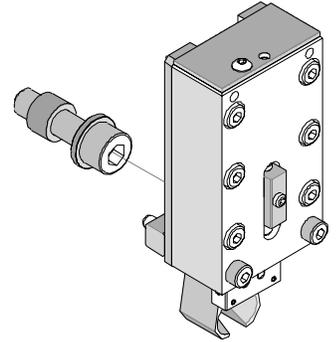




**Mini-Mac Applicator Accessory
Application Tooling Specification
Wire Guide Funnel - Continuous Molded Strip
Order No. 63883-7060**



FEATURES

- Directly mounts to face of 63883-7000 applicator.
- Provides additional wire guidance to prevent wire strands from folding back outside the terminal barrel.
- Adjustable funnel height to match various terminal barrel heights.
- Intended for use in automatic wire processors with split-cycle presses.

SCOPE

Products: Terminals crimped in the applicators listed below, using a 3.00mm (0.118 in.) nominal wire insulation diameter. Wires with smaller insulation diameter, may not be effectively guided in the funnel.

Applicators:
63883-7000

Product List

From the applicators listed above, refer to the product list on the applicator specification sheet available at www.molex.com.

WIRE GUIDE FUNNEL ASSEMBLY

The wire guide funnel consists of a slide assembly and a (wire-specific) funnel assembly. Funnels must be installed on the slide before mounting the unit to the applicator.

1. Place the compression spring in the pocket of each funnel half and squeeze the halves together. See Figure 1.
2. While holding the halves together, put the headed pins through the pivot holes and into the funnel slide. Make sure the flats on the pins face outward.
3. Using a 1.5mm hex wrench, tighten each setscrew holding the pins in place. See Figure 2. The funnel halves should open freely under spring pressure.

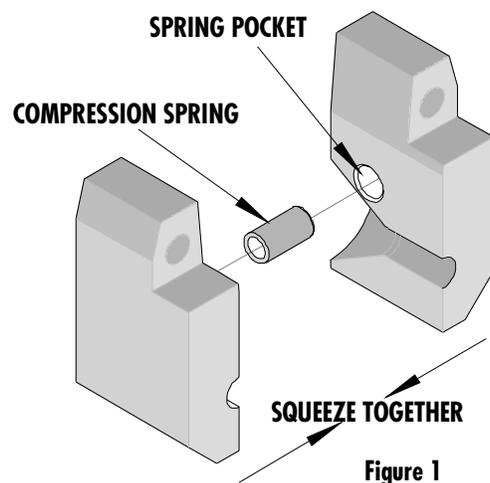
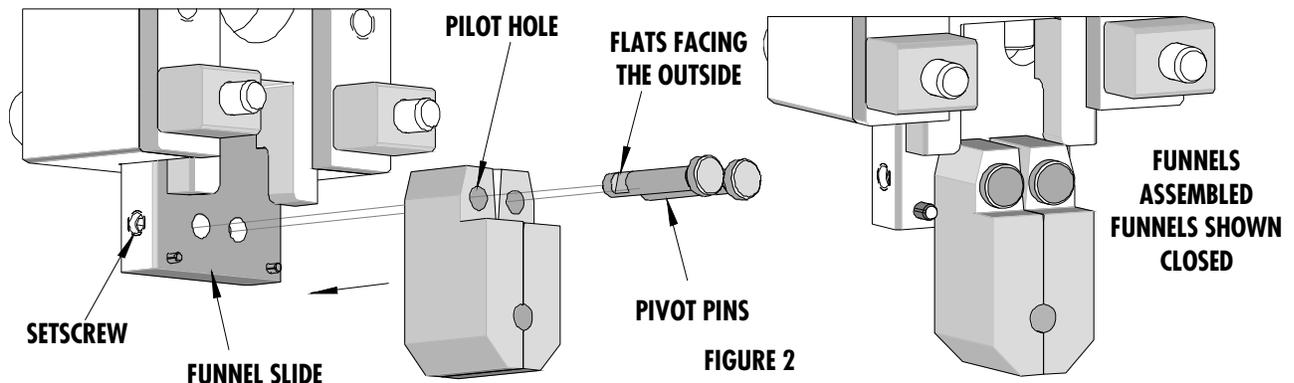


