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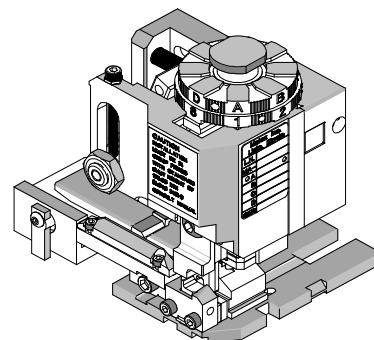
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Mini-Mac Applicator "Flat Blade" Terminals



Mini-Mac Applicator Specification Sheet Part No. 63830-4000



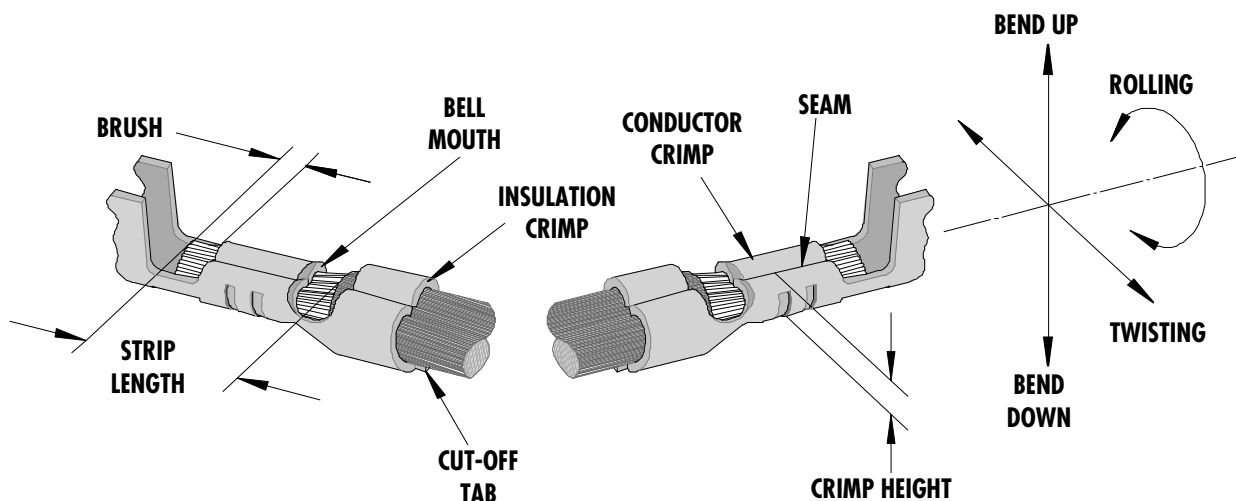
FEATURES

- Quick set-up time; plus the crimp height, track and feed adjustments can be preset in applicator
- Conductor and insulation rings allow quick adjustment for conductor and insulation diameter change
- Applicator designed to industry standard mounting and shut height 135.80mm (5.346")
- Directly adapts to most automatic wire processing machines

SCOPE

| Terminal Series No. | Wire Size | | Insulation Diameter | | Strip Length | |
|------------------------|-----------|-----------------|---------------------|-----------|--------------|-----------|
| | AWG | mm ² | mm | In. | mm | In. |
| 43178-100* | 18 | 0.80 | 2.36-3.56 | .093-.140 | 3.96-5.54 | .156-.218 |

DEFINITION OF TERMS



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

Mini-Mac Applicator "Flat Blade" Terminals

CRIMP SPECIFICATIONS

| Terminal Series No. | Bell mouth | | Cut-off Tab Max. | | Conductor Brush | |
|---------------------|------------|-----------|------------------|------|-----------------|------|
| | mm | In. | mm | In. | mm | In. |
| 43178-100* | 0.25-1.00 | .010-.039 | 0.50 | .019 | 1.50 | .059 |

| Terminal Series No. | Bend up Bend down | | Twist Roll | | Punch Width (Ref) | | | | Seam |
|---------------------|-------------------|---|------------|---|-------------------|------|------------|------|---|
| | Degree | | Degree | | Conductor | | Insulation | | |
| | | | | | mm | In | mm | In | |
| 43178-100* | 3 | 3 | 4 | 8 | 3.20 | .126 | 4.30 | .169 | Seam shall not be open and no wire allowed out of the crimping area |

After crimping, the conductor profile should measure the following.

| Terminal Series No. | Wire Size | | Crimp Height | | Pull Force Min. | |
|---------------------|-----------|-----------------|--------------|-----------|-----------------|-----|
| | AWG | mm ² | mm | In. | N | Lb. |
| 43178-100* | 18 | 0.80 | 1.78-1.88 | .070-.074 | 88.9 | 20 |

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

The above specifications are guidelines to an optimum crimp.

