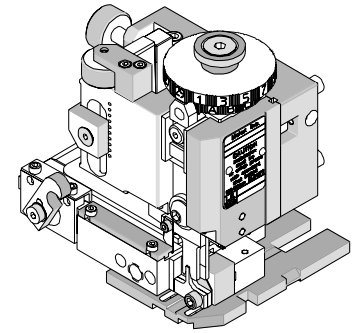




# Mini-Mac Applicator Specification Sheet Order No. 63888-1200



## FEATURES

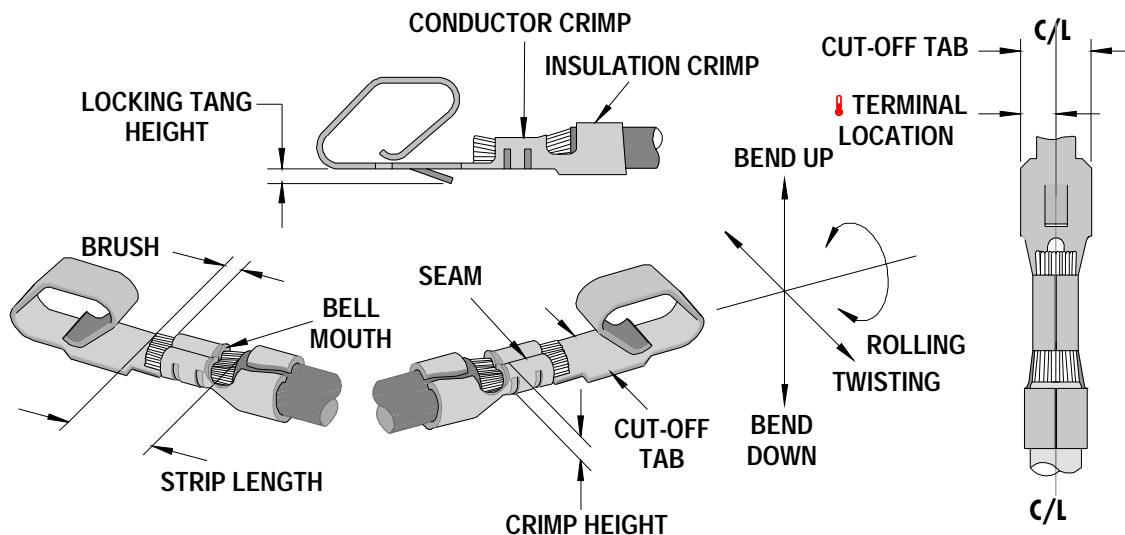
- Directly adapts to most automatic wire processing machines
- Applicator designed to industry standard mounting and shut height 135.80mm (5.346")
- Quick set-up time; plus the crimp height, track and feed adjustments can be set without removing the applicator from the press
- Fine adjustment allows 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: KK® 3.96 and 5.08mm (.156 and .200") Center Cat Ear Crimp Terminal, 18-26 AWG.

Terminal Series No.	Terminal Order No.	Wire Size		Insulation Diameter Maximum		Strip Length	
		AWG	mm <sup>2</sup>	mm	In.	mm	In.
5167	08-70-0012	18-26	0.82-0.12	2.79	.110	2.54-3.18	.100-.125

## DEFINITION OF TERMS



Terminal is to be centrally located between the two (2) cut-off tab edges by one half of the total cut-off tab tolerance.

This illustration is a generic terminal representation and not an exact image of any terminal listed in the scope.

**CRIMP SPECIFICATIONS**

Terminal Series No.	Bell mouth		Cut-off Tab		Conductor Brush	
	mm	In.	mm	In.	mm	In.
5167			2.64-.2.80	.104-.110		

Terminal Series No.	Locking Tang Height		Bend up	Bend down	Twist	Roll	Punch Width (Ref)				Seam Seam shall not be open and no wire allowed out of the crimping area
	mm	In	Degree				Degree		Conductor		
5167	0.51-0.77	.020-.030					1.925	.076	2.43	.096	

**NOTE:** Some of the specifications in these charts above are intentionally left blank due to the fact that the information does not currently exist.

