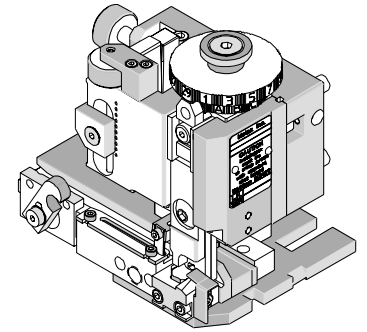




Mini-Mac Applicator Specification Sheet Order No. 63892-6100



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.

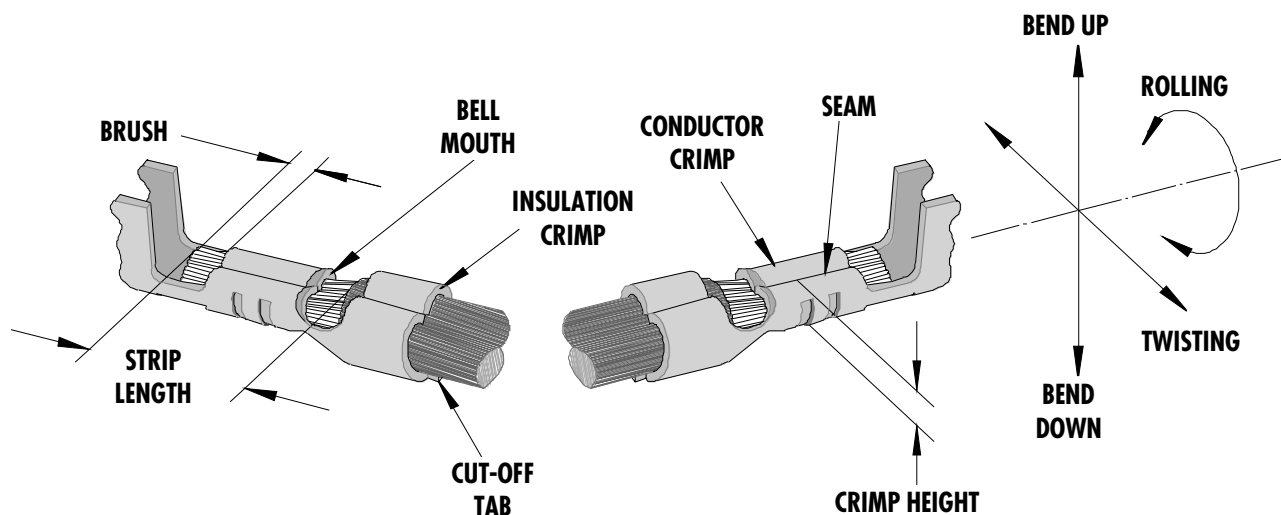
SCOPE

Products: High Normal Force (HNF) Female Terminals. High Normal Force (HNF) Female Terminal, For 6.3 x 0.8mm (.248 x .031") Tabs, 12-16.

| Terminal Series No. | Terminal Order No. | Wire Size | | Insulation Diameter | | Strip Length | |
|---------------------|--------------------------|-----------|-----------------|---------------------|-----------|--------------|-----------|
| | | AWG | mm ² | mm | In. | mm | In. |
| 94518 | 94518-0400 94518-0401 | 16(2) | 1.50 (2) | 3.14 Max. | .123 Max. | 5.00-5.50 | .197-.216 |
| | | 18 + 16 | 0.75 + 1.50 | 3.14 Max. | .123 Max. | 5.00-5.50 | .197-.216 |
| | | 18 (2) | 0.75 (2) | 3.14 Max. | .123 Max. | 5.00-5.50 | .197-.216 |
| | | 20+16 | 0.50+1.50 | 3.14 Max. | .123 Max. | 5.00-5.50 | .197-.216 |
| | | 20+18 | 0.50+0.75 | 3.14 Max. | .123 Max. | 5.00-5.50 | .197-.216 |
| | | 20 (2) | 0.50 (2) | 3.14 Max. | .123 Max. | 5.00-5.50 | .197-.216 |