Figure 1

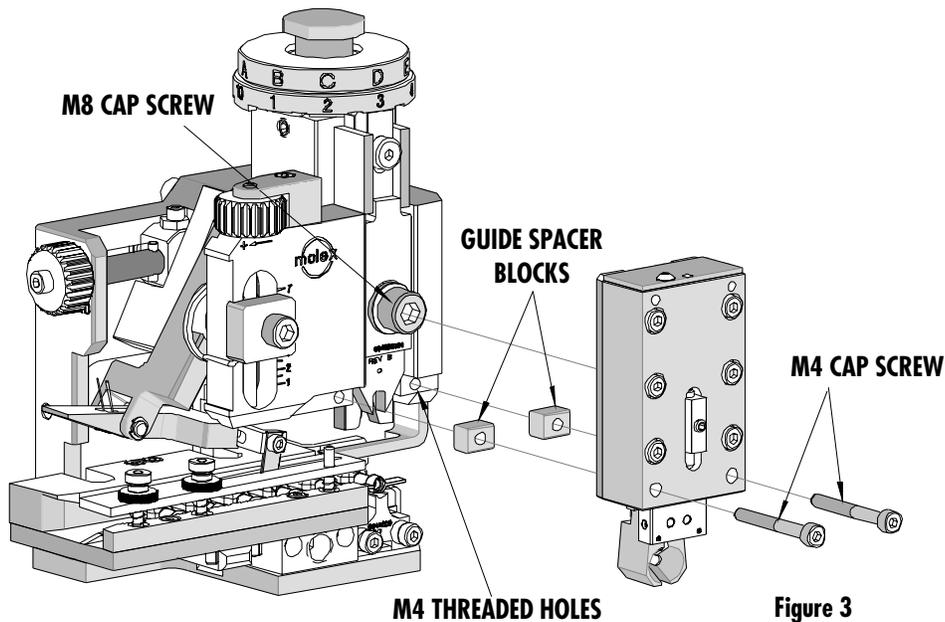


INSTALLATION ON APPLICATOR (See Figure 3)

1. To install the wire guide funnel, make sure the power is disconnected from the press.
2. The press ram should be fully up.
3. Replace the M8 button head cap screw that holds the punches in the ram with the M8 by 30mm long socket head cap screw furnished with the wire guide funnel. The head of the cap screw will be used to drive the wire guide funnel slide. Check revision marking on the front of the cut-off punch. It **MUST BE** marked revision B for the wire guide funnel assembly to work properly.
4. The wire guide funnel is mounted to the two M4-threaded holes on the lower face of the applicator frame. The roll pins at the top of the funnel slide block are intended to rest on the top of the applicator frame, providing additional stability for the slide.
5. Put (two) M4 by 35mm long socket head cap screws through the lower holes in the slide block, then place the guide spacer block over each screw.

Note: A thin film of grease applied to the guide spacer block will keep it from falling off the screw as the wire guide funnel is mounted to the applicator.

6. Align the counterbored hole in the slide with the head of the M8 cap screw and place the wire guide funnel against the applicator frame.



7. Using a 3mm hex wrench, tighten the two M4 screws to secure the wire guide funnel to the applicator. (Note: a small gap will exist between the funnel guide and the applicator frame)
8. With power disconnected, hand cycle the press to verify that the applicator ram and funnel plate slide move freely without binding.
9. Restore power to the press.

WIRE GUIDE FUNNEL ADJUSTMENTS

The wire guide funnel can be adjusted left-to-right and up or down for alignment with the terminal.

Since the wire guide funnel slide is centrally mounted to the applicator ram, left-to-right adjustment should not be necessary. If it is required, some movement is available by loosening the two M4 socket head cap screws (holding the funnel slide to the applicator frame) and moving the slide left or right.

Left-to-right positioning can also be accomplished by adjusting the applicator's terminal feed to relocate the terminal. On continuous-molded strip applicators, however, excessive feed position adjustment will affect terminal cutoff quality.

Up or down adjustment:

1. With a terminal in position over the crimp anvils, cycle the press to its split-point.

Note: If the press has an adjustable split-point, adjust it as low as possible (without starting to crimp the terminal). This will hold the terminal more securely against the anvils.

2. Using a 2.0mm hex wrench, loosen the adjustment lock screw on the front of the funnel slide.
3. The height adjustment screw is accessed through the hole on the top of the funnel slide. Using a 2.0mm hex wrench, turn the adjustment screw clockwise to raise the funnel or counterclockwise to lower the funnel. Proper adjustment should result in the insulation guide hole being concentric with the terminal barrel. See Figure 4.
4. Tighten the adjustment lock screw. Over-tightening the lock screw will damage the threads of the height adjustment screw.

