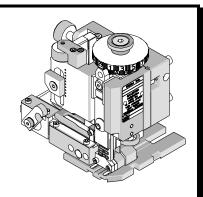


Mini-Mac Applicator **Specification Sheet** Order No. 63892-8100



FEATURES

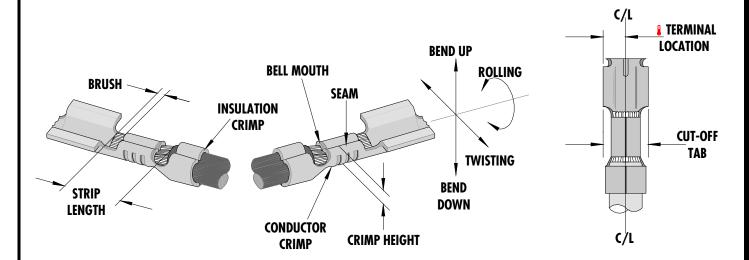
- Directly adapts to most automatic wire processing machines
- Applicator designed to industry standard mounting and shut height 135.80mm (5.346")
- Quick set-up time; plus the crimp height, track and feed adjustments can be set without removing the applicator from the press
- Fine adjustment allows 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: 3.18mm (.125") Diameter HCS-125, Pin and Socket Male and Female Crimp Terminal, 10-14 AWG.

Terminal Series No.	Terminal Order No.	Wire Size	Insulat	ion Diameter	Strip Length		
		AWG	mm²	mm	ln.	mm	ln.
1900	18-12-2601	10-14 and (1) 12+ (1) 18	5.0-2.0	4.57	.180 Max.	4.06-5.59	.160220
1901	18-12-1601	10-14 and (1) 12+ (1) 18	5.0-2.0	4.57	.180 Max.	4.06-5.59	.160220

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.

Doc No. ATS-638928100 Release Date: 02-13-07 **UNCONTROLLED COPY** Page 1 of 5 Revision Date: 02-13-07

CRIMP SPECIFICATIONS

	Terminal Series No.	Bell mouth		₽ Cut-	off Tab	Conductor Brush		
Terminal Series	reminium series No.	mm	ln.	mm	ln.	mm	In.	
	1900			5.00-5.16	.197203			
	1901			5.00-5.16	.197203			

	Bend up Bend down		Twist Roll	Roll	Punch Width (Ref)				Seam	
Terminal Series No.	Della op	Della aowii	IWISI	KUII	Cond	uctor	Insul	ation		
	De	egree	Deg	ree	mm	ln.	mm	ln.	Seam shall not be open	
1900					3.85	.152	5.00	.197	and no wire allowed out	
1901					3.85	.152	5.00	.197	of the crimping area	

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.

	Wire Size			Pull Force					
Terminal Series No.	vviie Size	Crimp	Height	Crimp wid	Minimum				
	AWG	mm²	mm	ln.	mm	ln.	N	Lb.	
	10	5.00	2.03-2.16	080085			356.0	80.0	
1900	12	3.30	1.96-2.08	.077082			311.4	70.0	
1700	14	2.00	1.80-1.91	.071075			266.9	60.0	
	(1) 12 + (1) 18	3.30+0.80	2.03-2.16	.080085			89.0	20.0	
	10	5.00	2.03-2.16	080085			356.0	80.0	
1901	12	3.30	1.96-2.08	.077082			311.4	70.0	
1701	14	2.00	1.80-1.91	.071075			266.9	60.0	
	(1) 12 + (1) 18	3.30+0.80	2.03-2.16	.080085			89.0	20.0	
For Double Application: Position smaller wire size on the bottom and larger wire size on top.									

