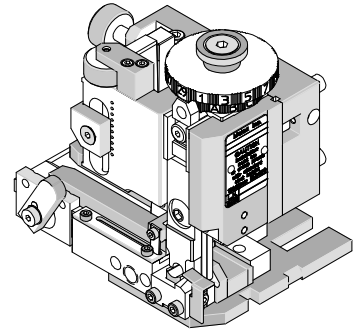




Mini-Mac Applicator Application Tooling Specification Order No. 63832-6100



FEATURES

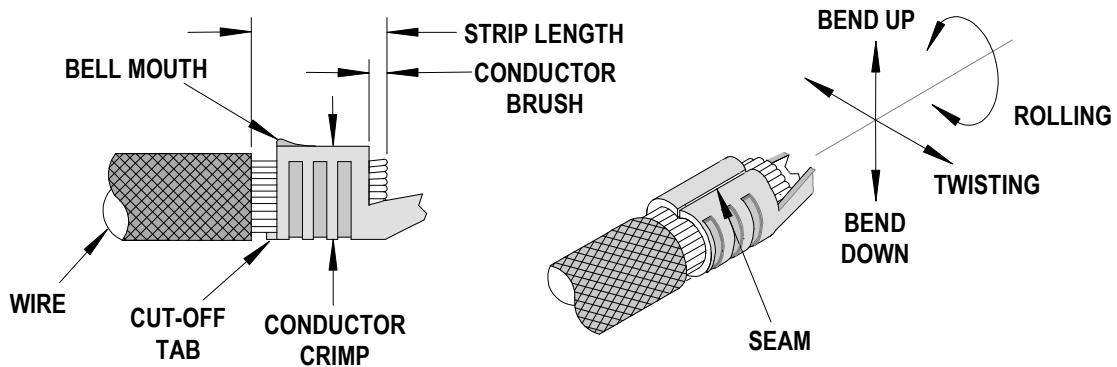
- Directly adapts to most automatic wire processing machines
- Applicator designed to industry standard mounting and shut height 135.80mm (5.346")
- Quick set-up time; plus the crimp height, track and feed adjustments can be set without removing the applicator from the press
- Fine adjustment allows 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: Male and Female Power Contact Crimp Terminals, 14-16 AWG, 18 AWG Doubles, and 16 AWG Doubles.

| Terminal Series No. | *Terminal Order No. | | | Wire Size | | Insulation Diameter Maximum | | Strip Length | |
|--|---------------------|------------|------------|-----------|-----------------|-----------------------------|-----|--------------|-----|
| | | | | AWG | mm ² | mm | In. | mm | In. |
| 44262 | 44262-4306 | 44262-4506 | 44262-6412 | 14-16 | 2.00-1.30 | N/A | N/A | 6.35 | .25 |
| | 44262-4336 | 44262-4536 | 44262-6420 | 18 (2) | 0.80 (2) | | | | |
| | 44262-4406 | 44262-6410 | 44262-6422 | 16 (2) | 1.30 (2) | | | | |
| | 44262-4436 | 44262-6411 | 44262-6421 | | | | | | |
| 63832-6100 Applicator is set up to crimp Male terminals. To crimp female terminals perishable tooling set-up needs to be changed. No additional parts are required. *See Changeover Parts on page 3 for each terminal listed. | | | | | | | | | |

DEFINITION OF TERMS



The above terminal drawing is a generic terminal representation. It is not an image of any terminal listed in the scope.

CRIMP SPECIFICATION

| Terminal Series No. | Bell mouth | | Cut-off Tab Maximum | | Conductor Brush | |
|---------------------|------------|-----------|---------------------|------|-----------------|-----------|
| | mm | In. | mm | In. | mm | In. |
| 44262 | 0.25-1.25 | .010-.049 | 0.50 | .020 | 0.64-1.90 | .025-.075 |

| 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 | | |
| | mm | In | mm | In | mm | In | mm | In | |
| 44262 | 3 | 3 | 3 | 3 | 3.90 | .154 | N/A | N/A | |

After crimping, the crimp profiles should measure the following.

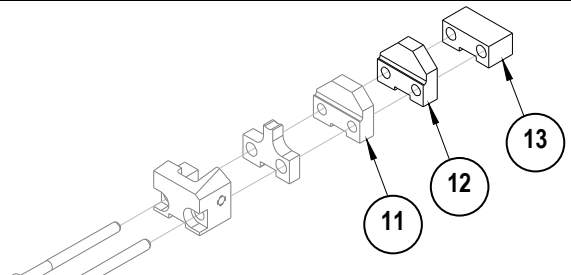
| Terminal Series No. | Wire Size | | Conductor | | | | Pull Force Minimum | |
|---------------------|-----------|-----------------|--------------|-----------|--------------------|------|--------------------|------|
| | AWG | mm ² | Crimp Height | | Crimp Width (Ref.) | | N | Lb. |
| | | | mm | In. | mm | In. | | |
| 44262 | 14 | 2.00 | 2.65-2.75 | .104-.108 | 4.00 | .158 | 222.41 | 50.0 |
| | 16 | 1.30 | 2.50-2.60 | .098-.102 | 4.00 | .158 | 133.45 | 30.0 |
| | 18 (2) | 0.80 (2) | 2.55-2.65 | .100-.104 | 4.00 | .158 | 88.96 | 20.0 |
| | 16 (2) | 1.30 (2) | 2.65-2.75 | .104-.108 | 4.00 | .158 | 133.45 | 30.0 |