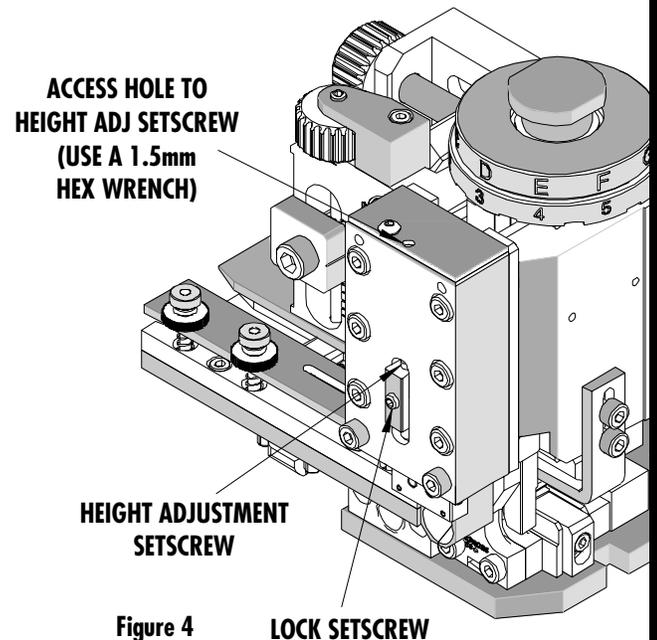


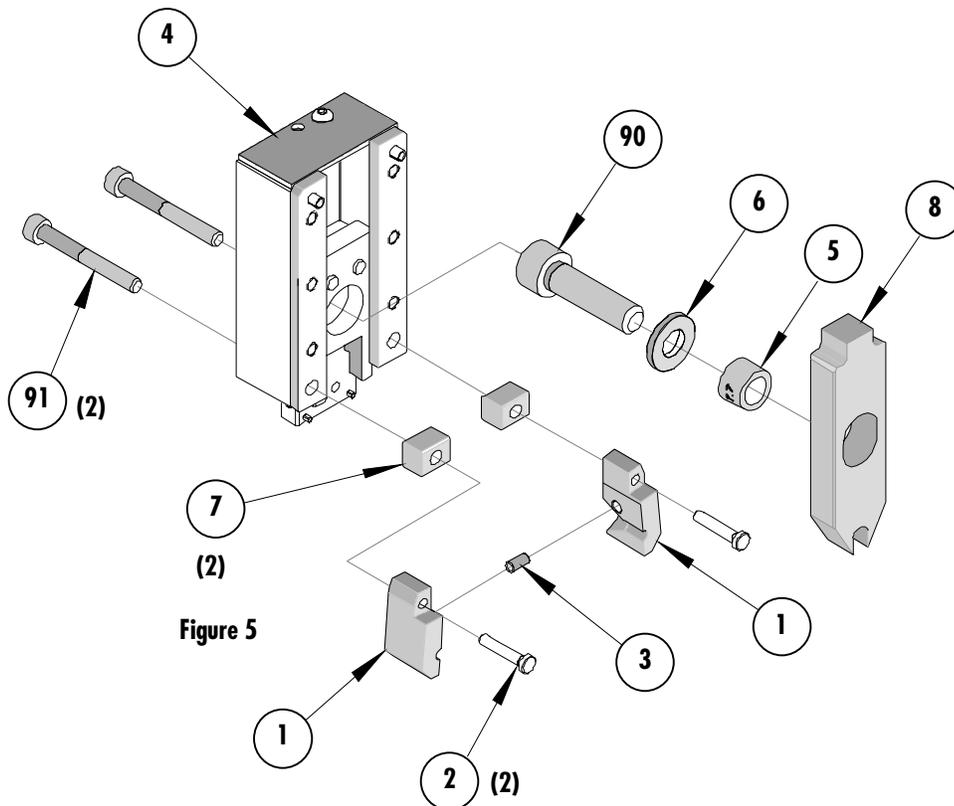
Figure 4 LOCK SETSCREW

PARTS LIST

Wire Guide Funnel 63883-7060				
Item	Order No	Engineering No.	Description	Quantity
Funnel Tooling				
	63883-7080	63883-7080	Tool Kit (All "Y" Items)	REF
1	63466-0801	63466-0801	Wire Funnels 3.20 Dia. wire (set)	1 Y
2	63600-1607	63600-1607	Funnel Pivot Pin	2 Y
3	11-40-5129	63303-T108	Compression Spring	1 Y
Funnel Slide				
4	63801-6300	63801-6300	Funnel Slide Assembly	1
5	63890-0867	63890-0867	Bushing	1 (REF)
6	63600-1290	63600-1290	Washer	1 (REF)
7	63801-6307	63801-6307	Guide Spacer	2 (REF)
Cut-Off Tooling				
8	63469-0001	63469-0001	Cut-Off Punch	1
Hardware				
90	N/A	N/A	M8 by 30 Long SHCS	1**
91	N/A	N/A	M4 by 35 Long SHCS	2**

** Available from an industrial supply company such as MSC (1-800-645-7270).

ASSEMBLY DRAWING



Note: The bushing (item 5) is included with the Funnel Slide Assembly; however, it is not necessary for installation on the molded strip applicators.

NOTES

1. An extra wire funnel set (Item 1) should be kept at your facility.
2. Verify tooling alignment by manually cycling the press with applicator before crimping under power. Check that all screws are tight.
3. Slugs, loose terminals, dirt, and oil should be kept clear of work area.
4. Wear safety glasses whenever operating or maintaining this equipment.
5. For recommended applicator maintenance refer to the Mini-Mac Applicator Manual (Document no. 63880-0000).

CAUTION: This applicator accessory 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 any applicator without the guards supplied with the press or wire-processing machine in place. Refer to 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

For more information on Molex application tooling please contact Molex at 1-800-786-6539.

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