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

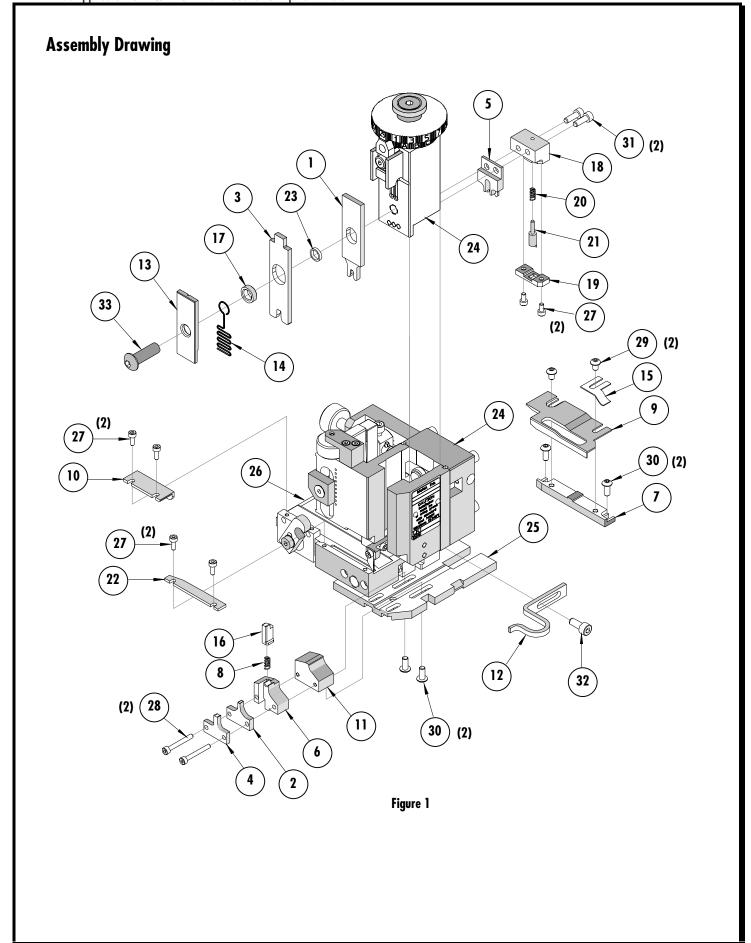
The above specifications are guidelines to an optimum crimp.

Doc No. ATS-638928100 Release Date: 02-13-07 Revision: A Revision Date: 02-13-07

PARTS LIST

Mini-Mac Applicator 63892-8100									
Item	Order No	Order No Engineering No. Description							
Perishable Tooling									
	63892-8170	63892-8170	Tool Kit (All "Y" Items)	REF					
1	11-18-4986	60805B106	Conductor Punch	1 Y					
2	11-18-4987	60805B107	Conductor Anvil	1 Y					
3	11-18-4988	60805B108	Insulation Punch	1 Y					
4	11-18-4989	60805B109	Insulation Anvil	1 Y					
5	11-18-4977	60805A104	Cut-Off Punch	1 Y					
6	11-18-4983	60805A111	Rear Cut-off Die Blade	1 Y					
		Other Co	omponents						
7	11-18-4810	60800A106	Rear Block	1					
8	11-18-4811	60800A107	Compression Spring	1					
9	11-18-4815	60800A111	Guide Plate	1					
10	11-18-4816	60800A112	Terminal Drag Plate	1					
11	11-18-4818	60800A114	Mounting Block	1					
12	11-18-4829	60800A125	Wire Stop	1					
13	11-18-4848	60800A123	Spring Retainer	1					
14	11-18-4849	60800A124	Wire Hold Down Spring	1					
15	11-18-4894	60800A129	Knockout Spring	1					
16	11-18-4984	60805A112	Plunger	1					
17	11-18-4985	60805A115	Tooling Washer	1					
18	11-18-5005	60800D112	Hold Down Block	1					
19	11-18-5006	60800D113	Spring Retainer	1					
20	11-18-5007	60800D114	Compression Spring (Hold Down)	1					
21	11-18-5014	60805A121	Hold Down Plunger	1					
22	11-18-5015	60805A122	Front Cover	1					
23	63803-5111	63803-5111	Conductor Bushing	1					
			ame						
24	63801-3201	63801-3201	Тор	1					
25	63801-3282	63801-3282	Base	1					
26	63801-6550	63801-6550	Track	1					
		Har	dware						
27	N/A	N/A	M3 by 6 Long SHCS	6**					
28	N/A	N/A	M3 by 25 Long SHCS	2**					
29	N/A	N/A	M4 by 6 Long BHCS	2**					
30	N/A	N/A	M4 by 10 Long BHCS	4**					
31	N/A	N/A	M4 by 18 Long SHCS						
32	N/A	N/A	M5 by 10 Long SHCS 1*						
33	N/A	N/A	M8 by 20 Long BHCS]**					
	** Available fron	n an industrial supply o	ompany such as MSC (1-800-645-72	70).					

UNCONTROLLED COPY Page 3 of 5 Doc No. ATS-638928100 Release Date: 02-13-07 Revision: A



Doc No. ATS-638928100 Revision: A Release Date: 02-13-07 Revision Date: 02-13-07

NOTES

- Molex recommends an extra perishable tooling kit be maintained at your facility.
- Verify tooling alignment by manually cycling the press and applicator before crimping under power. Check that all screws are tight.
- 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 135.80mm (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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Doc No. ATS-638928100 Release Date: 02-13-07 **UNCONTROLLED COPY** Page 5 of 5 Revision Date: 02-13-07

Revision: A