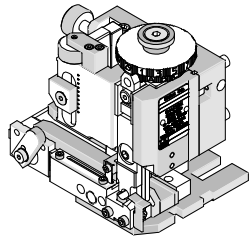
Mini-Mac Applicator

molex

Application Tooling Specification Sheet



Order No. 63891-4100

FEATURES

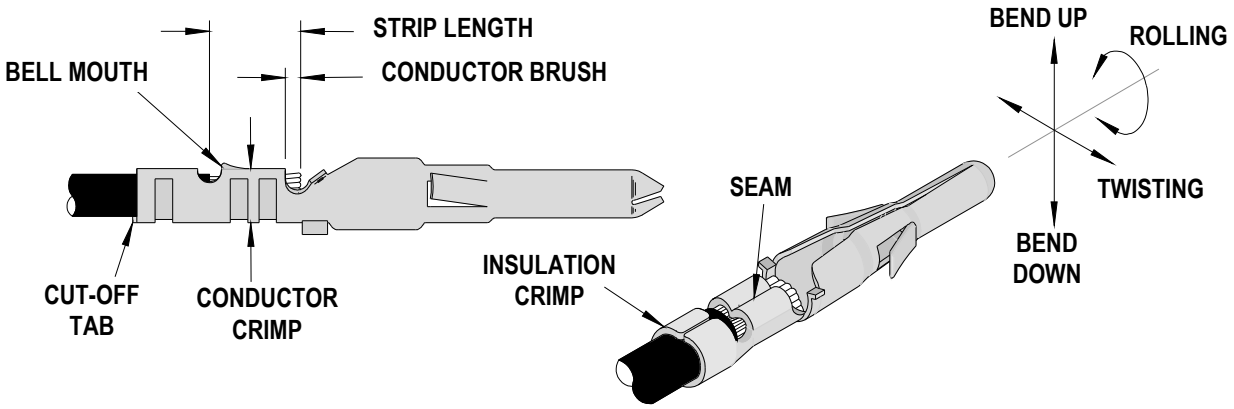
- Directly adapts to most automatic wire processing machines
- Applicator designed to industry standard mounting and shut height 135.80mm (5.346")
- Quick set-up time; plus the crimp height, track and feed adjustments can be set without removing the applicator from the press
- Fine adjustment allows 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: 1.57mm (.062") Diameter, Standard .062" Pin and Socket Crimp Terminal 24-30 AWG.

Terminal Series No.	Terminal Order No.			Wire Size		Insulation Diameter		Strip Length	
				AWG	mm²	mm	In.	mm	In.
1854	02-06-2131	02-06-2134	02-06-6130	24-30	0.20-0.05	1.78 Max.	.070 Max.	3.18-3.96	.125-.156
	02-06-6137	02-06-6138	02-06-6143						
	02-06-6145	04-01-0809							
	39-00-0280	39-00-0336		22-28	0.33-0.08	1.50 Max.	.059 Max.	3.18-3.96	.125-.156
1855	02-06-1131	02-06-1141	02-06-1143	24-30	0.20-0.05	1.78 Max.	.070 Max.	3.18-3.96	.125-.156
	02-06-5130	02-06-5137	02-06-5138						
	02-06-5147	04-01-0810							
	39-00-0338	39-00-0340		22-28	0.33-0.08	1.50 Max.	.059 Max.	3.18-3.96	.125-.156
2189	02-06-1231	02-06-3202	02-06-5203	24-30	0.20-0.05	1.78 Max.	.070 Max.	3.18-3.96	.125-.156
	02-06-5212								
2190	02-06-2231	02-06-4202	02-06-6207	24-30	0.20-0.05	1.78 Max.	.070 Max.	3.18-3.96	.125-.156
4559	02-06-1109	02-06-5211		24-30	0.20-0.05	1.78 Max.	.070 Max.	3.18-3.96	.125-.156

DEFINITION OF TERMS



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

CRIMP SPECIFICATIONS

Terminal Series No.		Wire Size		Bell mouth		Cut-off Tab Ma imum		Conductor Brush	
		AWG	mm²	mm	In.	mm	In.	mm	In.
1854		24-30	0.20-0.05	0.10-0.60	.004-.024	0.13	.005	.25-1.00	.010-.039
1854	39-00-0280 39-00-0336 Only	22-28	0.33-0.08	0.10-0.60	.004-.024	0.50	.019	.25-1.00	.010-.039
1855		24-30	0.20-0.05	0.10-0.60	.004-.024	0.13	.005	.25-1.00	.010-.039
1855	39-00-0338 39-00-0340 Only	22-28	0.33-0.08	0.10-0.60	.004-.024	0.50	.019	.25-1.00	.010-.039
2189		24-30	0.20-0.05	0.10-0.60	.004-.024	0.13	.005	.25-1.00	.010-.039
2190		24-30	0.20-0.05	0.10-0.60	.004-.024	0.13	.005	.25-1.00	.010-.039
4559		24-30	0.20-0.05	0.10-0.60	.004-.024	0.13	.005	.25-1.00	.010-.039

Terminal Series No.	Wire Size		Punch Width mm (Ref)				Seam
	AWG	mm²	Conductor		Insulation		
			mm	In	mm	In	
1854	22-30	0.33-0.05	1.65	.065	1.65	.065	Seam shall not be open and no wire allowed out of the crimping area.
1855	22-30	0.33-0.05	1.65	.065	1.65	.065	
2189	24-30	0.20-0.05	1.65	.065	1.65	.065	
2190	24-30	0.20-0.05	1.65	.065	1.65	.065	
4559	24-30	0.20-0.05	1.65	.065	1.65	.065	

PARTS LIST

Mini-Mac Applicator 63891-4100				
Item	**Order No**	**Engineering No.**	**Description**	**Quantity**
Perishable Tooling				
	63891-4170	63891-4170	Tool Kit (All "Y" Items)	REF
1	11-18-4120	60707-9	Conductor Punch	1 Y
2	11-18-4122	60707-11	Combination Anvil	1 Y
3	11-18-4121	60707-10	Insulation Punch	1 Y
4	11-17-3076	7163-30	Front Cut-Off Plunger	1 Y
5	11-17-3079	7163-33	Rear Cut-Off Plunger	1 Y
6	11-17-2136	7163-4	Rear Cut-Off Die Blade	1 Y
7	11-18-4246	60707-18	Front Cut-off Plunger Retainer	1 Y
8	11-18-4247	60707-19	Rear Cut-off Plunger Retainer	1 Y
Other Components				
9	11-17-2140	7163-8	Insulation Punch Spacer	1
10	11-17-2152	7163-14	Hold Down Pad	1
11	11-18-4079	60707-4	Cover Plate	1
12	11-18-4081	60707-6	Front Plunger Striker	1
13	11-18-4082	60707-7	Rear Plunger Striker	1
14	11-18-4083	60707-8	Feed Guide	1
15	11-18-5060	60707-21	Cut-off Plunger Spring	2
16	63443-0090	63443-0090	Wire Stop	1
17	63803-5127	63803-5127	Conductor Bushing	1
Frame				
18	63801-3201	63801-3201	Top	1
19	63801-3282	63801-3282	Base	1

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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 MiniMac 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.

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