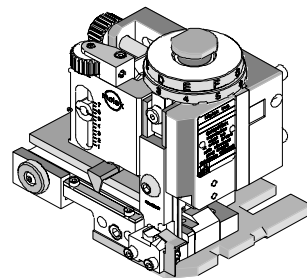




## Mini-Mac Applicator Application Tooling Specification Mechanical Feed-Front Metal Strip Order No. 63832-5000



### FEATURES

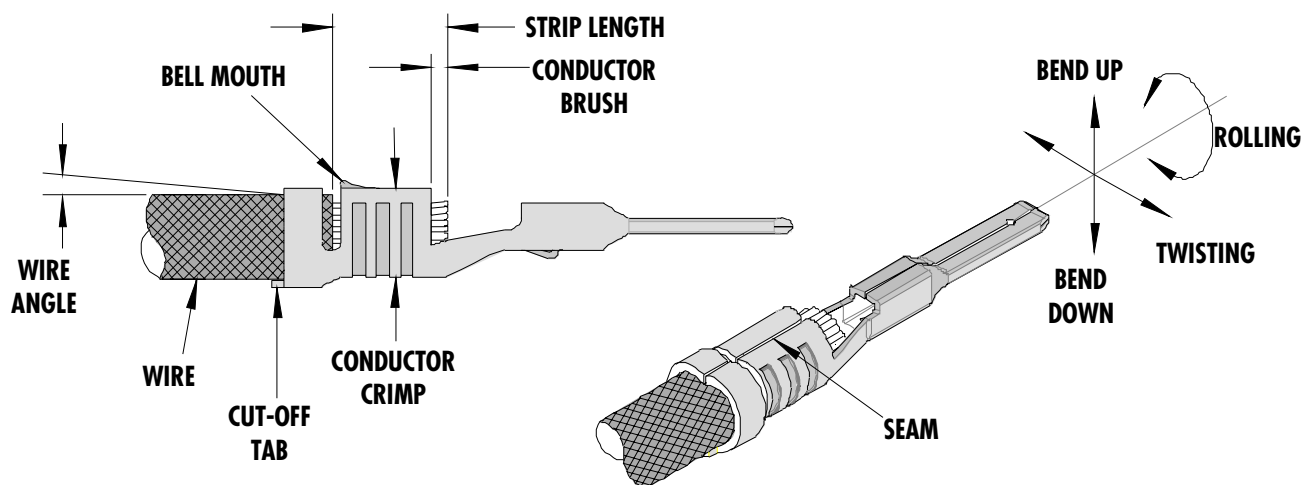
- Directly adapts to most crimp presses and automatic wire processors
- Applicator designed to industry-standard mounting and shut height of 135.80mm (5.346")
- Conductor and insulation rings allow quick adjustment for conductor and insulation crimp height change
- Quick set-up time; plus the crimp height,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

### SCOPE

Products: MX150L™ 10-12 AWG

| Terminal Series No. | Terminal Order No. | Wire Size |                 | Insulation Diameter |           | Strip Length |           |
|---------------------|--------------------|-----------|-----------------|---------------------|-----------|--------------|-----------|
|                     |                    | AWG       | mm <sup>2</sup> | mm                  | In.       | mm           | In.       |
| 19431               | 19431-0001         | 10-12     | 5.26-3.31       | 3.90-4.85           | .153-.191 | 5.50-6.20    | .217-.244 |
| 19434               | 19434-0001         | 10-12     | 5.26-3.31       | 3.90-4.85           | .153-.191 | 5.50-6.20    | .217-.244 |

### DEFINITION OF TERMS



### CRIMP SPECIFICATION

| Terminal Series No. | Bell mouth |           | Cut-off Tab Max. |      | Conductor Brush |           |
|---------------------|------------|-----------|------------------|------|-----------------|-----------|
|                     | mm         | In.       | mm               | In.  | mm              | In.       |
| 19431-0001          | 0.25-1.25  | .010-.049 | 0.50             | .020 | 0.10-0.50       | .004-.020 |
| 19434-0001          | 0.25-1.25  | .010-.049 | 0.50             | .020 | 0.10-0.50       | .004-.020 |

| Terminal<br>Series No. | Bend up   Bend down |   | Twist   Roll |   | Punch Width (Ref) |      |            |      | Wire Angle | Seam<br><br>Seam shall not be<br>open and no wire allowed<br>out of the crimping area |
|------------------------|---------------------|---|--------------|---|-------------------|------|------------|------|------------|---------------------------------------------------------------------------------------|
|                        | Degree              |   | Degree       |   | Conductor         |      | Insulation |      |            |                                                                                       |
|                        |                     |   |              |   | mm                | In   | mm         | In   | Degree     |                                                                                       |
| 19431-0001             | 2                   | 3 | 4            | 8 | 3.80              | .150 | 5.00       | .197 | 5° Max     |                                                                                       |
| 19434-0001             | 2                   | 3 | 4            | 8 | 3.80              | .150 | 5.00       | .197 | 5° Max     |                                                                                       |

