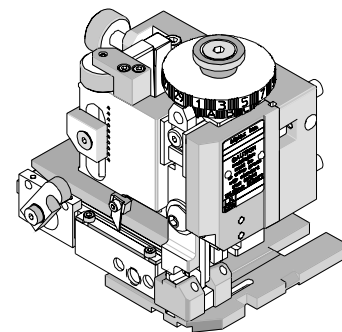




# Mini-Mac Applicator Specification Sheet Order No. 63892-5000



## 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 barrel crimp height and .063mm (.0025") for insulation height. See notes on Page 2.
- Independent adjustment rings allow users to quickly adjust the conductor or insulation crimp height without affecting each other.

## SCOPE

Products: Board-In Crimp Terminal Male, 22-26 AWG.

| Terminal Series No. | Terminal Order No. | Wire Size |                 | Insulation Diameter |           | Strip Length |           |
|---------------------|--------------------|-----------|-----------------|---------------------|-----------|--------------|-----------|
|                     |                    | AWG       | mm <sup>2</sup> | mm                  | In.       | mm           | In.       |
| 4811                | 16-02-0037         | 22-26     | 0.35-0.12       | 2.29-2.54           | .090-.100 | 5.97-6.35    | .235-.250 |
|                     | 16-02-0041         |           |                 |                     |           |              |           |

## DEFINITION OF TERMS

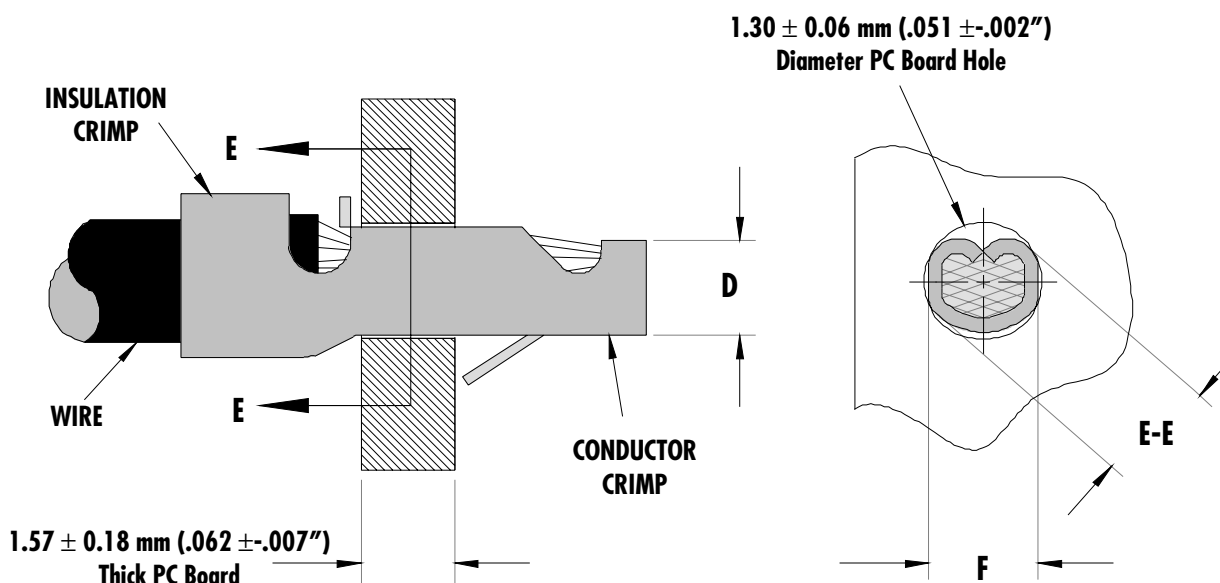


Figure 1

Section E-E

## CRIMP SPECIFICATIONS

After crimping, the conductor profiles should measure the following (See Figure 1).