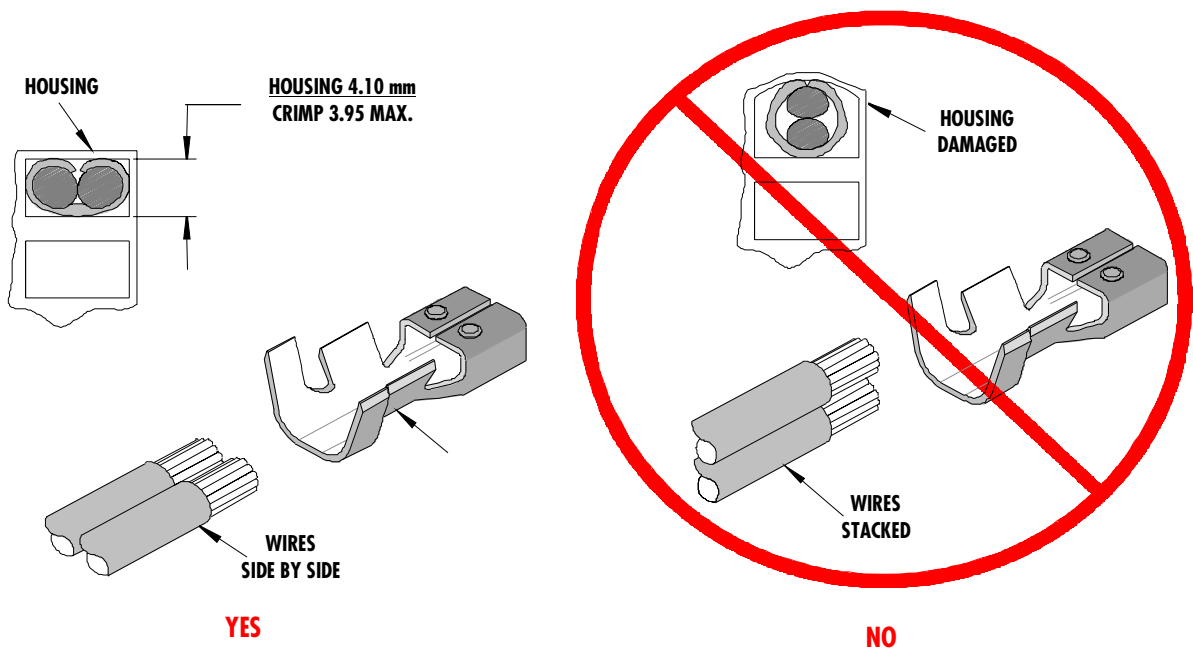
DEFINITION OF TERMS

The following illustration is a generic terminal representation and not an exact image of any terminal listed in the scope.



Wire Feeding Orientation

This Terminal and Connector Housing requires that the wires be crimped **side by side** to function properly, otherwise the housing and the latch may be damaged. It also may cause high insertion force to the header. See the following illustrations below.



CRIMP SPECIFICATION

| Terminal Series No. | Bell mouth | | Cut-off Tab Max. | | Conductor Brush | |
|---------------------|------------|-----------|------------------|------|-----------------|-----------|
| | mm | In. | mm | In. | mm | In. |
| 94518 | 0.20-0.40 | .008-.016 | 0.60 | .024 | 0.50-1.50 | .020-.059 |

| Terminal Series No. | Bend up Bend down | | Twist Roll | | Punch Width (Ref) | | | | Seam Seam shall not be open and no wire allowed out of the crimping area |
|---------------------|-------------------|---|------------|---|-------------------|------|------------|------|---|
| | Degree | | Degree | | Conductor | | Insulation | | |
| | | | | | mm | In | mm | In | |
| 94518 | 3 | 3 | 4 | 8 | 2.75 | .108 | 5.50 | .216 | |

After crimping, the crimp profiles should measure the following.