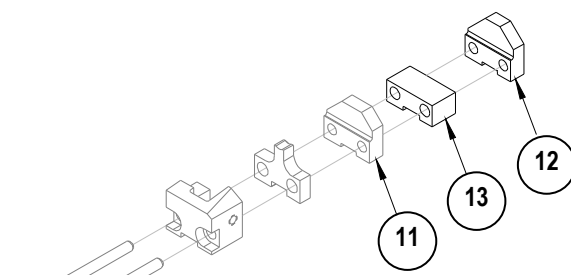
* This applicator was qualified to the above specifications with UL 1015 wire.

The above specifications are guidelines to an optimum crimp.

*** Changeover Parts**

The following charts below show the different locations for the spacers when crimping male or female terminals.

| Terminal Series No. | Terminal Order No. | | | |
|--|--------------------|------------|----------------|------------|
| 44262 (Male) | 44262-6410 | 44262-6411 | 44262-6412 | 44262-6420 |
| | 44262-6421 | 44262-6422 | | |
| Note: To properly crimp these terminals, assemble spacers with cutoff tooling as shown in Figure 1. See also parts list and assembly drawing. | | | | |
|  <p style="text-align: center;">Figure 1</p> | Item No. | Order No. | Description | |
| | 11 | 63443-1719 | 18.90mm Spacer | |
| | 12 | 63443-1734 | 20.40mm Spacer | |
| | 13 | 63443-2212 | 12.00mm Spacer | |

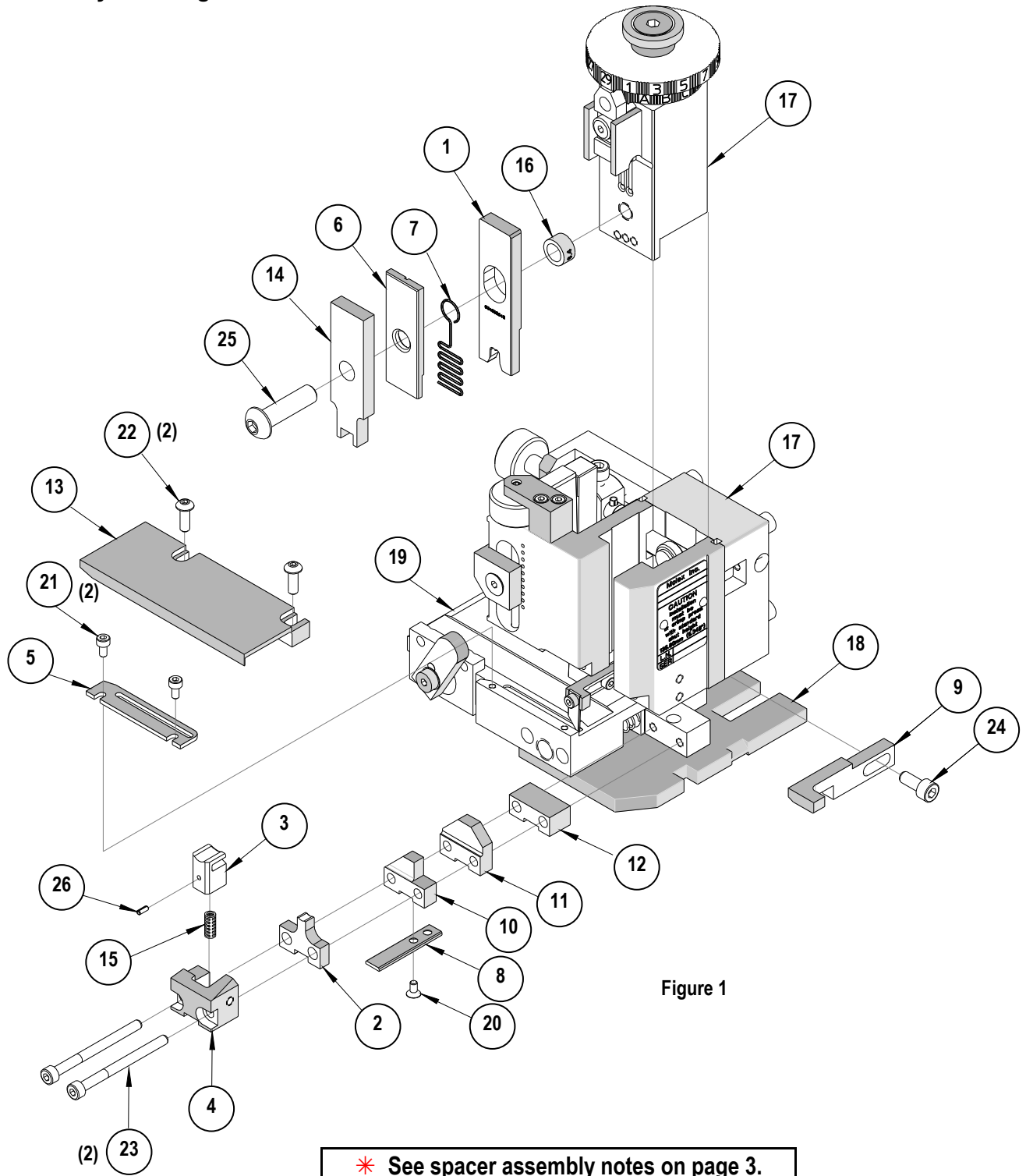
| Terminal Series No. | Terminal Order No. | | | |
|--|--------------------|------------|----------------|------------|
| 44262 (Female) | 44262-4306 | 44262-4336 | 44262-4406 | 44262-4436 |
| | | | | |
| Note: To properly crimp these terminals, assemble spacers with cutoff tooling as shown in Figure 1. See also parts list and assembly drawing. | | | | |
|  <p style="text-align: center;">Figure 2</p> | Item No. | Order No. | Description | |
| | 11 | 63443-1719 | 18.90mm Spacer | |
| | 13 | 63443-2212 | 12.00mm Spacer | |
| | 12 | 63443-1734 | 20.40mm Spacer | |

