supply company such as MSC (1-800-645-7270).				

### Assembly Drawing

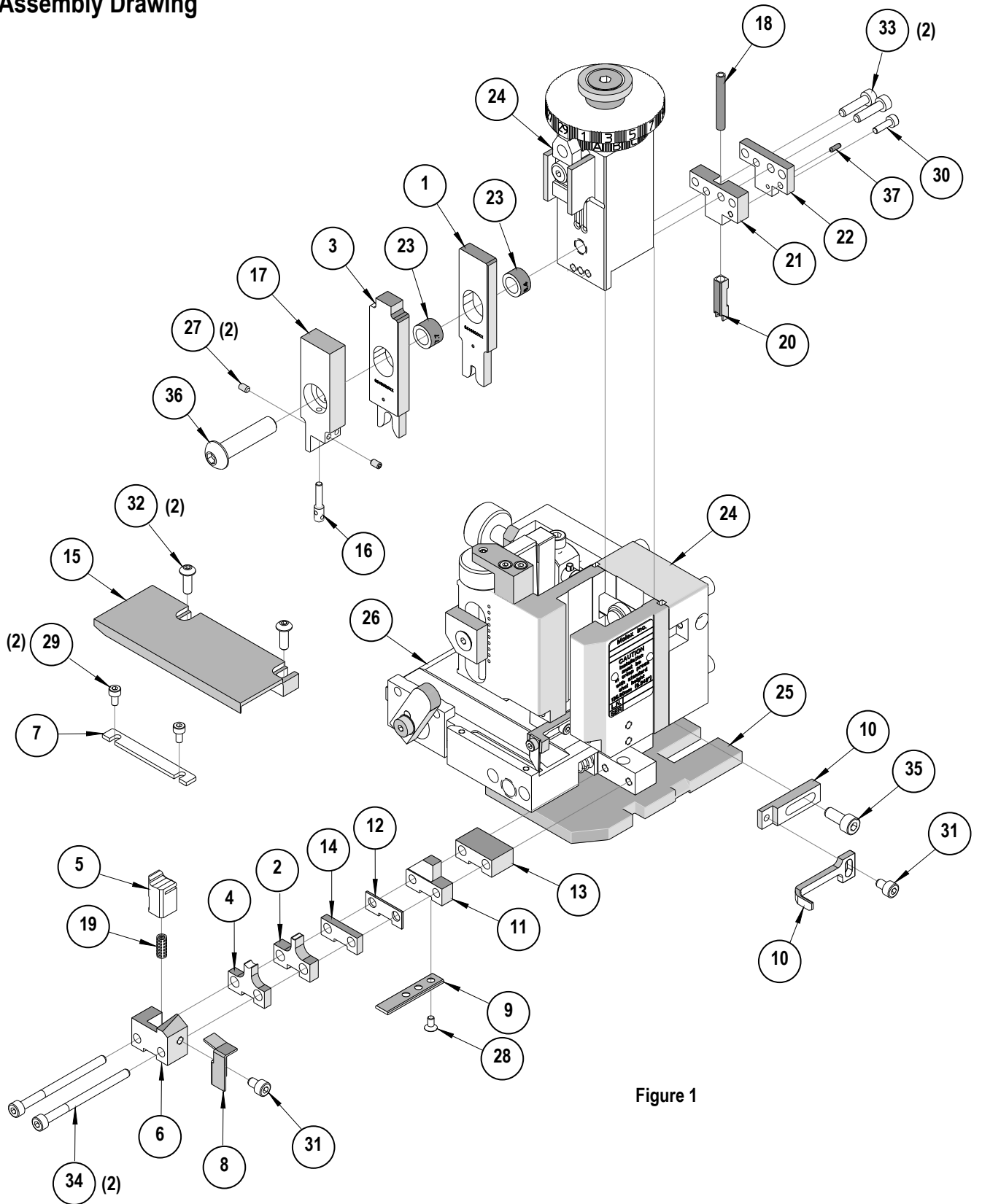


Figure 1

## 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.

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