| Terminal Series No. | Wire Size | | Crimp Height | | | | Crimp Width (Ref.) | | | | Pull Force Minimum | |
|---------------------|-----------|-----------------|--------------|-----------|-------------------|-----------|--------------------|-----------|-------------------|-----------|--------------------|------|
| | | | Conductor | | Insulation (Ref.) | | Conductor (Ref.) | | Insulation (Ref.) | | | |
| | AWG | mm ² | mm | In. | mm | In. | mm | In. | mm | In. | N | Lb. |
| 94518 | 16+16 | 1.5+1.5 | 1.95-2.05 | .077-.081 | 3.70-3.80 | .146-.150 | 2.80-2.90 | .110-.114 | 5.50-5.70 | .216-.224 | 176.4 | 39.7 |
| | 18+16 | 0.75+1.5 | 1.95-2.05 | .077-.081 | 3.70-3.80 | .146-.150 | 2.80-2.90 | .110-.114 | 5.50-5.70 | .216-.224 | 176.4 | 39.7 |
| | 18+18 | 0.75+0.75 | 1.85-1.95 | .073-.077 | 3.45-3.55 | .136-.140 | 2.80-2.90 | .110-.114 | 5.50-5.70 | .216-.224 | 176.4 | 39.7 |
| | 20+16 | 0.5+1.5 | 1.85-1.95 | .073-.077 | 3.45-3.55 | .136-.140 | 2.80-2.90 | .110-.114 | 5.50-5.70 | .216-.224 | 78.2 | 17.6 |
| | 20+18 | 0.5+0.75 | 1.80-1.90 | .070-.075 | 3.40-3.50 | .134-.138 | 2.80-2.90 | .110-.114 | 5.50-5.70 | .216-.224 | 78.2 | 17.6 |
| | 20+20 | 0.5+0.5 | 1.75-1.85 | .068-.073 | 3.35-3.45 | .132-.136 | 2.80-2.90 | .110-.114 | 5.50-5.70 | .216-.224 | 78.2 | 17.6 |

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

Pull force listed is for the smaller AWG wire, one wire only.

The above specifications are guidelines to an optimum crimp.

PARTS LIST

| Mini-Mac Applicator 63892-6100 | | | | |
|--|-----------------|------------------------|-----------------------------------|-----------------|
| Item | Order No | Engineering No. | Description | Quantity |
| Perishable Tooling | | | | |
| | 63892-6170 | 63892-6170 | Tool Kit (All "Y" Items) | REF |
| 1 | 63470-0004 | 63470-0004 | Conductor Punch | 1 Y |
| 2 | 63832-0402 | 63832-0402 | Conductor Anvil | 1 Y |
| 3 | 63471-0006 | 63471-0006 | Insulation Punch | 1 Y |
| 4 | 63832-0408 | 63832-0408 | Insulation Anvil | 1 Y |
| 5 | 63832-0406 | 63832-0406 | Front Cut-off Plunger | 1 Y |
| 6 | 63443-0036 | 63443-0036 | Front Cut-off Plunger Retainer | 1 Y |
| Other Components | | | | |
| 7 | 11-18-4083 | 60707-8 | Feed Cover | 1 |
| 8 | 63443-0009 | 63443-0009 | Scrap Chute Front | 1 |
| 9 | 63443-0025 | 63443-0025 | Key Dual Carrier | 1 |
| 10 | 63443-0062 | 63443-0062 | Collar-8.0mm Long | 1 |
| 11 | 63443-0090 | 63443-0090 | Wire Stop | 1 |
| 12 | 63443-1700 | 63443-1700 | Z Spacer | 1 |
| 13 | 63443-2214 | 63443-2214 | 14.0mm Spacer | 1 |
| 14 | 63443-2310 | 63443-2310 | 3.5mm Spacer | 1 |
| 15 | 63443-6123 | 63443-6123 | Rear Cover | 1 |
| 16 | 63700-0539 | 63700-0539 | Cut-Off Plunger Spring | 1 |
| 17 | 63700-3597 | 63700-3597 | Compression Spring (Wire Locator) | 1 |
| 18 | 63830-0505 | 63830-0505 | Striker (Front Plunger) | 1 |
| 19 | 63832-0407 | 63832-0407 | Wire Locator | 1 |
| Frame | | | | |
| 20 | 63801-3201 | 63801-3201 | Top | 1 |
| 21 | 63801-3281 | 63801-3281 | Base | 1 |
| 22 | 63801-4650 | 63801-4650 | Track | 1 |
| Hardware | | | | |
| 23 | N/A | N/A | M3 by 6 Long FHCS | 1** |
| 24 | N/A | N/A | M3 by 6 Long SHCS | 2** |
| 25 | N/A | N/A | M4 by 6 Long SHCS | 2** |
| 26 | N/A | N/A | M4 by 12 Long BHCS | 2** |
| 27 | N/A | N/A | M4 by 50 Long SHCS | 2** |
| 28 | N/A | N/A | M5 by 12 Long SHCS | 1** |
| 29 | N/A | N/A | M8 by 30 Long BHCS | 1** |
| ** Available from an industrial supply company such as MSC (1-800-645-7270). | | | | |

