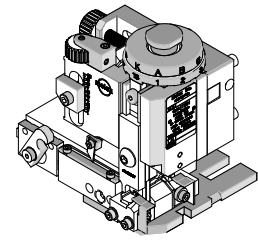




**Mini-Mac  
Mechanical Feed-Metal  
Strip Applicator**

**Application Tooling  
Specification Sheet**



**Order No. 63832-5200**

**FEATURES**

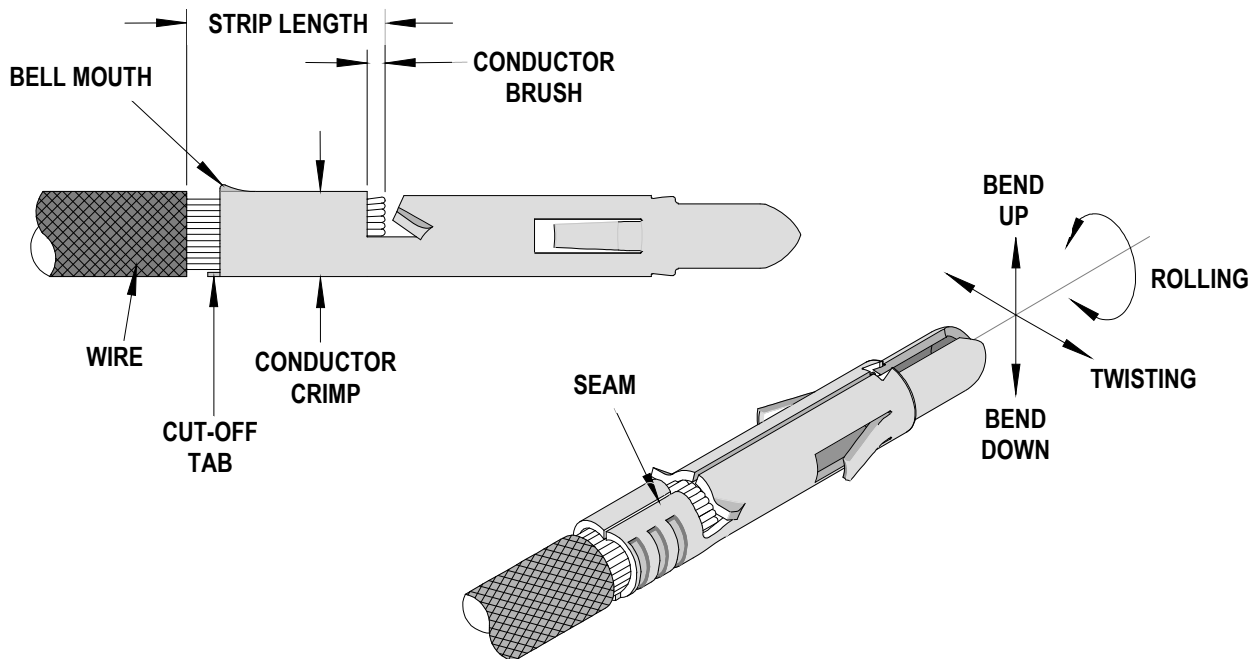
- Directly adapts to most crimp press and automatic wire processing machines
- Applicator designed to industry-standard mounting and shut height of 135.80mm (5.346")
- Conductor and insulation rings allow quick adjustment for conductor and insulation crimp height change
- Quick setup time; plus, the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

**SCOPE**

Products: MLX Crimp Terminals, 10-12 AWG.

Terminal Series No.	Terminal Order No.	Wire Size		Insulation Diameter		Strip Length	
		AWG	mm <sup>2</sup>	mm	In.	mm	In.
36663	36663-0001	10-12	5.00-3.30	5.08	.200	6.40-7.14	.252-.281
36664	36664-0001	10-12	5.00-3.30	5.08	.200	6.40-7.14	.252-.281

**DEFINITION OF TERMS**



## CRIMP SPECIFICATIONS

Terminal Series No.	Bell Mouth		Cut-Off Tab Max.		Conductor Brush	
	mm	In.	mm	In.	mm	In.
36663	0.30-0.60	.012-.024	0.50	.020	0.30-0.80	.012-.031
36664	0.30-0.60	.012-.024	0.50	.020	0.30-0.80	.012-.031

