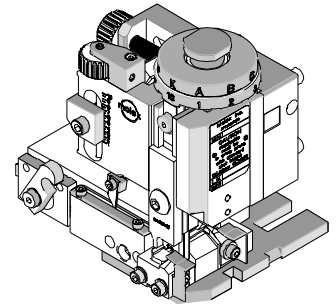




# Mini-Mac Applicator Application Tooling Specification Sheet Mechanical Feed-Metal Strip Order No. 63832-5200



## FEATURES

- Directly adapts to most crimp press and automatic wire processing machines
- Applicator designed to industry standard mounting and shut height of 135.80mm (5.346")
- Conductor and insulation rings allow quick adjustment for conductor and insulation crimp height change
- Quick set-up time; plus the crimp height, track and feed adjustments can be set without removing the applicator from the crimp press

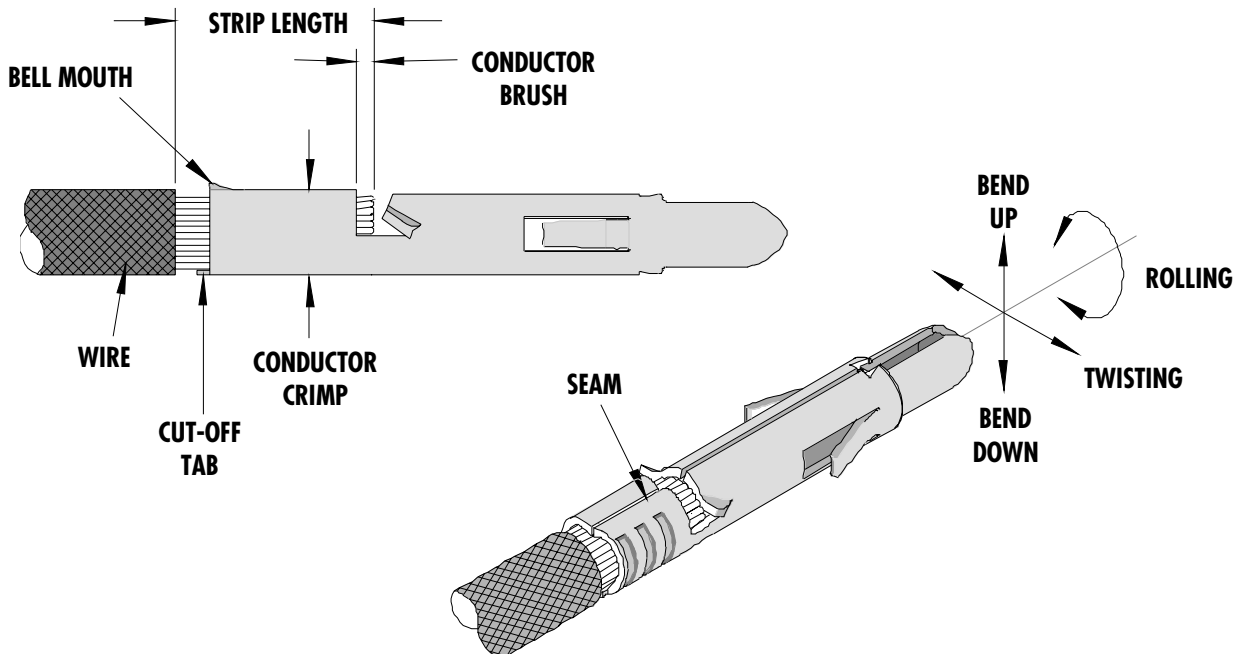
## SCOPE

Products: MLX Double Crimp Terminals, 10-12 AWG.

The following is a partial list of the product part numbers and their specifications that this tool is designed to run. We will be adding to this list and an up to date copy is available on [www.molex.com](http://www.molex.com).