| Terminal Series No. | Wire Size |                 | Dimensions (Figure 1) |           |              |           |          |      | Pull Force Min. |     |
|---------------------|-----------|-----------------|-----------------------|-----------|--------------|-----------|----------|------|-----------------|-----|
|                     |           |                 | D (Conductor)         |           | E-E (Barrel) |           | F (Ref.) |      |                 |     |
|                     | AWG       | mm <sup>2</sup> | mm                    | In        | mm           | In..      | mm       | In.  | N               | Lb. |
| 4811                | 22        | 0.35            | 0.88-0.97             | .035-.038 | 1.19-1.24    | .047-.049 | 0.97     | .038 | 13.30           | 3.0 |
|                     | 24        | 0.20            | 0.88-0.97             | .035-.038 | 1.19-1.24    | .047-.049 | 0.97     | .038 | 13.30           | 3.0 |
|                     | 26        | 0.12            | 0.84-0.91             | .033-.036 | 1.19-1.24    | .047-.049 | 0.97     | .038 | 13.30           | 3.0 |

⚠ The crimp on this terminal is not an electrical crimp; the final soldering operation is the electrical connection. This minimum force is what should be expected when pulling the terminal with both insulation and conductor crimped.

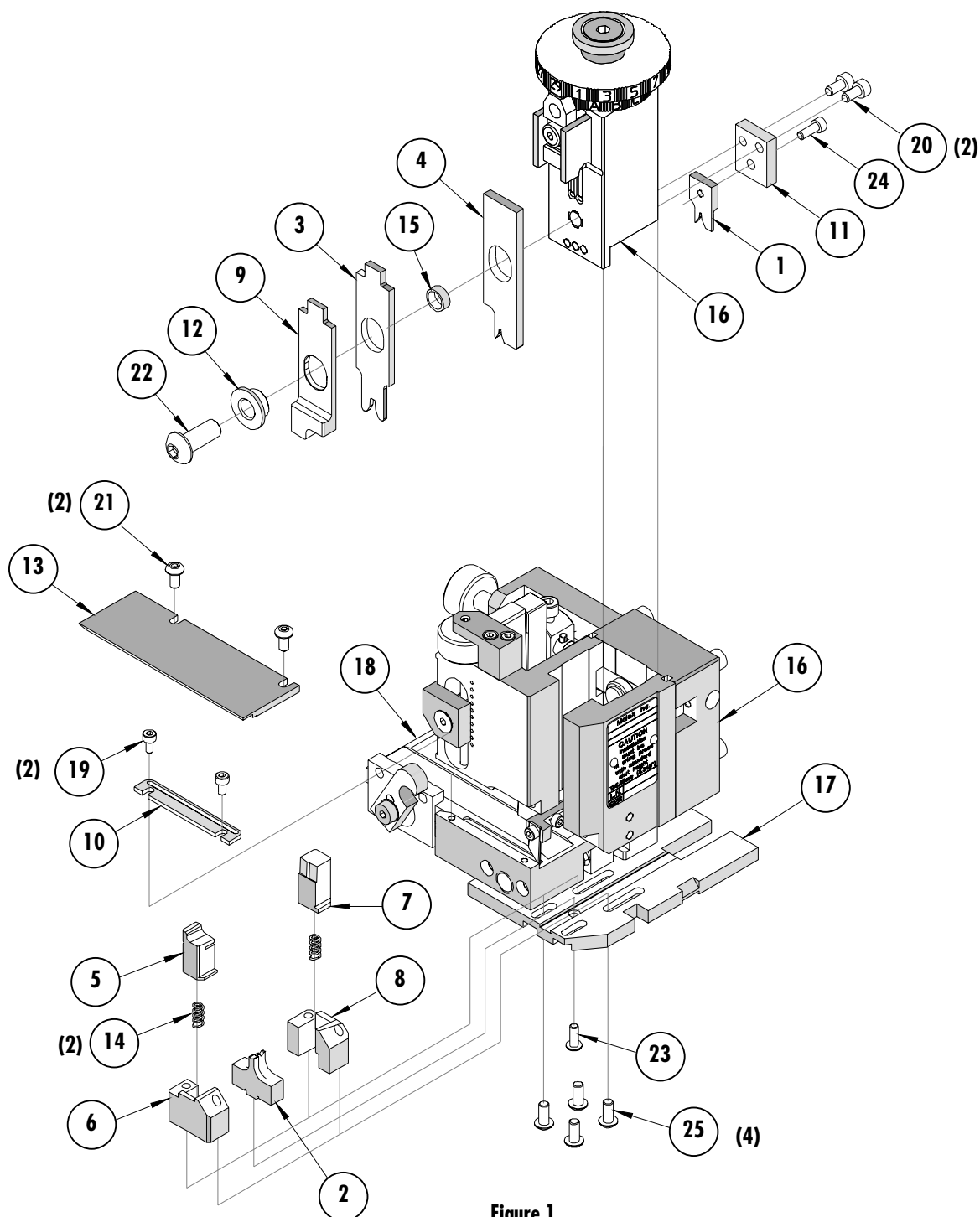
### Notes:

