

Mini-Mac Applicator

Application Tooling Specification Sheet



Order No. 63891-2000

FEATURES

- Directly adapts to most automatic wire processing machines. This applicator ships from the factory set-up in the up-stroke condition for bench-top operation; however it will directly adapt to most automatic wire processing machines. Please review the applicator manual that shipped with your tool and is linked on the Molex website.
- 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.
- Optimum terminal feed/indexing can be obtained with the optional terminal guide assembly, Order No. 63830-0120. See page 5.
- Easy change-over for terminal feeding (up-stroke or down-stroke). Applicator shipped as up-stroke.

SCOPE

Products: Mini-Fit Sr. ™ Male and Female Crimp Terminals, 14 to 16 AWG

Terminal	Terminal Order No.			Wire Size		Insulation Diameter Maximum		Strip Length	
Series No.			AWG	mm²	mm	ln.	mm	In.	
42815	42815-0040	42815-0041	42815-0042	14-16	N/A	3.33	0.131	4.25-4.75	.167187
42015	42815-0049	42815-0144		14-10	N/A	3.33	0.131	4.20-4.70	.10/10/
	42817-0040	42817-0041	42817-0042	14-16	N/A		0.131		
42817	42817-0049	42817-0140	42817-0141			3.33		4.25-4.75	.167187
42017	42817-0142	42817-0149	42817-1044			3.33		4.20-4.70	.10/10/
	42817-1144								
(1) Crimp terminals to stranded copper wire only.									
(2) Lubricate terminals plated in precious metals using Molex Oiler 63801-7240.									



CRIMP SPECIFICATIONS

Terminal Series No.	Bell n	nouth	Cut-off Tab	o Maximum	Conductor Brush		
Terminal Series NO.	mm	In.	mm	ln.	mm	ln.	
42815	0.20-0.50	.008020	0.50	.020	0.25-0.75	.010030	
42817	0.20-0.50	.008020	0.50	.020	0.25-0.75	.010030	

	Dond up	Bend up Bend down		Dell	Punch Width (Ref)			
Terminal Series No.	Bella up	Twist	RUII	Conductor		Insulation		
	Degree		Degree		mm	In	mm	In
42815	3	3	4	8	3.20	.126	4.50	.177
42817 3 3 4 8 3.20 .126 4.50 .17					.177			
Seam								
Seam shall r	not be open	and no wire a	llowed o	out of th	ie crim	oing are	ea.	

After crimping, the conductor profile should measure the following.

	Wire	Size		Conduct	or		Pull F	orce
Terminal Series No.	Wire Size		Crimp Height		Crimp Width		Minimum	
	AWG	mm ²	mm	ln.	mm	ln.	Ν	Lb.
42815	14	N/A	1.89-1.99	.074078	3.20	.126	222.4	50.00
42010	16	N/A	1.82-1.92	.072075	3.20	.126	133.4	30.00
42817	14	N/A	1.89-1.99	.074078	3.20	.126	222.4	50.00
42017	16	N/A	1.82-1.92	.072075	3.20	.126	133.4	30.00