Terminal Series No.	Bend Up	Bend Down	Twist	Roll	Punch Width (Ref)				Seam
					Conductor		Insulation		
	Degree		Degree		mm	In.	mm	In.	
36663	3	3	3	5	3.45	.136	N/A	N/A	Seam to be closed, and no wire allowed out of the crimping area.
36664	3	3	3	5	3.45	.136	N/A	N/A	

## CONDITIONS

After crimping, the conductor profiles should measure the following (see notes on page 5):

Terminal Series No.	Wire Size		Crimp Height				Crimp Width				Pull Force Minimum	
			Conductor		Insulation		Conductor		Insulation			
	AWG	mm <sup>2</sup>	mm	In.	mm	In.	mm	In.	mm	In.	N	Lb.
36663	10	5.0	2.35-2.45	.093-.095	N/A	N/A	3.50-3.60	.138-.142	N/A	N/A	355.9	80.0
	12	3.3	1.90-2.00	.075-.078	N/A	N/A	3.50-3.60	.138-.142	N/A	N/A	311.4	70.0
36664	10	5.0	2.35-2.45	.093-.095	N/A	N/A	3.50-3.60	.138-.142	N/A	N/A	355.9	80.0
	12	3.3	1.90-2.00	.075-.078	N/A	N/A	3.50-3.60	.138-.142	N/A	N/A	311.4	70.0

## 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.

**PARTS LIST**

<b>Mini-Mac Applicator 63832-5200</b>				
<b>Item</b>	<b>Order No.</b>	<b>Engineering No.</b>	<b>Description</b>	<b>Quantity</b>
<b>Perishable Tooling</b>				
	63832-5270	63832-5270	Tool Kit (All "Y" Items)	REF
1	63801-5973	63801-5973	Conductor Punch	1 Y
2	63801-5972	63801-5972	Conductor Anvil	1 Y
3	63443-0037	63443-0037	Front Cut-Off Plunger	1 Y
4	63443-0038	63443-0038	Front Cut-off Plunger Retainer	1 Y
<b>Other Components</b>				
5	11-18-4083	60707-8	Front Cover	1
6	63443-0009	63443-0009	Front Scrap Chute	1
7	63443-0021	63443-0021	Lower Tooling Key	1
8	63443-0061	63443-0061	Wire Stop	1
9	63443-2503	63443-2503	Spacer (Anvil Mount)	1
10	63443-6130	63443-6130	Rear Cover	1
11	63466-0502	63466-0502	Front Plunger Striker	1
12	63600-1290	63600-1290	Washer	1
13	63700-0539	63700-0539	Cut-Off Plunger Spring	1
14	63890-0866	63890-0866	Collar-6.4 Long	1
<b>Frame</b>				
15	63801-3201	63801-3201	Mechanical Feed Applicator Frame Head	1
16	63801-3281	63801-3281	Base	1
17	63801-4650	63801-4650	Track Assembly	1
<b>Hardware</b>				
18	N/A	N/A	M3 by 6 Long SHCS	2**
19	N/A	N/A	M4 by 6 Long SHCS	1**
20	N/A	N/A	M4 by 14 Long SHCS	2**
21	N/A	N/A	M4 by 50 Long SHCS	2**
22	N/A	N/A	M5 by 12 Long SHCS	1**
23	N/A	N/A	M8 by 30 Long BHCS	1**
24	N/A	N/A	3mm by 6 Long Roll Pin	1**
** Available from an industrial supply company such as MSC (1-800-645-7270).				