After crimping, the crimp profiles should measure the following:

| Terminal<br>Series No. | Wire Size |                 | Conductor    |           |                       |               | Insulation   |          |                       |               | Pull Force<br>Min. |      |
|------------------------|-----------|-----------------|--------------|-----------|-----------------------|---------------|--------------|----------|-----------------------|---------------|--------------------|------|
|                        |           |                 | Crimp Height |           | Crimp Width<br>(Ref.) |               | Crimp Height |          | Crimp Width<br>(Ref.) |               |                    |      |
|                        | AWG       | mm <sup>2</sup> | mm           | In.       | mm                    | In.           | mm           | In.      | mm                    | In.           | N                  | Lb.  |
| 19431-0001             | 10        | 5.26            | 2.45-2.55    | .096-.100 | 3.80 +/- .10          | .150 +/- .004 | 5.00 Max     | .197 Max | 5.20 +/- .10          | .205 +/- .004 | 356.0              | 80.0 |
| 19431-0001             | 12        | 3.31            | 2.05-2.15    | .081-.085 | 3.80 +/- .10          | .150 +/- .004 | 4.50 Max     | .177 Max | 5.10 +/- .10          | .201 +/- .004 | 311.5              | 70.0 |
|                        |           |                 |              |           |                       |               |              |          |                       |               |                    |      |
| 19434-0001             | 10        | 5.26            | 2.45-2.55    | .096-.100 | 3.80 +/- .10          | .150 +/- .004 | 5.00 Max     | .197 Max | 5.20 +/- .10          | .205 +/- .004 | 356.0              | 80.0 |
| 19434-0001             | 12        | 3.31            | 2.05-2.15    | .081-.085 | 3.80 +/- .10          | .150 +/- .004 | 4.50 Max     | .177 Max | 5.10 +/- .10          | .201 +/- .004 | 311.5              | 70.0 |

\* This applicator was qualified to the above specifications with UL1015 wire.

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 63832-5000</b>                                        |                 |                        |                                       |                 |
|------------------------------------------------------------------------------|-----------------|------------------------|---------------------------------------|-----------------|
| <b>Item</b>                                                                  | <b>Order No</b> | <b>Engineering No.</b> | <b>Description</b>                    | <b>Quantity</b> |
| <b>Perishable Tooling</b>                                                    |                 |                        |                                       |                 |
|                                                                              | 63832-5070      | 63832-5070             | Tool Kit (All "Y" Items)              | REF             |
| 1                                                                            | 63465-0042      | 63465-0042             | Conductor Punch                       | 1 Y             |
| 2                                                                            | 63455-0029      | 63455-0029             | Conductor Anvil                       | 1 Y             |
| 3                                                                            | 63472-0002      | 63472-0002             | Insulation Punch                      | 1 Y             |
| 4                                                                            | 63445-5007      | 63445-5007             | Insulation Anvil                      | 1 Y             |
| 11                                                                           | 63443-0037      | 63443-0037             | Cut-off Plunger Front                 | 1 Y             |
| 13                                                                           | 63443-0038      | 63443-0038             | Plunger Retainer Front                | 1 Y             |
| <b>Other Components (Ref. 25050)</b>                                         |                 |                        |                                       |                 |
| 21                                                                           | 63466-0506      | 63466-0506             | Cut-off Plunger Striker Front         | 1               |
| 23                                                                           | 63443-0009      | 63443-0009             | Scrap Chute Front                     | 1               |
| 25                                                                           | 63700-0539      | 63700-0539             | Cut-Off Plunger Spring                | 1               |
| 31                                                                           | 63832-5005      | 63832-5005             | Anvil Mount                           | 1               |
| 33                                                                           | 63443-0021      | 63443-0021             | Lower Tooling Key                     | 1               |
| 45                                                                           | 63443-0061      | 63443-0061             | Wire Stop                             | 1               |
| 52                                                                           | 63890-0866      | 63890-0866             | Collar-6.40 Lg.                       | 1               |
| 53                                                                           | 63890-0995      | 63890-0995             | Collar-4.05 Lg.                       | 1               |
| 72                                                                           | 11-18-4083      | 60707-8                | Feed Guide                            | 1               |
| 73                                                                           | 63443-6140      | 63443-6140             | Rear Cover                            | 1               |
| <b>Frame</b>                                                                 |                 |                        |                                       |                 |
| 81                                                                           | 63801-3201      | 63801-3201             | Mechanical Feed Applicator Frame Head | REF             |
| 82                                                                           | 63801-3281      | 63801-3281             | Base                                  | REF             |
| 83                                                                           | 63801-4650      | 63801-4650             | Track Assembly                        | REF             |
| <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 12 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