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

Operation Perishable Tooling 63891-2070 Tool Kit (All "Y" Items) REF 1 63830-0301 63830-0302 Conductor Punch 1 Y 2 63830-0302 63830-0302 Conductor Anvil 1 Y 3 63830-0305 Insulation Punch 1 Y 4 63445-4502 Ga445-4502 Insulation Anvil 1 Y 5 63443-0045 63443-0045 Front Cut-off Plunger 1 Y 6 63443-0046 63443-0046 Front Cut-off Plunger Retainer 1 Y 6 63443-0046 63443-0024 De used on all wire processors only. 0 7 63443-0024 63443-0024 Lower Tooling Key 1 9 63443-0024 63443-0024 Lower Tooling Washer 1 10 63443-2214 Course Spacer (14.00mm) 1 11 63443-2214 Course Spacer (14.00mm) 1 12 63443-2208 Fine Spacer (3.40mm) 1 13 63700-0539 Cut-Off Plunger Spring 1	Mini-Mac Applicator 63891-2000					
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Hardware 23 N/A N/A M3 by 6 Long FHCS 1** 24 N/A N/A M3 by 6 Long SHCS 2** 25 N/A N/A M4 by 6 Long SHCS 5** 26 N/A N/A M4 by 12 Long BHCS 2** 27 N/A N/A M4 by 50 Long SHCS 2** 28 N/A N/A M5 by 12 Long SHCS 1** 29 N/A N/A M8 by 20 Long BHCS 1** 30 N/A N/A 2mm by 8 Long Roll Pin 1**						
23 N/A N/A M3 by 6 Long FHCS 1** 24 N/A N/A M3 by 6 Long SHCS 2** 25 N/A N/A M4 by 6 Long SHCS 5** 26 N/A N/A M4 by 12 Long BHCS 2** 27 N/A N/A M4 by 50 Long SHCS 2** 28 N/A N/A M5 by 12 Long SHCS 1** 29 N/A N/A M8 by 20 Long BHCS 1** 30 N/A N/A 2mm by 8 Long Roll Pin 1**	22	63801-4650	63801-4650		1	
24 N/A N/A M3 by 6 Long SHCS 2** 25 N/A N/A M4 by 6 Long SHCS 5** 26 N/A N/A M4 by 12 Long BHCS 2** 27 N/A N/A M4 by 50 Long SHCS 2** 28 N/A N/A M4 by 50 Long SHCS 2** 29 N/A N/A M5 by 12 Long SHCS 1** 30 N/A N/A 2mm by 8 Long Roll Pin 1**		1			1	
25 N/A N/A M4 by 6 Long SHCS 5** 26 N/A N/A M4 by 12 Long BHCS 2** 27 N/A N/A M4 by 50 Long SHCS 2** 28 N/A N/A M5 by 12 Long SHCS 1** 29 N/A N/A M8 by 20 Long BHCS 1** 30 N/A N/A 2mm by 8 Long Roll Pin 1**						
26 N/A N/A M4 by 12 Long BHCS 2** 27 N/A N/A M4 by 50 Long SHCS 2** 28 N/A N/A M5 by 12 Long SHCS 1** 29 N/A N/A M8 by 20 Long BHCS 1** 30 N/A N/A 2mm by 8 Long Roll Pin 1**						
27 N/A N/A M4 by 50 Long SHCS 2** 28 N/A N/A M5 by 12 Long SHCS 1** 29 N/A N/A M8 by 20 Long BHCS 1** 30 N/A N/A 2mm by 8 Long Roll Pin 1**	25				-	
28 N/A N/A M5 by 12 Long SHCS 1** 29 N/A N/A M8 by 20 Long BHCS 1** 30 N/A N/A 2mm by 8 Long Roll Pin 1**	26					
29 N/A N/A M8 by 20 Long BHCS 1** 30 N/A N/A 2mm by 8 Long Roll Pin 1**	27					
30 N/A 2mm by 8 Long Roll Pin 1**	28				-	
	29			M8 by 20 Long BHCS	-	
	30					
	aescri	ptions listed ab	ove in the parts list ta	adie.		

Abbreviation descriptions: SHCS = Socked Head Cap Screw, FHCS = Flat Head Cap Screw, SSS = Socket Set Screw, BHCP = Button Head Cap Screw, Roll Pin = Spiral Pin.



Older Version Applicators

Older versions of this applicator can be updated with the Terminal Guide Assembly please order the parts below.

The Terminal Guide Assembly helps to align slightly bent up or down terminals, entering the track. Recommended for use with wire processing equipment, or roughly handled terminal reels. To install the Terminal Guide assembly follow the steps below.

- 1. Remove the (2) M4 by 12 BHCS from the existing rear cover.
- 2. Remove the rear cover
- 3. Replace it with the 63830-0120 Terminal Guide Assembly.
- 4. Replace the (2) M4 by 12 BHCS.



ltem	Order No	Engineering No.	Description	Quantity		
1	63830-0117	63830-0117	Terminal Lead-In	2		
2	63830-0118	63830-0118	Rear Cover	1		
		Hardwa	are			
3	N/A	N/A	M4 by 6 Long SHCS	4**		
 ** Fastener parts can be obtained through most industrial supply houses by using the generic descriptions listed above in the parts list table. Abbreviation descriptions: SHCS = Socked Head Cap Screw, FHCS = Flat Head Cap Screw, SSS = Socket Set Screw, BHCP = Button Head Cap Screw, Roll Pin = Spiral Pin. 						

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 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 tooling crimp specifications are valid only when used with Molex terminals and tooling manufactured by Molex or authorized distributors ("Molex Tooling"). When using tooling other than Molex Tooling with specific Molex specific connector systems listed in our ATS documents, the Molex tooling qualification does not apply and the responsibility for full qualification of the connector system is that of the customer. Molex accepts no liability for connector performance or tooling support where tooling other than Molex Tooling is used, or where Molex Tooling is modified.
CAUTION	A-620 and other industry standards do not supersede the manufacturer's specifications. Some terminals designed over 20 years ago may not meet the desired physical attributes for some of today's standards. However, these terminals will still perform electrically at an acceptable quality level based on the qualification testing and years of successful performance in the field.

Contact Information

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