Mini-Mac Applicator Air Feed	**molex**® Application Tooling Specification Sheet	Order No.63832-0800
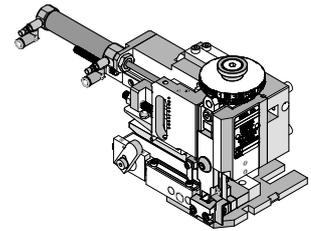
FEATURES

- 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.
- Molex applicators with air feed require presses equipped with an air valve. Molex presses with air valves include the TM-4000 (63801-7600).

SCOPE

Products: Power 60 Amp Crimp Terminals, 10 AWG

Terminal Series No.	Terminal Order No.	Wire Size		✦Insulation Diameter Maximum		Strip Length	
		AWG	mm²	mm	In.	mm	In.
46819	46819-0011	10	5.00	9.00	.354	8.00-9.00	.315-.354
✦Overall insulation OD specification for terminal.							

Note: The 63832-0800 applicator must be used with TM-4000 (63801-7600) or an equivalent press with no less than 3 tons.

DEFINITION OF TERMS
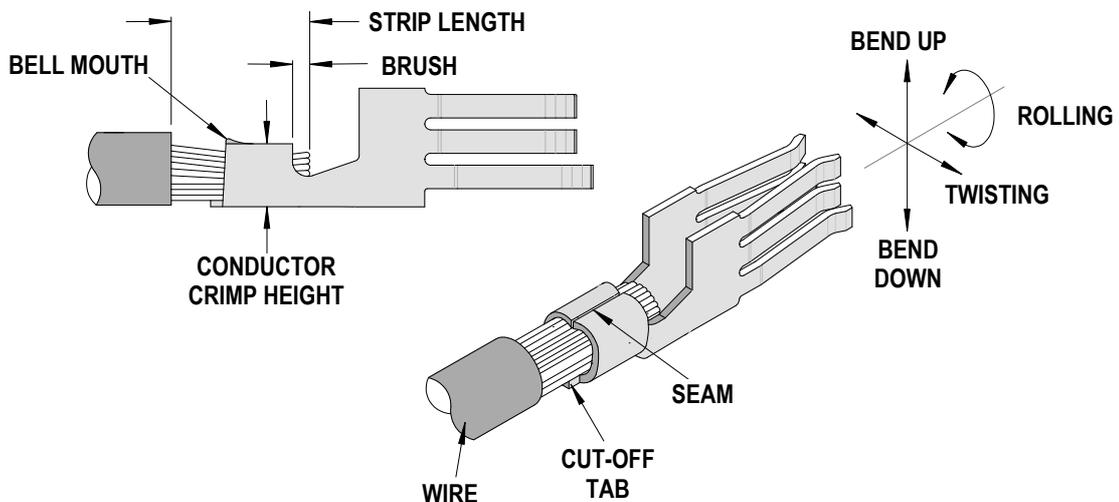
CRIMP SPECIFICATION

Terminal Series No.	Bell mouth		Cut-off Tab Maximum		Conductor Brush	
	mm	In.	mm	In.	mm	In.
46819	0.25-1.25	.010-.049	0.35	.014	1.00-2.50	.039-.098

Terminal Series No.	Bend up	Bend down	Twist	Roll	Punch Width (Ref)		Seam
	Degree		Degree		Conductor		Seam shall not be open and no wire allowed out of the crimping area
					mm	In	
46819	3	3	3	3	4.90	.193	

After crimping, the crimp profiles should measure the following.

Terminal Series No.	Wire Size		Conductor				Pull Force Minimum	
			Crimp Height		Crimp Width (Ref.)			
	AWG	mm²	mm	In.	mm	In.	N	Lb.
46819	10	5.00	2.85-2.95	.112-.116	5.00	.197	600.51	135.00

Tool Qualification Notes:

1. The above specifications are guidelines to an optimum crimp.

PARTS LIST

Mini-Mac Applicator 63832-0800				
Item	**Order No**	**Engineering No.**	**Description**	**Quantity**
Perishable Tooling				
	63832-0870	63832-0870	Tool Kit (All "Y" Items)	REF
1	63465-0070	63465-0070	Conductor Punch	1 Y
2	63455-0072	63455-0072	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				
5	11-18-4848	60800A123	Spring Retainer	1
6	11-18-4849	60800A124	Wire Hold Down Spring	1
7	63443-0007	63443-0007	Scrap Chute Front	1
8	63443-0025	63443-0025	Key	1
9	63443-1225	63443-1225	Wire Stop	1
10	63443-1715	63443-1715	Height Spacer (18.50mm)	
11	63443-2214	63443-2214	Coarse Spacer (14.00mm)	1
12	63443-2304	63443-2304	Fine Spacer (3.20mm)	1
13	63466-0512	63466-0512	Striker	1
14	63700-0539	63700-0539	Compression Spring	1
15	63801-3511	63801-3511	Feed Finger	1
16	63821-0012	63821-0012	Feed Guide	1
17	63832-0602	63832-0602	Rear Cover	1
18	63890-0866	63890-0866	Bushing-Punch (Conductor)	1
Frame				
19	63801-3301	63801-3301	Top	1
20	63801-3281	63801-3281	Base	1
21	63801-4650	63801-4650	Track	1
22	63801-3501	63801-3501	Air-Feed Assembly	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	1**
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**
30	N/A	N/A	2mm by 5 Long 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.

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