Terminal Series No.	Terminal Order No.	Wire Size		Insulation Diameter		Strip Length	
		AWG	mm <sup>2</sup>	mm	In.	mm	In.
36663	36663-0001	10-12	5.00-3.30	5.08	.200	6.40-7.14	.252-.281
36664	36664-0001	10-12	5.00-3.30	5.08	.200	6.40-7.14	.252-.281

## DEFINITION OF TERMS



**CRIMP SPECIFICATIONS**

Terminal Series No.	Bell mouth		Cut-off Tab Max.		Conductor Brush	
	mm	In.	mm	In.	mm	In.
36663	0.30-0.60	.012-.024	0.50	.020	0.30-0.80	.012-.031
36664	0.30-0.60	.012-.024	0.50	.020	0.30-0.80	.012-.031

Terminal Series No.	Bend up	Bend down	Twist	Roll	Punch Width (Ref)				Seam Seam to be closed, and no wire allowed out of the crimping area.
					Conductor		Insulation		
	Degree		Degree		mm	In	mm	In	
36663	3	3	3	5	3.45	.136	N/A	N/A	
36664	3	3	3	5	3.45	.136	N/A	N/A	

**CONDITIONS:**

After crimping, the conductor profiles should measure the following (See notes on page 5).

Terminal Series No.	Wire Size		Crimp Height				Crimp Width				Pull Force Min.	
			Conductor		Insulation		Conductor		Insulation			
	AWG	mm <sup>2</sup>	mm	In.	mm	In.	mm	In.	mm	In.	N	Lb.
36663	10	5.0	2.35-2.45	.093-.095	N/A	N/A	3.50-3.60	.138-.142	N/A	N/A	355.9	80.0
36663	12	3.3	1.90-2.00	.075-.078	N/A	N/A	3.50-3.60	.138-.142	N/A	N/A	311.4	70.0
36664	10	5.0	2.35-2.45	.093-.095	N/A	N/A	3.50-3.60	.138-.142	N/A	N/A	355.9	80.0
36664	12	3.3	1.90-2.00	.075-.078	N/A	N/A	3.50-3.60	.138-.142	N/A	N/A	311.4	70.0

Pull Force should be measured with no influence from the insulation crimp. The above specifications are guidelines to an optimum crimp.

**PARTS LIST**

<b>Mini-Mac Applicator 63832-5200</b>				
<b>Item</b>	<b>Order No</b>	<b>Engineering No.</b>	<b>Description</b>	<b>Quantity</b>
<b>Perishable Tooling</b>				
	63832-5270	63832-5270	Tool Kit (All "Y" Items)	REF
1	63801-5973	63801-5973	Conductor Punch	1 Y
2	63801-5972	63801-5972	Conductor Anvil	1 Y
11	63443-0037	63443-0037	Front Cut-Off Plunger	1 Y
13	63443-0038	63443-0038	Front Cut-off Plunger Retainer	1 Y
<b>Other Components (Ref. 25250)</b>				
21	63466-0502	63466-0502	Front Plunger Striker	1
23	63443-0009	63443-0009	Front Scrape Chute	1
25	63700-0539	63700-0539	Cut-Off Plunger Spring	1
31	63443-2503	63443-2503	Spacer (Anvil Mount)	1
33	63443-0021	63443-0021	Lower Tooling Key	1
45	63443-0061	63443-0061	Wire Stop	1
51	63600-1290	63600-1290	Washer	1
52	63890-0866	63890-0866	Collar-6.4 Lg.	1
72	11-18-4083	60707-8	Front Cover	1
73	63443-6130	63443-6130	Rear Cover	1
<b>Frame</b>				
81	63801-3201	63801-3201	Mechanical Feed Applicator Frame Head	1
82	63801-3281	63801-3281	Base	1
83	63801-4650	63801-4650	Track Assembly	1
<b>Hardware</b>				
91	N/A	N/A	M3 by 6 Lg. SHCS	2**
92	N/A	N/A	M4 by 6 Lg SHCS	1**
93	N/A	N/A	M4 by 14 Lg SHCS	2**
94	N/A	N/A	M4 by 50 Lg. SHCS	2**
95	N/A	N/A	M5 by 12 Lg. SHCS	1**
96	N/A	N/A	M8 by 30 Lg. BHCS	1**
97	N/A	N/A	3mm by 6 Lg. Roll Pin	1**
** Available from an industrial supply company such as MSC (1-800-645-7270).				