PARTS LIST

| Mini-Mac Applicator 63832-6100 | | | | |
|--|-----------------|------------------------|---------------------------|-----------------|
| Item | Order No | Engineering No. | Description | Quantity |
| Perishable Tooling | | | | |
| | 63832-6170 | 63832-6170 | Tool Kit (All "Y" Items) | REF |
| 1 | 63465-0050 | 63465-0050 | Conductor Punch | 1 Y |
| 2 | 63455-0046 | 63455-0046 | Conductor Anvil | 1 Y |
| 3 | 63443-0095 | 63443-0095 | Front Cut-Off Plunger | 1 Y |
| 4 | 63890-0487 | 63890-0487 | Front Plunger Retainer | 1 Y |
| Other Components (REF 326150) | | | | |
| 5 | 63821-0012 | 63821-0012 | Feed Guide | 1 |
| 6 | 11-18-4848 | 60800A123 | Spring Retainer | 1 |
| 7 | 11-18-4849 | 60800A124 | Wire Hold Down Spring | 1 |
| 8 | 63443-0024 | 63443-0024 | Key | 1 |
| 9 | 63821-0015 | 63821-0015 | Wire Stop | 1 |
| 10 | *63443-1719 | 63443-1719 | 18.90mm Spacer | 1 |
| 11 | *63443-1734 | 63443-1734 | 20.40mm Spacer | 1 |
| 12 | *63443-2212 | 63443-2212 | 12.00mm Spacer | 1 |
| 13 | 63443-6130 | 63443-6130 | Rear Cover | 1 |
| 14 | 63466-0509 | 63466-0509 | Striker-Flat Bottom | 1 |
| 15 | 63700-0539 | 63700-0539 | Compression Spring | 1 |
| 16 | 63890-0866 | 63890-0866 | Bushing-Punch (Conductor) | 1 |
| Frame | | | | |
| 17 | 63801-3201 | 63801-3201 | Top | 1 |
| 18 | 63801-3281 | 63801-3281 | Base | 1 |
| 19 | 63801-4650 | 63801-4650 | Track | 1 |
| Hardware | | | | |
| 20 | N/A | N/A | M3 by 6 Long FHCS | 1** |
| 21 | N/A | N/A | M3 by 6 Long SHCS | 2** |
| 22 | N/A | N/A | M4 by 12 Long BHCS | 2** |
| 23 | N/A | N/A | M4 by 50 Long SHCS | 2** |
| 24 | N/A | N/A | M5 by 12 Long SHCS | 1** |
| 25 | N/A | N/A | M8 by 30 Long BHCS | 1** |
| 26 | N/A | N/A | 2mm by 5 Long Roll Pin | 1** |
| ** Available from an industrial supply company such as MSC (1-800-645-7270). | | | | |

*** See spacer assembly notes on page 3.**

Assembly Drawing



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.

Americas Headquarters
Lisle, Illinois 60532 U.S.A.
1-800-78MOLEX
amerinfo@molex.com

Far East North Headquarters
Yamato, Kanagawa, Japan
81-462-65-2324
feninfo@molex.com

Far East South Headquarters
Jurong, Singapore
65-6-268-6868
fesinfo@molex.com

European Headquarters
Munich, Germany
49-89-413092-0
eurinfo@molex.com

Corporate Headquarters
2222 Wellington Ct.
Lisle, IL 60532 U.S.A.
630-969-4550
Fax: 630-969-1352

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

63832-6100 Applicator
is set up to crimp Male
terminals. To crimp female
terminals perishable tooling
set-up needs to be changed.
No additional parts are
required.

See Changeover Parts on
page 3 of Application Tooling
Specification for each
terminal listed.