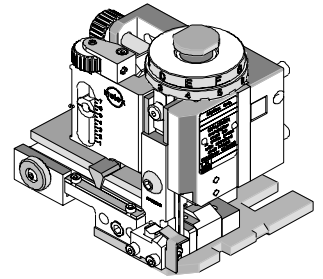**molex®**

Mini-Mac Applicator
Application Tooling Specification
Mechanical Feed-Front Metal Strip
# Order No. 63832-5100

FEATURES

- Directly adapts to most crimp press and automatic wire processing machines
- Applicator designed to industry standard mounting and shut height of 135.80mm (5.346")
- Conductor and insulation rings allow quick adjustment for conductor and insulation crimp height change
- Quick set-up time; plus the crimp height, track and feed adjustments can be set without removing the applicator from the crimp press

SCOPE

Products: MX150L™ 8 AWG

Terminal Series No.	Terminal Order No.	Wire Size		Insulation Diameter		Strip Length	
		AWG	mm²	mm	In.	mm	In.
19431	19431-0015	8	8.37	6.30-6.70	.248-.264	8.90-9.40	.350-.370
19434	19434-0002	8	8.37	6.30-6.70	.248-.264	8.90-9.40	.350-.370

DEFINITION OF TERMS
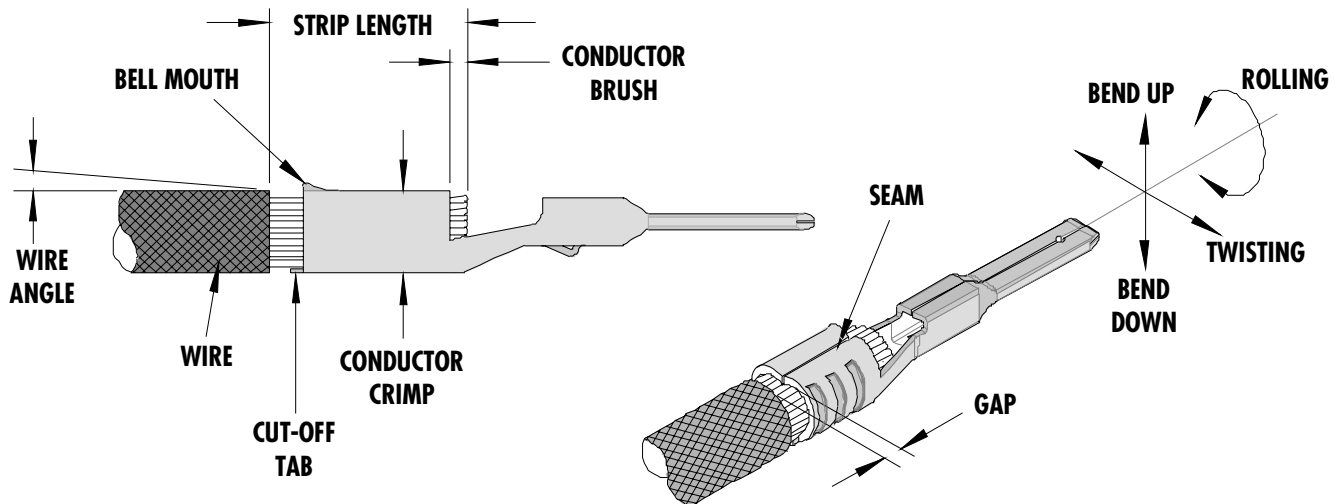
CRIMP SPECIFICATION

Terminal Series No.	Bell mouth		Cut-off Tab Max.		Conductor Brush		Gap	
	mm	In.	mm	In.	mm	In.	mm	In.
19431-0015	0.25-1.25	.010-.049	0.50	.020	0.10-0.50	.004-.020	3.30-4.06	.130-.160
19434-0002	0.25-1.25	.010-.049	0.50	.020	0.10-0.50	.004-.020	3.30-4.06	.130-.160

Terminal Series No.	Bend up	Bend down	Twist	Roll	Punch Width (Ref)				Wire Angle	Seam
	Degree		Degree		Conductor		Insulation		Degree	Seam shall not be open and no wire allowed out of the crimping area
					mm	In	mm	In		
19431-0015	2	3	4	8	4.80	.189	N/A	N/A	5° Max	
19434-0002	2	3	4	8	4.80	.189	N/A	N/A	5° Max	

After crimping, the crimp profiles should measure the following.

Terminal Series No.	Wire Size		Conductor				Insulation				Pull Force Min.	
	AWG	mm²	Crimp Height		Crimp Width (Ref.)		Crimp Height		Crimp Width		N	Lb.
			mm	In.	mm	In.	mm	In.	mm	In.		
19431-0015	8	8.37	3.07-3.20	.121-.126	4.80 +/- .10	.189 +/- .004	N/A	N/A	N/A	N/A	400.5	90.0
19434-0002	8	8.37	3.07-3.20	.121-.126	4.80 +/- .10	.189 +/- .004	N/A	N/A	N/A	N/A	400.5	90.0

* This applicator was qualified to the above specifications with UL 1028 wire.

Pull Force should be measured with no influence from the insulation crimp.

The above specifications are guidelines to an optimum crimp.