After crimping, the conductor profile should measure the following.

Terminal Series No.	Wire Size		Crimp Height		Crimp Width (Ref)		Pull Force Minimum	
	AWG	mm <sup>2</sup>	mm	In.	mm	In.	N	Lb.
5167	18	0.82	1.09-1.14	.043-.045			111.21	25.0
	20	0.52	1.02-1.09	.040-.043			66.72	15.0
	22	0.35	0.96-1.02	.038-.040			44.48	10.0
	24	0.20	0.91-0.96	.036-.038			35.59	8.0
	26	0.12	0.86-0.91	.034-.036			26.69	6.0

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 63888-1200				
Item	Order No	Engineering No.	Description	Quantity
<b>Perishable Tooling</b>				
	63888-1270	63888-1270	Tool Kit (All "Y" Items)	REF
1	11-18-4108	60712-8	Conductor Punch	1 Y
2	11-18-4110	60712-10	Conductor Anvil	1 Y
3	11-18-4107	60712-7	Insulation Punch	1 Y
4	11-18-4111	60712-11	Insulation Anvil	1 Y
5	11-18-4109	60712-9	Cut-Off Punch	1 Y
6	11-18-4470	60712-24	Cut-Off Insert	1 Y
<b>Other Components (REF 881250)</b>				
7	11-18-4006	60703-8	Stripper Blade Holder	1
8	11-18-4103	60712-3	Cover Plate	1
9	11-18-4106	60712-6	Insulation Punch Spacer	1
10	11-18-4332	60703-16	Stripper	1
11	11-18-4471	60712-25	Retainer Block	1
12	11-18-5015	60805A122	Front Cover	1
13	11-40-4085	8301-10	Terminal Stop and Scrape Shield	1
14	63803-5120	63803-5120	Conductor Bushing	1
15	63820-0012	63820-0012	Cover-Drag Frame	1
<b>Frame</b>				
16	63801-3201	63801-3201	Top	1
17	63801-3283	63801-3283	Base	1
18	63801-6550	63801-6550	Track	1
<b>Hardware</b>				
19	N/A	N/A	M3 by 6 Long SHCS	2**
20	N/A	N/A	M3 by 8 Long SHCS	2**
21	N/A	N/A	M4 by 6 Long SHCS	2**
22	N/A	N/A	M4 by 12 Long BHCS	2**
23	N/A	N/A	M5 by 10 Long SHCS	1**
24	N/A	N/A	M8 by 20 Long BHCS	1**
25	N/A	N/A	#4-40 by .19" Long SHCS	2**
26	N/A	N/A	#6-32 by 3/8" Long BHCS	2**
27	N/A	N/A	#10-32 by 1.120" Long SHCS	1**
** Available from an industrial supply company such as MSC (1-800-645-7270).				

