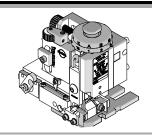
# Mini-Mac Mechanical Feed-Metal Strip Applicator



# **Application Tooling Specification Sheet**



Order No. 63832-5200

### **FEATURES**

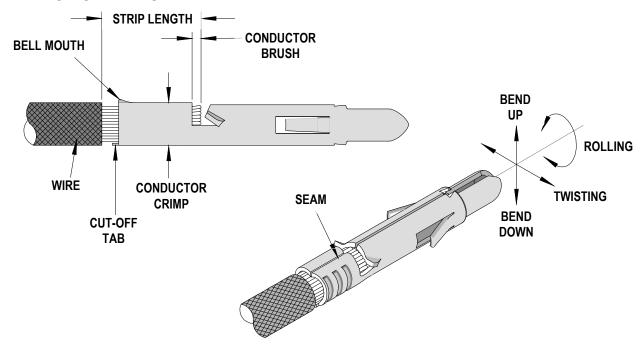
- Directly adapts to most crimp press and automatic wire processing machines
- Applicator designed to industry-standard mounting and shut height of 135.80mm (5.346")
- Conductor and insulation rings allow quick adjustment for conductor and insulation crimp height change
- Quick setup time; plus, the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

#### **SCOPE**

Products: MLX Crimp Terminals, 10-12 AWG.

Terminal Series No.	Terminal Order No.	Wi	re Size	Insulation	Diameter	Strip Length		
Terminal Series No.		AWG	mm²	mm	ln.	mm	ln.	
36663	36663-0001	10-12	5.00-3.30	5.08	.200	6.40-7.14	.252281	
36664	36664-0001	10-12	5.00-3.30	5.08	.200	6.40-7.14	.252281	

#### **DEFINITION OF TERMS**



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## **CRIMP SPECIFICATIONS**

Terminal Series No.	Bell N	/louth	Cut-Off	Гаb Мах.	Conductor Brush		
Terminal Series No.	mm	mm In.		ln.	mm	ln.	
36663	0.30-0.60	.012024	0.50	.020	0.30-0.80	.012031	
36664	0.30-0.60	.012024	0.50	.020	0.30-0.80	.012031	

	Bend Up	Bend Down	Twist	Roll	Punch Width (Ref)					
Terminal Series No.	Della Up	Bella Dowli	IWISL		Cond	Conductor		ation	Seam	
	De	Degree		mm	ln.	mm	ln.			
36663	3	3	3	5	3.45	.136	N/A	N/A	Seam to be closed, and no wire allowed out of	
36664	3	3	3	5	3.45	.136	N/A	N/A	the crimping area.	

## **CONDITIONS**

After crimping, the conductor profiles should measure the following (see notes on page 5):

	Wiro	Sizo	Crimp Height				Crimp Width				Pull Force	
Terminal Series No.	Wire Size		Conductor		Insulation		Conductor		Insulation		Minimum	
	AWG	mm <sup>2</sup>	mm	ln.	mm	ln.	mm	ln.	mm	ln.	N	Lb.
36663	10	5.0	2.35-2.45	.093095	N/A	N/A	3.50-3.60	.138142	N/A	N/A	355.9	80.0
30003	12	3.3	1.90-2.00	.075078	N/A	N/A	3.50-3.60	.138142	N/A	N/A	311.4	70.0
36664	10	5.0	2.35-2.45	.093095	N/A	N/A	3.50-3.60	.138142	N/A	N/A	355.9	80.0
	12	3.3	1.90-2.00	.075078	N/A	N/A	3.50-3.60	.138142	N/A	N/A	311.4	70.0