PARTS LIST

| Mini-Mac Applicator 63832-5100				
Item	**Order No**	**Engineering No.**	**Description**	**Quantity**
Perishable Tooling				
	63832-5170	63832-5170	Tool Kit (All "Y" Items)	REF
1	63465-0017	63465-0017	Conductor Punch	1 Y
2	63455-0028	63455-0028	Conductor Anvil	1 Y
11	63443-0037	63443-0037	Cut-off Plunger Front	1 Y
13	63443-0038	63443-0038	Plunger Retainer Front	1 Y
Other Components (REF 25150)				
21	63466-0505	63466-0505	Cut-off Plunger Striker Front	1
23	63443-0009	63443-0009	Scrap Chute Front	1
25	63700-0539	63700-0539	Cut-Off Plunger Spring	1
31	63832-5105	63832-5105	Anvil Mount	1
33	63443-0021	63443-0021	Lower Tooling Key	1
45	63443-0061	63443-0061	Wire Stop	1
52	63890-0866	63890-0866	Collar-6.40 Lg.	1
54	11-18-4849	60800A124	Wire Hold Down Spring	1
55	11-18-4848	60800A123	Wire Hold Down Cover	1
72	11-18-4083	60707-8	Feed Guide	1
73	63443-6140	63443-6140	Rear Cover	1
Frame				
81	63801-3201	63801-3201	Mechanical Feed Applicator Frame Head	REF
82	63801-3281	63801-3281	Base	REF
83	63801-4650	63801-4650	Track Assembly	REF
Hardware				
91	N/A	N/A	M3 by 6 Lg. SHCS	2**
92	N/A	N/A	M4 by 6 Lg SHCS	1**
93	N/A	N/A	M4 by 12 Lg SHCS	2**
94	N/A	N/A	M4 by 50 Lg. SHCS	2**
95	N/A	N/A	M5 by 12 Lg. SHCS	1**
96	N/A	N/A	M8 by 30 Lg. BHCS	1**
97	N/A	N/A	3mm by 6 Lg. Roll Pin	1**
** Available from an industrial supply company such as MSC (1-800-645-7270).				

Assembly Drawing
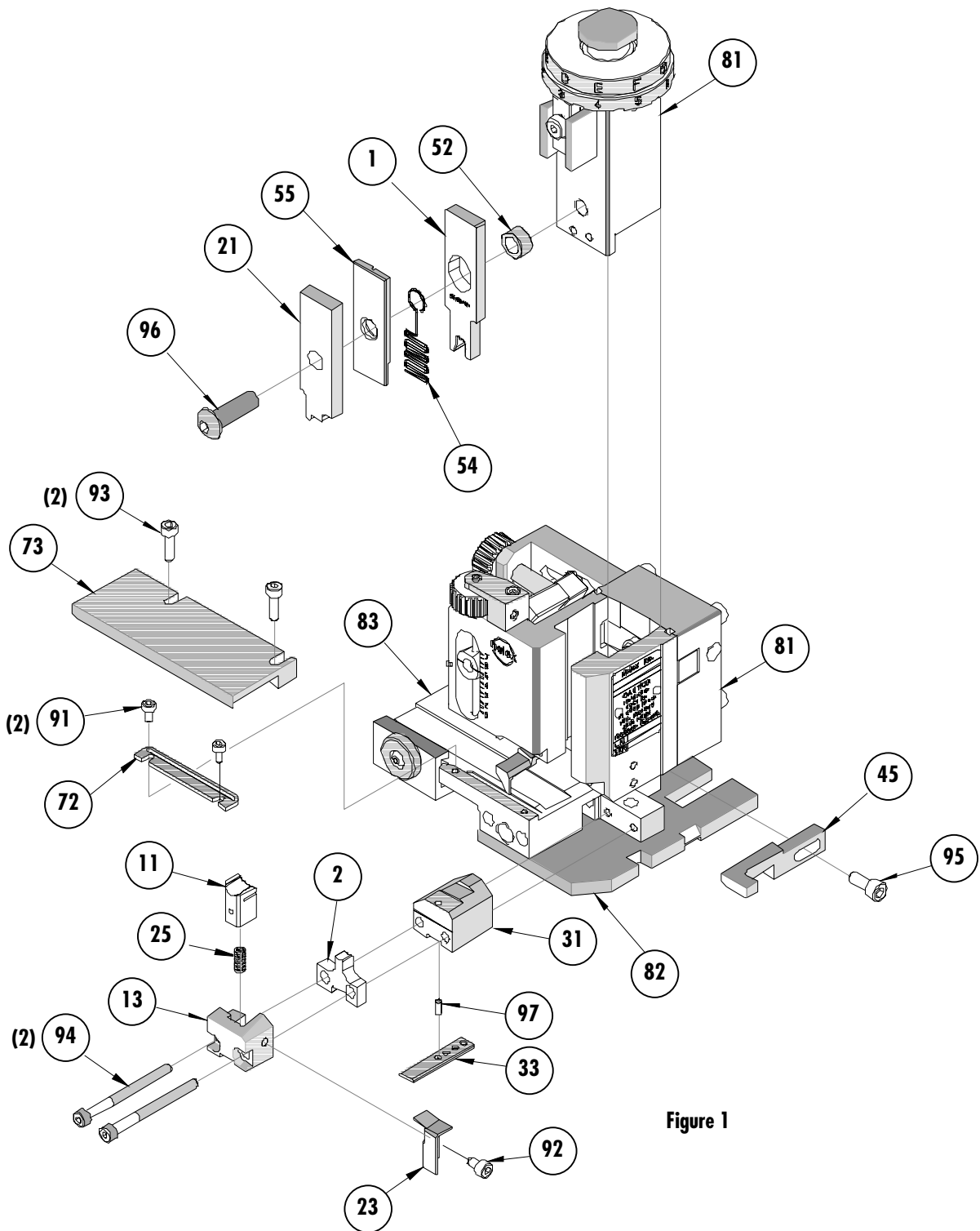
Figure 1

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.

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