Mini-Mac Applicator "Flat Blade" Terminals

PARTS LIST

| Item | Order No | Engineering No. | Description | Quantity |
|------|-------------------|-------------------|-----------------------------------|------------|
| | 63830-4000 | 63830-4000 | Mini-Mac Applicator | REF |
| 1 | 11-18-5413 | 60842A106 | Conductor Punch | 1 Y |
| 2 | 63445-3262 | 63445-3262 | Conductor Anvil | 1 Y |
| 3 | 11-18-5419 | 60843A108 | Insulation Punch | 1 Y |
| 4 | 63445-4322 | 63445-4322 | Insulation Anvil | 1 Y |
| 5 | 63443-0047 | 63443-0047 | Front Cut-Off Plunger | 1 Y |
| 6 | 63443-0012 | 63443-0012 | Cut-off Plunger Retainer | 1 Y |
| 7 | 63700-0539 | 63700-0539 | Heavy Duty Cut-off Plunger Spring | 1 |
| 8 | 63830-3006 | 63830-3006 | Front Plunger Striker | 1 |
| 9 | 63443-0021 | 63443-0021 | Lower Tooling Key | 1 |
| 10 | 11-18-5440 | 60842A117 | Rear Cover | 1 |
| 11 | 11-18-5441 | 60842A123 | Front Cover | 1 |
| 12 | 63830-4002 | 63830-4002 | Anvil Mount | 1 |
| 13 | 63821-0015 | 63821-0015 | Wire Stop | 1 |
| 14 | 63830-3005 | 63830-3005 | Tooling Washer | 1 |
| 15 | 11-18-5016 | 60812A105 | Conductor Adjusting Cam | 1 |
| 16 | 63800-0100 | 63800-0100 | Mini-Mac Applicator Frame | 1 |
| 17 | N/A | N/A | M3 by 6 Lg. SHCS | 2** |
| 18 | N/A | N/A | M4 by 8 Lg. BHCS | 4** |
| 19 | N/A | N/A | M4 by 10 Lg. BHCS | 2** |
| 20 | N/A | N/A | M4 by 25 Lg. SHCS | 2** |
| 21 | N/A | N/A | M5 by 12 Lg. SHCS | 1** |
| 22 | N/A | N/A | 3MM by 6 Lg. Roll Pin | 1** |
| 23 | 63830-4070 | 63830-4070 | Tool Kit (All "Y" Items) | REF |

** The following purchased parts are available from an Industrial supply company such as MSC (1-800-645-7270).

Mini-Mac Applicator "Flat Blade" Terminals

Assembly Drawing

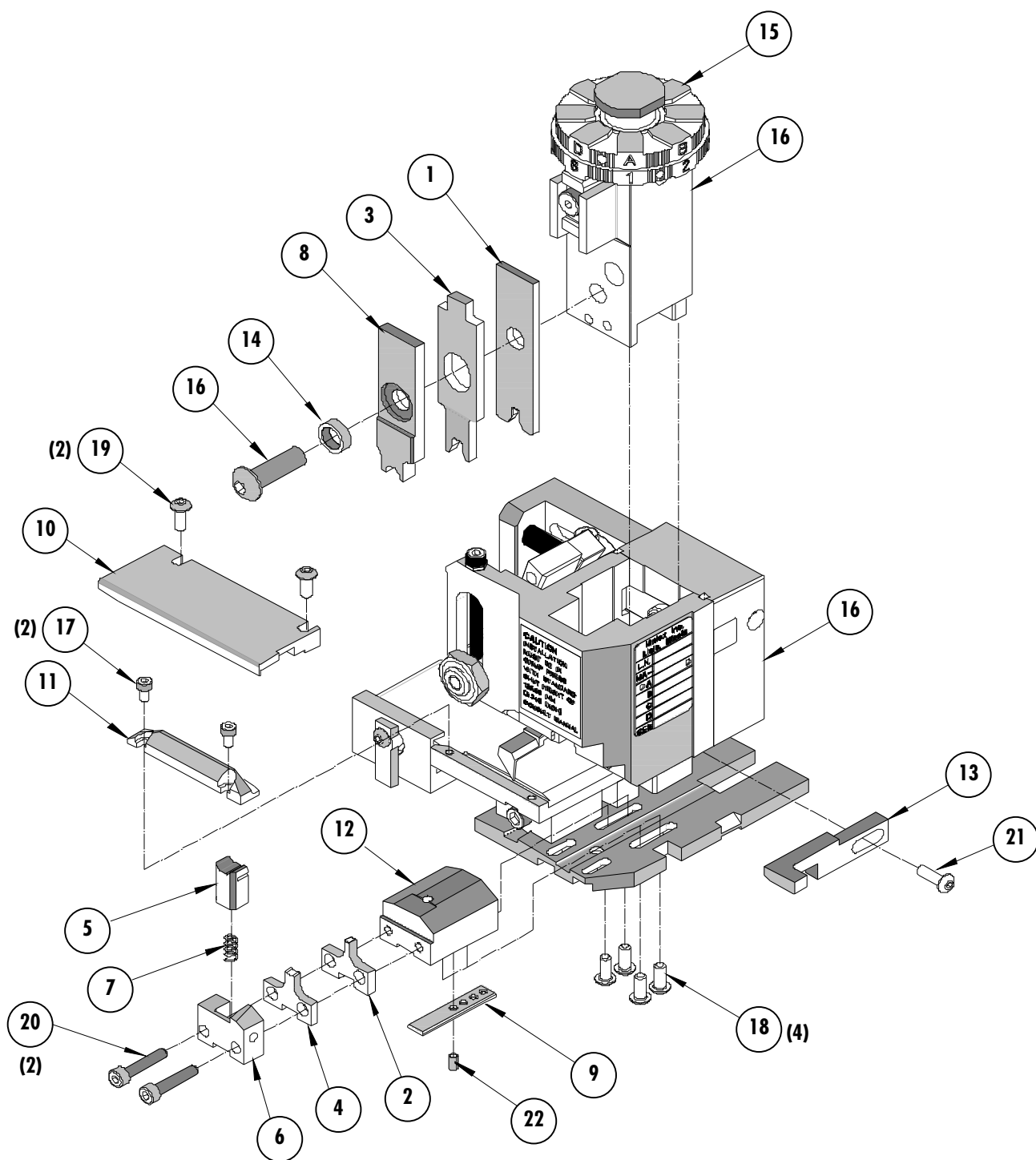


Figure 1

Mini-Mac Applicator "Flat Blade" Terminals

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 MiniMac 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 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.

Molex Application Tooling Group

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