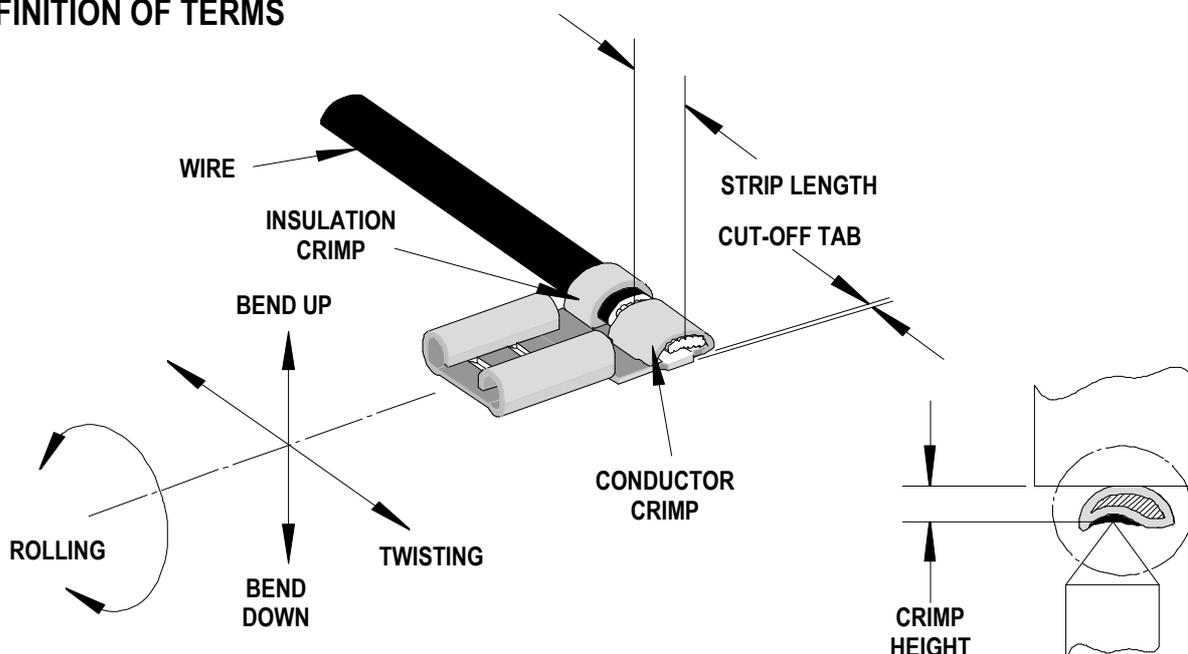| **Mini-Mac Applicator Rear Feed**	**molex®**	
	Application Tooling Specification Sheet	
	Order No. 63802-7500	
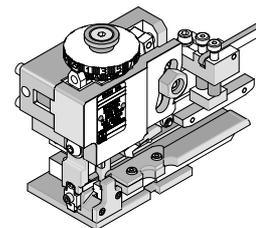
FEATURES

- 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

<u>Products</u>: Flag Krimptite™ Quick Disconnect Female Terminals, 18-22 AWG.

Terminal Order No.	Terminal Eng. No.	Wire Size		Tab Size		Insulation Diameter		Strip Length	
		AWG	mm²	mm	In.	mm	In.	mm	In.
19008-0008	AAZ-1147	18-22	0.80-0.35	4.75 by 0.51	.187 by .020	N/A	N/A	7.94	.313
19008-0009	AAZ-1147-032	18-22	0.80-0.35	4.75 by 0.81	.187 by .032	N/A	N/A	7.94	.313
19008-0013	AAZ-1158	18-22	0.80-0.35	6.35 by 0.51	.250 by .020	N/A	N/A	7.94	.313

DEFINITION OF TERMS

WIRE
INSULATION CRIMP
BEND UP
ROLLING
BEND DOWN
TWISTING
CONDUCTOR CRIMP
STRIP LENGTH
CUT-OFF TAB
CRIMP HEIGHT

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

CRIMP SPECIFICATIONS

Terminal Order No.	Terminal Eng. No.	Wire Size		Conductor Crimp Height						Pull Force Minimum	
				Mean		Go		No Go			
		AWG	mm²	mm	In.	mm	In.	mm	In.	N	Lb.
19008-0008	AAZ-1147	18	0.80	1.27	.050	1.22	.048	1.32	.052	20.0	89.0
		20	0.50							13.0	57.9
		22	0.35							8.0	35.6
19008-0009	AAZ-1147-032	18	0.80	1.27	.050	1.22	.048	1.32	.052	20.0	89.0
		20	0.50							13.0	57.9
		22	0.35							8.0	35.6
19008-0013	AAZ-1158	18	0.80	1.27	.050	1.22	.048	1.32	.052	20.0	89.0
		20	0.50							13.0	57.9
		22	0.35							8.0	35.6
Seam Seam shall not be open and no wire allowed out of the crimping											

Pull Force should be measured with no influence from the insulation crimp. The above specifications are guidelines to an optimum crimp.

CRIMP PROFILE
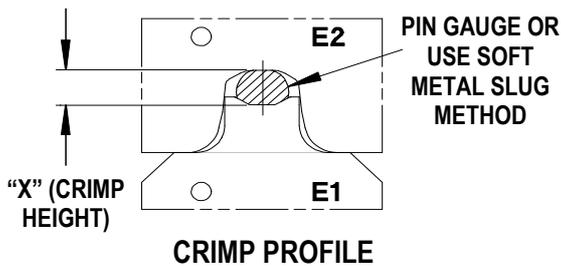
Use gauge pins or soft metal slug (solder) method to measure the "X" dimension. Verify tooling crimp height calibration by referring to the Go/No Go dimensions shown in the chart below.

Molex does not sell gauge pins contact your local industrial supplier.

PARTS LIST

Rear Feed Applicator 63802-7500				
Item	Order No	Engineering No.	Description	Quantity
Perishable Tooling				
	63802-7570	63802-7570	Tool Kit (All "Y" Items)	REF
1	63801-5514	63801-5514	Conductor Punch (Upper Die)	1 Y
2	19230-0086	24854-23	Conductor Anvil (Indenter Die)	1 Y
3	19229-0120	23650-43	Cutter Housing	1 Y
4	19229-0121	23650-44	Cutter Plunger	1 Y
Other Components				
5	19229-0095	23650-45	Cutter Back Plate	1
6	19229-0161	23650-49	Compression Spring	1
7	19230-0038	24854-08	Feed Finger	1
8	19230-0101	24854-09	Guide Rail	1
9	19230-0106	24854-25P	Guide and Hold Down	1
10	63801-7160	63801-7160	Terminal Drag Assembly	1
11	63801-7701	63801-7701	Cutter Striker	1
12	63803-5109	63803-5109	Conductor Bushing	1
Frame				
13	19230-0084	24854-05	Slide (Terminal Track)	1
14	63801-2600	63801-2600	Rear Feed Frame	1
15	63801-2603	63801-2603	Base	1
Hardware				
16	N/A	N/A	M3 by 10 Long SHCS	2**
17	N/A	N/A	M4 by 8 Long SHCS	6**
18	N/A	N/A	M4 by 8 Long BHCS	2**
19	N/A	N/A	M4 by 12 Long SHCS	2**
20	N/A	N/A	M6 by 10 Long BHCS	6**
21	N/A	N/A	M8 by 20 Long BHCS	1**
22	N/A	N/A	M8 Flat Washer	1**
23	N/A	N/A	6mm by 10 Long Dowel Pin	4**
** 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.

Wear Safety Glasses At All Times.

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