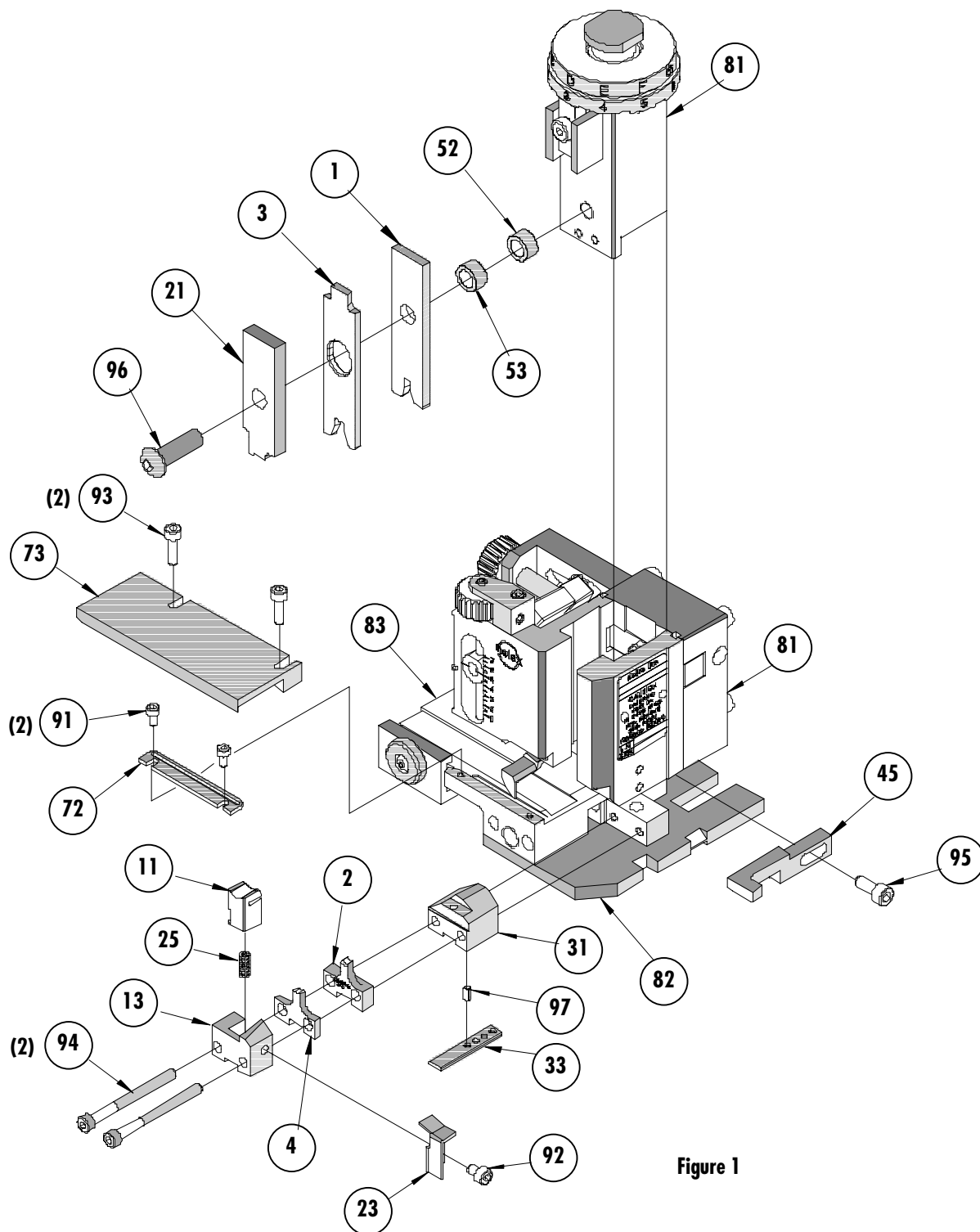


Figure 1

## 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 Mini-Mac Applicator Manual (Document no. 63880-0000).

**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.

### **Molex Application Tooling Group**

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Visit our Web site at <http://www.molex.com>



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