# Assembly Drawing

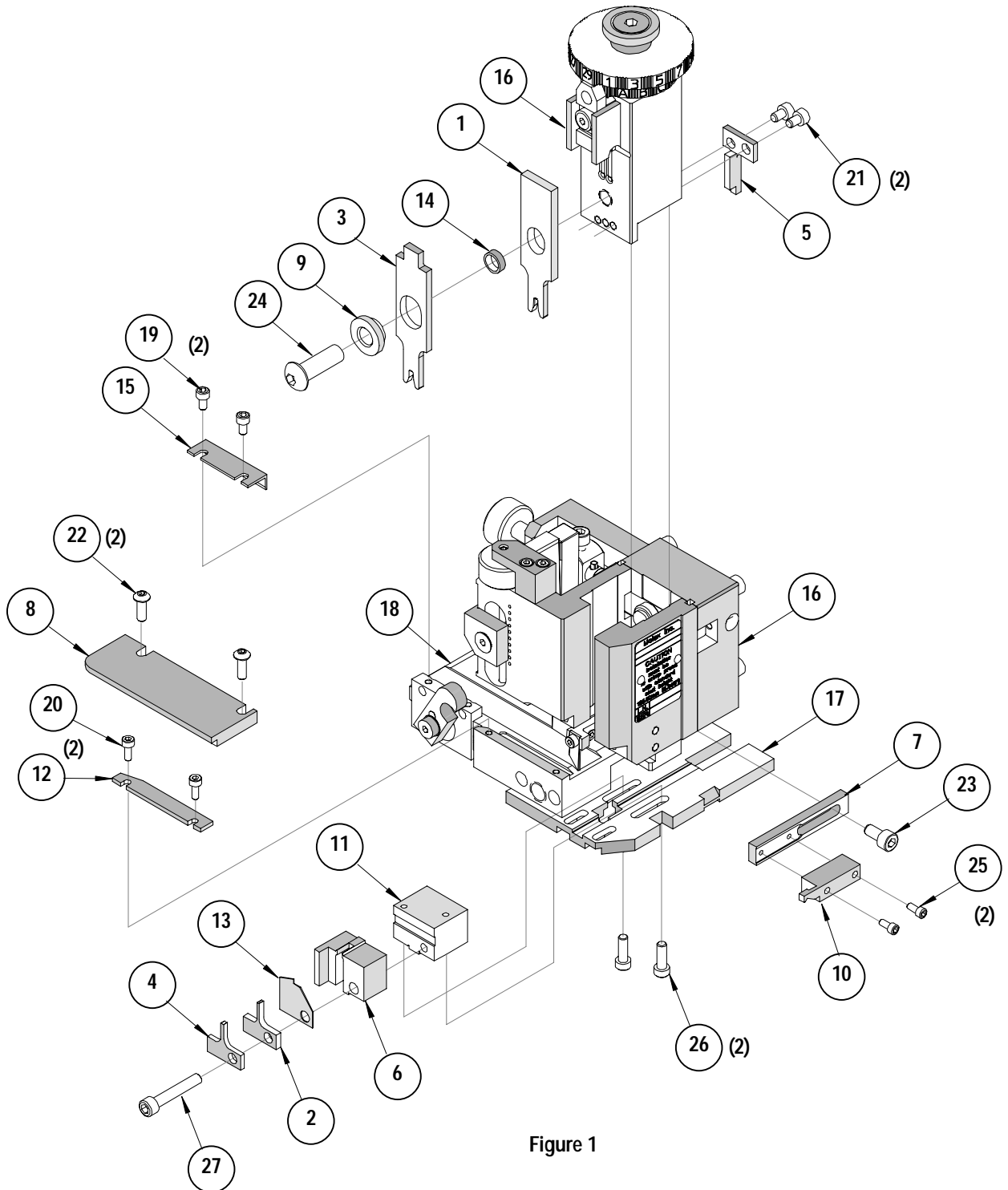


Figure 1

## NOTES

1. Molex recommends an extra perishable tooling kit be maintained at your facility.
2. Verify tooling alignment by manually cycling the press 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.

**Americas Headquarters**  
Lisle, Illinois 60532 U.S.A.  
1-800-78MOLEX  
amerinfo@molex.com

**Far East North Headquarters**  
Yamato, Kanagawa, Japan  
81-462-65-2324  
feninfo@molex.com

**Far East South Headquarters**  
Jurong, Singapore  
65-6-268-6868  
fesinfo@molex.com

**European Headquarters**  
Munich, Germany  
49-89-413092-0  
eurinfo@molex.com

**Corporate Headquarters**  
2222 Wellington Ct.  
Lisle, IL 60532 U.S.A.  
630-969-4550  
Fax: 630-969-1352

Visit our Web site at <http://www.molex.com>