#### **Tool Qualification Notes**

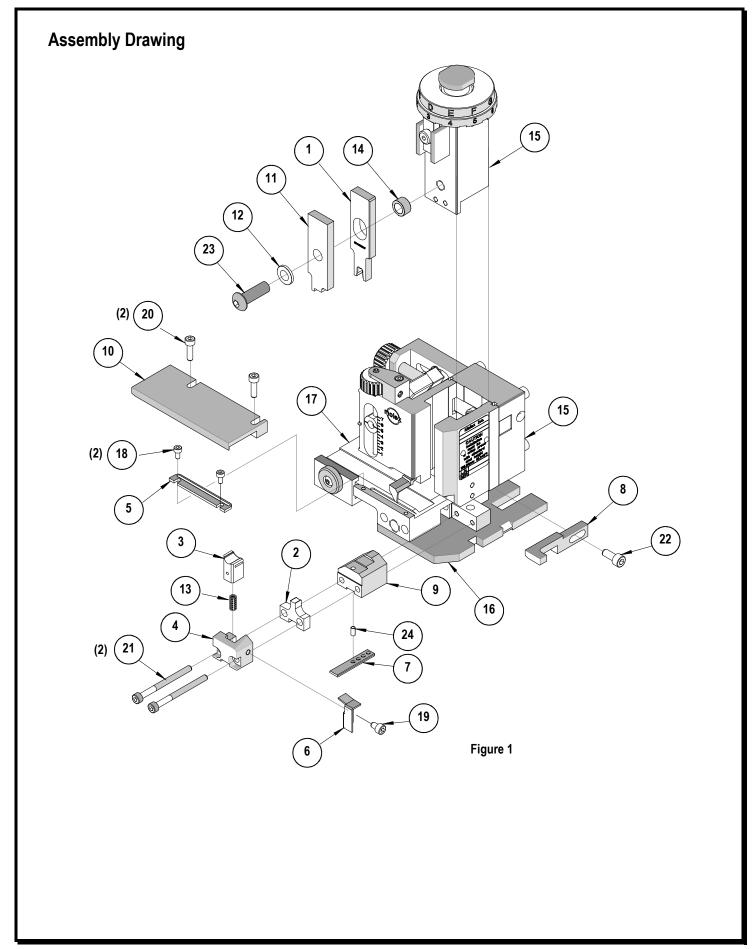
- 1. Pull force should be measured with no influence from the insulation crimp.
- 2. The above specifications are guidelines to an optimum crimp.

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# **PARTS LIST**

	Mini-Mac Applicator 63832-5200								
Item	Order No. Engineering No. Description								
	Perishable Tooling								
	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					
3	63443-0037	63443-0037	Front Cut-Off Plunger	1 Y					
4	63443-0038	63443-0038	Front Cut-off Plunger Retainer	1 Y					
			her Components						
5	11-18-4083	60707-8	Front Cover	1					
6	63443-0009	63443-0009	Front Scrap Chute	1					
7	63443-0021	63443-0021	Lower Tooling Key	1					
8	63443-0061	63443-0061	Wire Stop	1					
9	63443-2503	63443-2503	Spacer (Anvil Mount)	1					
10	63443-6130	63443-6130	Rear Cover	1					
11	63466-0502	63466-0502	Front Plunger Striker	1					
12	63600-1290	63600-1290	Washer	1					
13	63700-0539	63700-0539	Cut-Off Plunger Spring	1					
14	63890-0866	63890-0866	Collar-6.4 Long	1					
			Frame						
15	63801-3201	63801-3201	Mechanical Feed Applicator Frame Head	1					
16	63801-3281	63801-3281	Base	1					
17	63801-4650	63801-4650	Track Assembly	1					
			Hardware						
18	N/A	N/A	M3 by 6 Long SHCS	2**					
19	N/A	N/A	M4 by 6 Long SHCS	1**					
20	N/A	N/A	M4 by 14 Long SHCS	2**					
21	N/A	N/A	M4 by 50 Long SHCS	2**					
22	N/A	N/A	M5 by 12 Long SHCS	1**					
23	N/A	N/A	M8 by 30 Long BHCS	1**					
24	N/A	N/A	3mm by 6 Long Roll Pin	1**					
	** Available from an industrial supply company such as MSC (1-800-645-7270).								

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#### **NOTES**

- 1. Molex recommends that an extra perishable tooling kit be maintained at your facility.
- 2. Verify tooling alignment by manually cycling the press with the applicator before crimping under power. Check that all screws are tight.
- 3. Slugs, terminals, dirt and oil should be kept clear of the 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 wireprocessing 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.

# **Application Tooling Support**

Phone: (402) 458-TOOL (8665) E-Mail: applicationtooling@molex.com Website: www.molex.com/applicationtooling

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