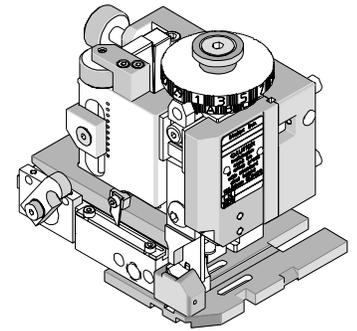




Mini-Mac Applicator Specification Sheet Order No. 63892-1000



FEATURES

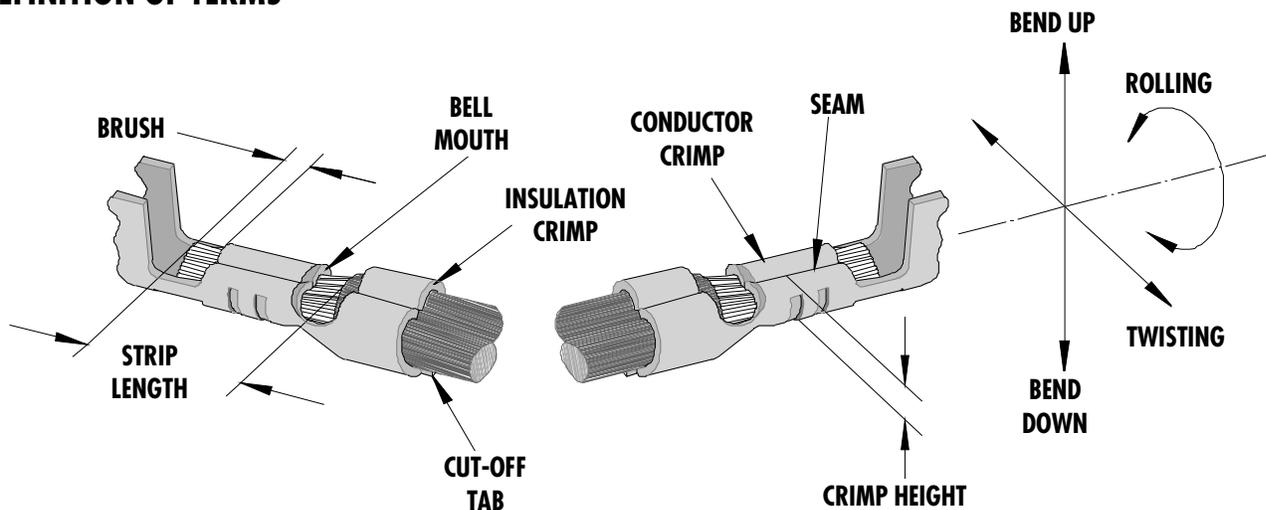
- Directly adapts to most automatic wire processing machines
- Applicator designed to industry standard mounting and shut height 135.80mm (5.346")
- Quick set-up time; plus the crimp height, track and feed adjustments can be set without removing the applicator from the press
- Fine adjustment allows 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: Clascon™ Female Crimp Terminal, 18-24 AWG.

Terminal Series No.	Terminal Order No.		Wire Size		Insulation Diameter		Strip Length	
			AWG	mm ²	mm	In.	mm	In.
2107	02-05-1104	02-05-1207	18-24	0.80-0.20	2.79 Max.	.110 Max.	3.18-3.96	.125-.156
	02-05-1106	02-05-5221						
	02-05-1204	02-05-5330						

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.	Bell mouth		Cut-off Tab Max.		Conductor Brush	
	mm	In.	mm	In.	mm	In.
2107						

Terminal Series No.	Wire Size		Bend up	Bend down	Twist	Roll	Punch Width (Ref)			
	AWG	mm ²	Degree		Degree		Conductor		Insulation	
			mm	In.	mm	In.	mm	In.		
2107	18-24	0.80-0.20					1.95	.077	2.83	.111
Seam										
Seam shall not be open and no wire allowed out of the crimping area.										
<p> 18 AWG UL Style 1015 may have pinched strands or an open seam. This condition is normal and does not effect crimp performance. The customer should determine suitability for the end application.</p>										

After crimping, the conductor profile should measure the following.

Terminal Series No.	Wire Size		Conductor				Pull Force Minimum	
			Crimp Height		Crimp Width			
	AWG	mm ²	mm	In.	mm	In.	N	Lb.
2107	18	0.80	1.02-1.07	.040-.042	1.95-2.06	.077-.081	89.0	20.00
	20	0.50	0.91-0.97	.036-.038	1.95-2.06	.077-.081	66.7	15.00
	22	0.35	0.84-0.89	.033-.035	1.95-2.06	.077-.081	44.5	10.00
	24	0.20	0.81-0.86	.032-.034	1.95-2.06	.077-.081	35.6	8.00