# Assembly Drawing

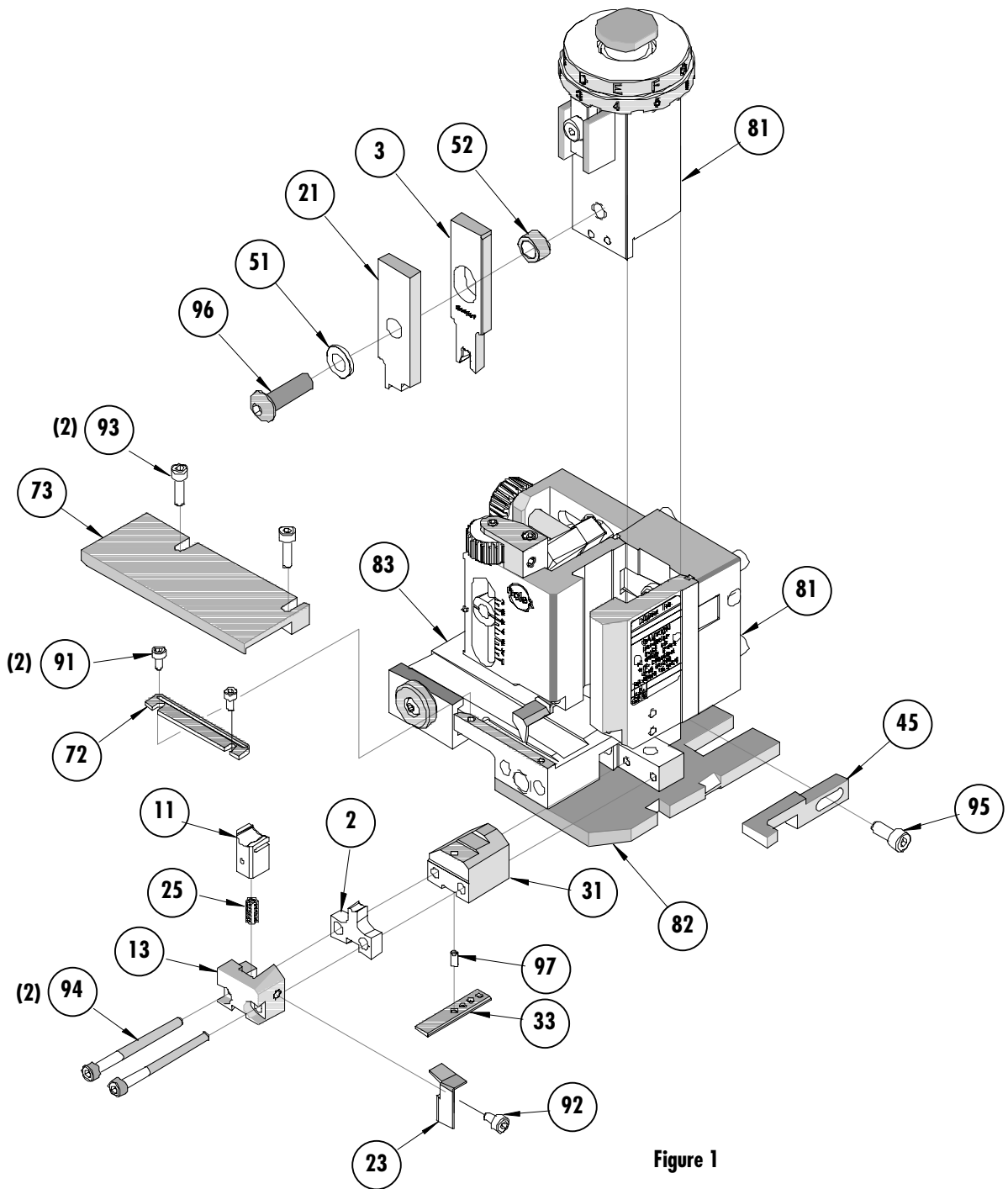


Figure 1

## NOTES

1. Molex recommends an extra perishable tooling kit be maintained at your facility.
2. Verify tooling alignment by manually cycling the press with 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 Industrial Mini-Mac Applicator 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.

## Contact Information

For more information on Molex Application Tooling please contact a Molex sales representative at 1-800-786-6539.

### **Molex Application Tooling Group**

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