### Assembly Drawing

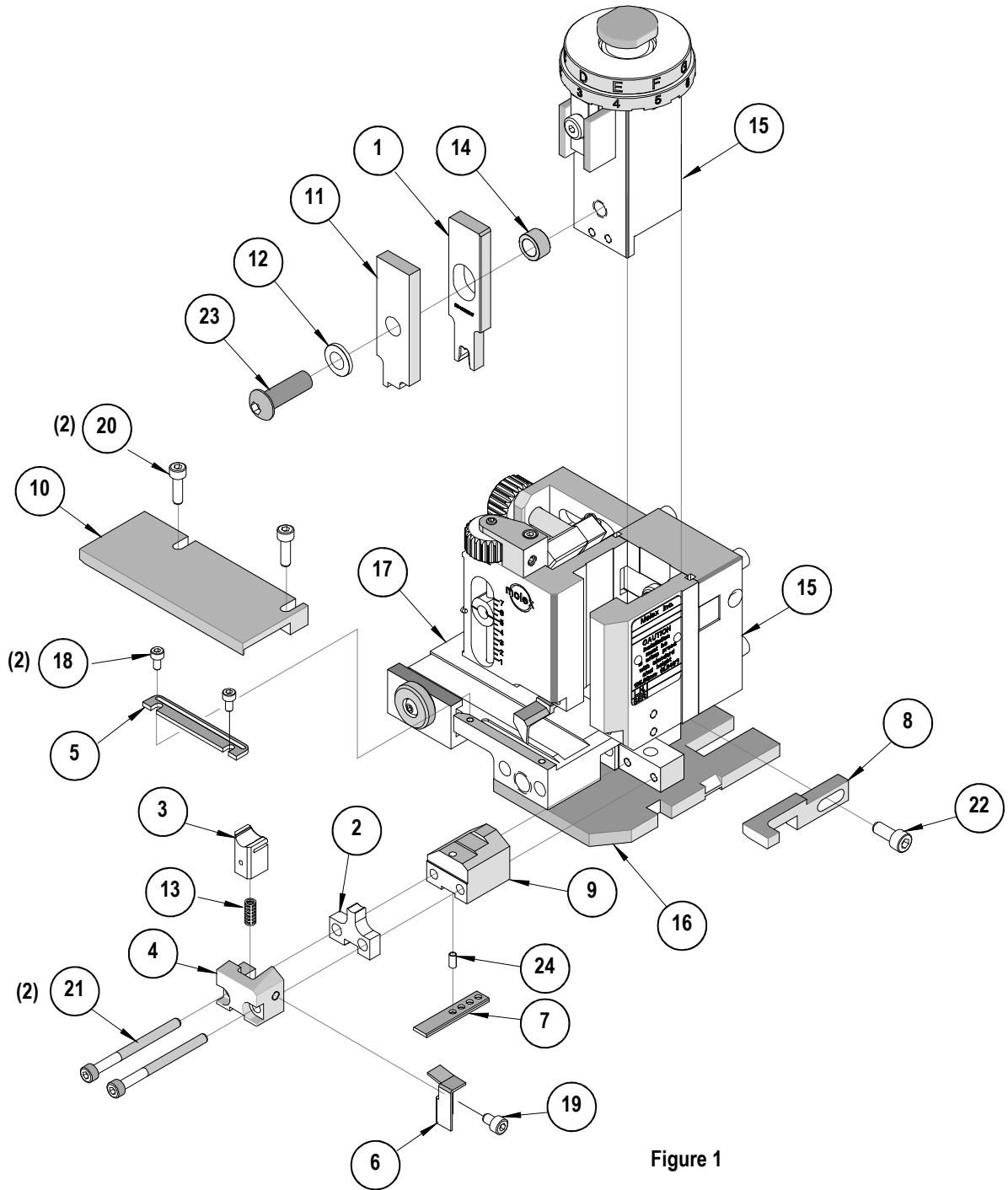


Figure 1

## NOTES

1. Molex recommends that an extra perishable tooling kit be maintained at your facility.
2. Verify tooling alignment by manually cycling the press with the applicator before crimping under power. Check that all screws are tight.
3. Slugs, terminals, dirt and oil should be kept clear of the work area.
4. Wear safety glasses at all times.
5. For recommended maintenance, refer to the industrial Mini-Mac applicator manual.

**CAUTION:** This applicator should only be used in a press with a shut height of 135.8 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.

### Application Tooling Support

**Phone:** (402) 458-TOOL (8665)

**E-Mail:** [applicationtooling@molex.com](mailto:applicationtooling@molex.com)

**Website:** [www.molex.com/applicationtooling](http://www.molex.com/applicationtooling)

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