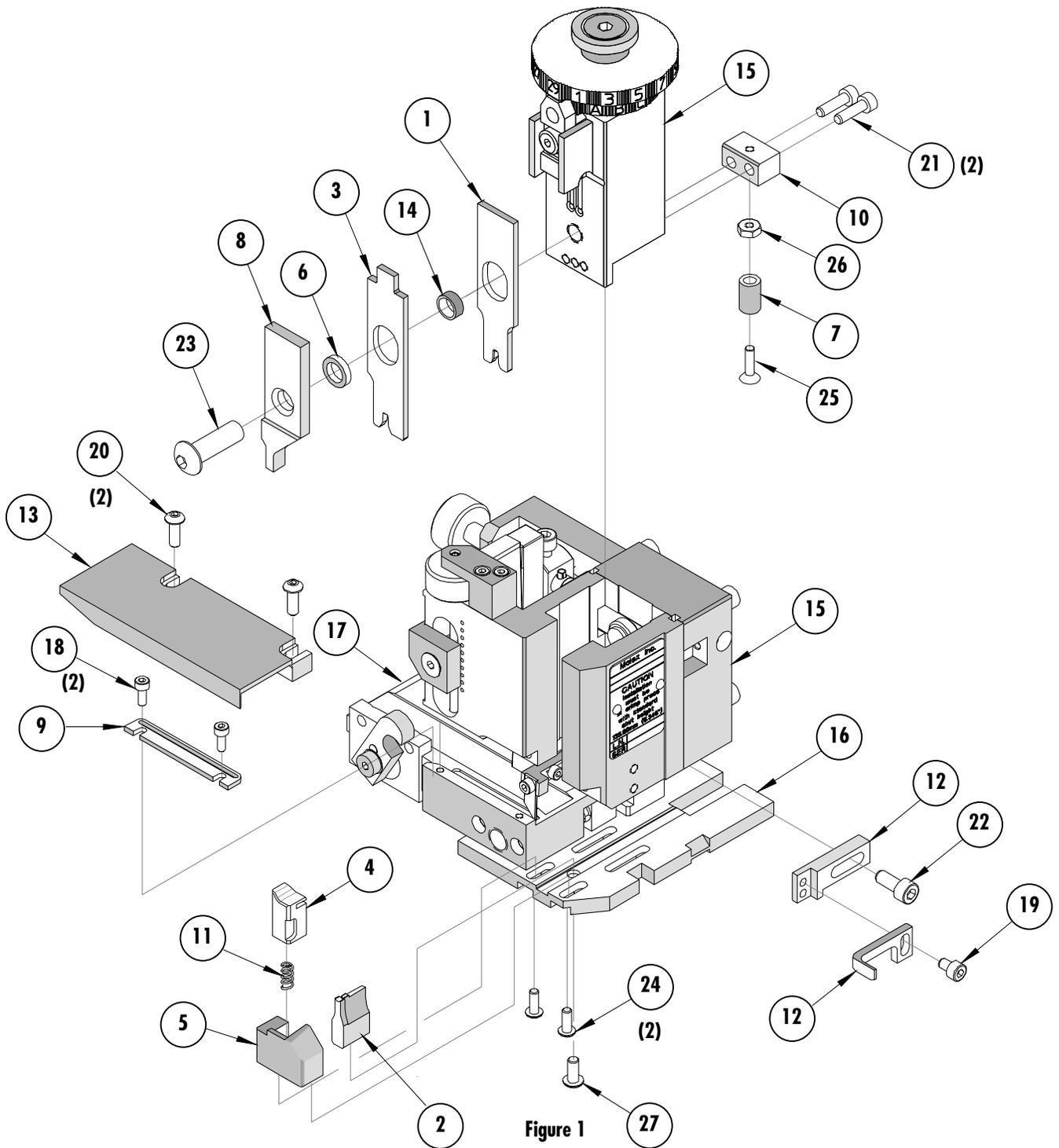
Pull Force should be measured with no influence from the insulation crimp.

The above specifications are guidelines to an optimum crimp.

PARTS LIST

Mini-Mac Applicator 63892-1000				
Item	Order No	Engineering No.	Description	Quantity
Perishable Tooling				
	63892-1070	63892-1070	Tool Kit (All "Y" Items)	REF
1	11-18-4076	60707-1	Conductor Punch	1 Y
2	11-18-4123	60707-13	Combination Anvil	1 Y
3	11-18-4077	60707-2	Insulation Punch	1 Y
4	11-17-3076	7163-30	Front Cut-Off Plunger	1 Y
5	11-18-4246	60707-18	Cut-off Plunger Retainer	1 Y
Other Components				
6	11-17-2140	7163-8	Insulation Punch Spacer	1
7	11-17-2152	7163-14	Hold Down Pad	1
8	11-18-4081	60707-6	Front Plunger Striker	1
9	11-18-4083	60707-8	Feed Guide	1
10	11-18-4124	60707-12	Adapter (Hold Down Pad)	1
11	11-24-1067	4996-4	Cut-off Plunger Spring	1
12	63443-0090	63443-0090	Wire Stop	1
13	63443-6115	63443-6115	Rear Cover	1
14	63803-5124	63803-5124	Conductor Bushing	1
Frame				
15	63801-3201	63801-3201	Top	1
16	63801-3282	63801-3282	Base	1
17	63801-6550	63801-6550	Track	1
Hardware				
18	N/A	N/A	M3 by 8 Long SHCS	2**
19	N/A	N/A	M4 by 6 Long BHCS	1**
20	N/A	N/A	M4 by 12 Long BHCS	2**
21	N/A	N/A	M4 by 16 Long SHCS	2**
22	N/A	N/A	M5 by 12 Long SHCS	1**
23	N/A	N/A	M8 by 20 Long BHCS	1**
24	N/A	N/A	#6-32 by 3/8" Long BHCS	2**
25	N/A	N/A	#6-32 by 1/2" Long FHCS	1**
26	N/A	N/A	#6-32 Hex Jam Nut	1**
27	N/A	N/A	#8-32 by 3/8" Long BHCS	1**
** 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

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

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