Assembly Drawing

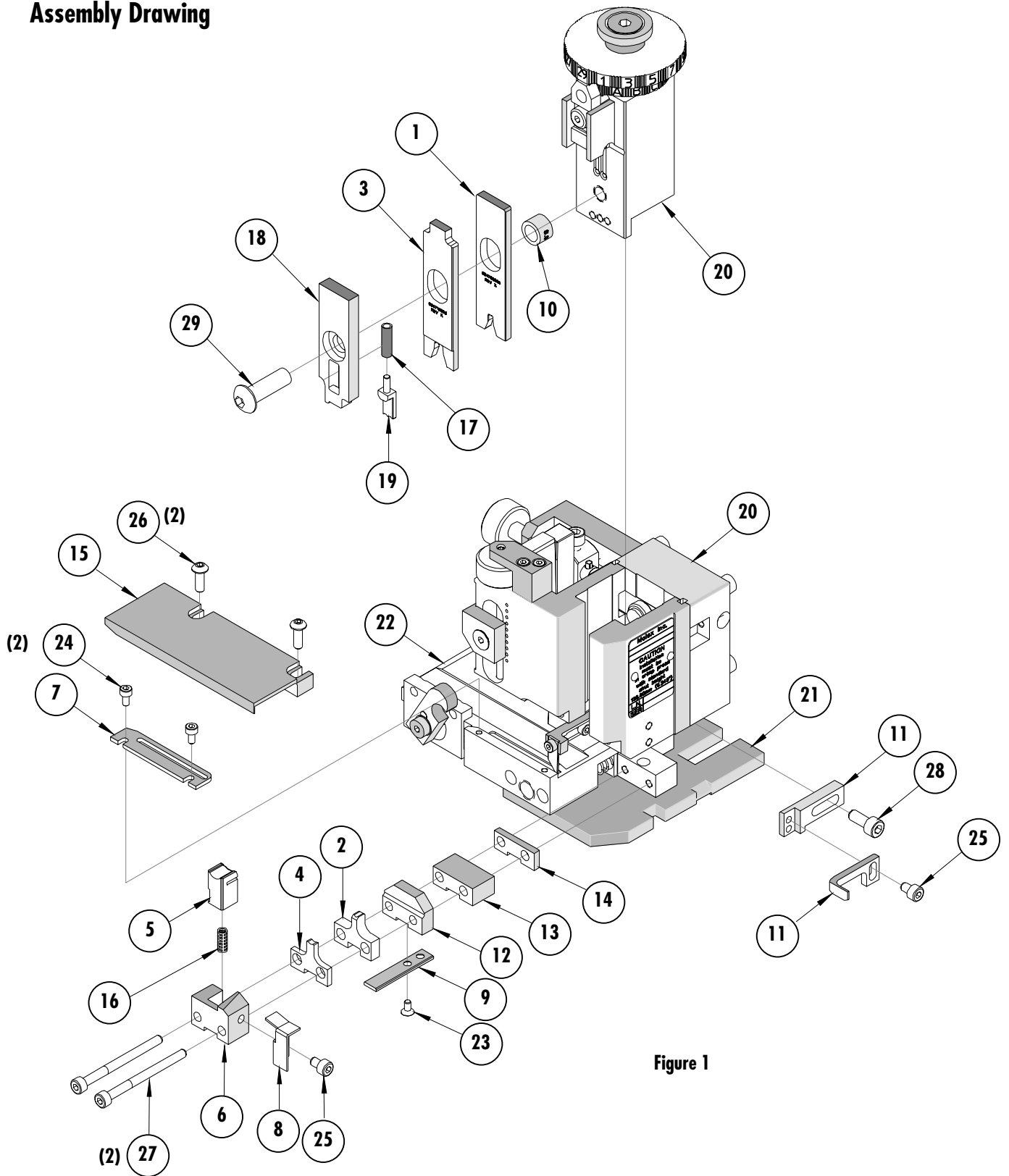


Figure 1

NOTES

1. Molex recommends an extra perishable tooling kit be maintained at your facility.
2. Verify tooling alignment by manually cycling the press 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

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