- 1 The Conductor crimp (D dimension on Figure 1) should be set at the maximum height to contain all wire strands, meet minimum pull, and fit into the PCB Hole. The insulation and barrel crimps are adjustable, by the cams (rings) on top of the Mini-Mac ram. The conductor crimp height is not adjustable. Shimming may be required of the conductor punch to optimize this for different wire types.

**PARTS LIST**

| <b>Mini-Mac Applicator 63892-5000</b>  |                 |                        |                                    |                 |
|--|-----------------|------------------------|------------------------------------|-----------------|
| <b>Item</b>  | <b>Order No</b> | <b>Engineering No.</b> | <b>Description</b>                 | <b>Quantity</b> |
| <b>Perishable Tooling</b>  |                 |                        |                                    |                 |
|  | 63892-5070      | 63892-5070             | Tool Kit (All "Y" Items)           | REF             |
| 1  | 11-18-4272      | 60702A103              | Conductor Punch                    | 1 Y             |
| 2  | 11-18-4274      | 60702A105              | Combination Anvil                  | 1 Y             |
| 3  | 11-18-4270      | 60702A101              | Insulation Punch                   | 1 Y             |
| 4  | 11-18-4271      | 60702A102              | Barrel Form Punch                  | 1 Y             |
| 5  | 11-18-4032      | 60705A106              | Cut-Off Plunger                    | 1 Y             |
| 6  | 11-18-4033      | 60705A107              | Cut-off Plunger Retainer           | 1 Y             |
| 7  | 11-18-4276      | 60702A107              | Rear Cut-Off Plunger and Wire Stop | 1 Y             |
| 8  | 11-18-4277      | 60702A108              | Rear Cut-off Plunger Retainer      | 1 Y             |
| <b>Other Components</b>  |                 |                        |                                    |                 |
| 9  | 11-18-4034      | 60705A108              | Front Plunger Striker              | 1               |
| 10   | 11-18-4083      | 60707-8                | Feed Guide                         | 1               |
| 11   | 11-18-4278      | 60702A109              | Rear Plunger Striker               | 1               |
| 12   | 11-18-4279      | 60702A110              | Tooling Washer                     | 1               |
| 13   | 11-18-4282      | 60702A113              | Rear Cover                         | 1               |
| 14   | 11-24-1067      | 4996-4                 | Cut-off Plunger Spring             | 2               |
| 15   | 63803-5108      | 63803-5108             | Conductor Bushing                  | 1               |
| <b>Frame</b>   |                 |                        |                                    |                 |
| 16   | 63801-3201      | 63801-3201             | Top                                | 1               |
| 17   | 63801-3282      | 63801-3282             | Base                               | 1               |
| 18   | 63801-6550      | 63801-6550             | Track                              | 1               |
| <b>Hardware</b>  |                 |                        |                                    |                 |
| 19   | N/A             | N/A                    | M3 by 8 Long SHCS                  | 2**             |
| 20   | N/A             | N/A                    | M4 by 8 Long SHCS                  | 2**             |
| 21   | N/A             | N/A                    | M4 by 8 Long BHCS                  | 2**             |
| 22   | N/A             | N/A                    | M8 by 20 Long BHCS                 | 1**             |
| 23   | N/A             | N/A                    | #6-32 by 3/8" Long BHCS            | 1**             |
| 24   | N/A             | N/A                    | #6-32 by 3/8" Long SHCS            | 1**             |
| 25   | N/A             | N/A                    | #8-32 by 3/8" Long BHCS            | 4**             |
| ** Available from an industrial supply company such as MSC (1-800-645-7270). |                 |                        |                                    |                 |

# Assembly Drawing



## 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 Mini-Mac Manual.

**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

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