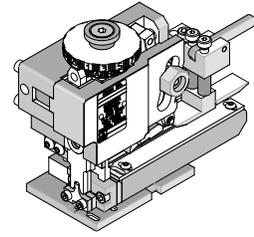


**Mini-Mac
Applicator
Rear Feed**



**Application Tooling
Specification Sheet**



Order No. 63806-4700

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

Products: .250 Slip on QD Receptacle Terminals, 20-22 AWG, UL1015 Wires.

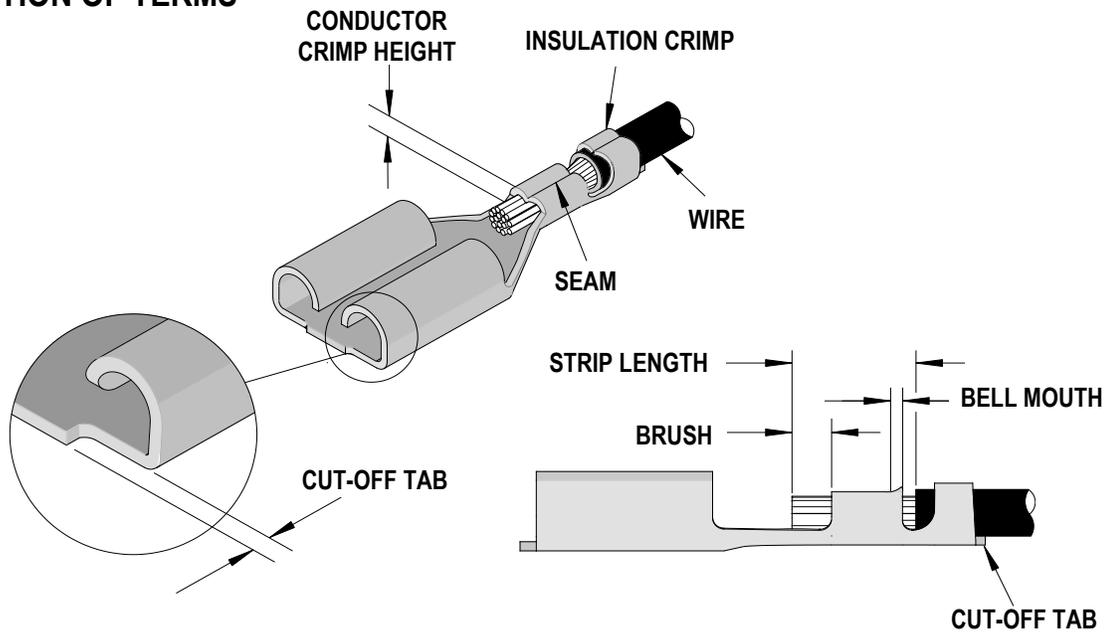
Terminal Series No.	Terminal Order No.		Wire Size		Insulation Diameter				Strip Length	
					IPC/WHMA-A620 (1)		Terminal (2) Insulation range			
					AWG	mm ²	mm	In.		
35725	35725-3800	35725-3801	20-22	---	2.30-2.60	.090-.102	2.60 Max.	.102 Max.	4.80-5.20	.189-.205

Note: This terminal will accommodate the UL1015 Wires.

(1) To achieve optimum IPC-A620 insulation crimps, use this insulation OD range. UL1015 Wires is recommended.

(2) Overall insulation OD specification for terminal.

DEFINITION OF TERMS



CRIMP SPECIFICATIONS

Terminal Series No.	Bell mouth		Cut-off Tab Maximum		Conductor Brush	
	mm	In.	mm	In.	mm	In.
35725	0.30-0.60	.012-.024	0.50	.020	0.30-0.80	.012-.031

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		Insulation		
	mm	In.	mm	In.	mm	In.	mm	In.	
35725	3	3	3	5	2.20	.087	3.00	.118	

After crimping, the crimp profiles should measure the following:

Terminal Series No.	Wire Size		Conductor Crimp				Insulation Crimp (REF)				Pull Force Minimum	
			Height		Width		Height		Width			
	AWG	mm ²	mm	In.	mm	In.	mm	In.	mm	In.	N	Lb.
35725	20	--	1.20-1.40	.047-.055	2.1-2.3	.082-.090	NA	NA	3.00	.118	78.3	17.6
	22	--	1.10-1.30	.043-.051	2.1-2.3	.082-.090	NA	NA	3.00	.118	58.7	13.2

* Tool Qualification Notes:

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

PARTS LIST

Mini-Mac Applicator 63806-4700				
Item	Order No.	Engineering No.	Description	Quantity
Perishable Tooling				
	63806-4770	63806-4770	Tool Kit (All "Y" Items)	REF
1	63806-4701	63806-4701	Conductor Punch	1 Y
2	63464-2201	63464-2201	Conductor Anvil	1 Y
3	63806-4702	63806-4702	Insulation Punch	1 Y
4	63445-3072	63445-3072	Insulation Anvil	1 Y
5	63801-5018	63801-5018	Cut-off Punch	1 Y
6	63485-1402	63485-1402	Cut-off Die	1 Y
7	63801-4906	63801-4906	Cut-Off Blade	1 Y
Other Components				
8	11-18-5371	60817A117	Feed Finger	1
9	63485-1809	63485-1809	Hold Down Blade	1
10	63700-4411	63700-4411	Compression Spring	1
11	63801-4160	63801-4160	Guide – R.H.	1
12	63801-4161	63801-4161	Guide – L.H.	1
13	63801-5013	63801-5013	Wire Stop	1
14	63801-5022	63801-5022	Spacer for Cut-off Punch	1
15	63801-5033	63801-5033	Tooling Washer	1
16	63803-5141	63803-5141	Conductor Bushing	1
Frame				
17	63801-2600	63801-2600	Rear Feed Applicator Frame Head	1
18	63801-2603	63801-2603	Base	1
19	63801-7151	63801-7151	Terminal Track	1
20	63801-7160	63801-7160	Terminal Drag Assembly	1
Hardware				
21	N/A	N/A	M4 by 8 Long BHCS	4**
22	N/A	N/A	M4 by 10 Long BHCS	1**
23	N/A	N/A	M4 by 14 Long SHCS	2**
24	N/A	N/A	M4 by 16 Long SHCS	2**
25	N/A	N/A	M5 by 12 Long BHCS	2**
26	N/A	N/A	M5 by 20 Long SHCS	2**
27	N/A	N/A	M6 by 10 Long BHCS	4**
28	N/A	N/A	M8 by 20 Long BHCS	1**
** Available from an industrial supply company such as MSC (1-800-645-7270).				

Assembly Drawing

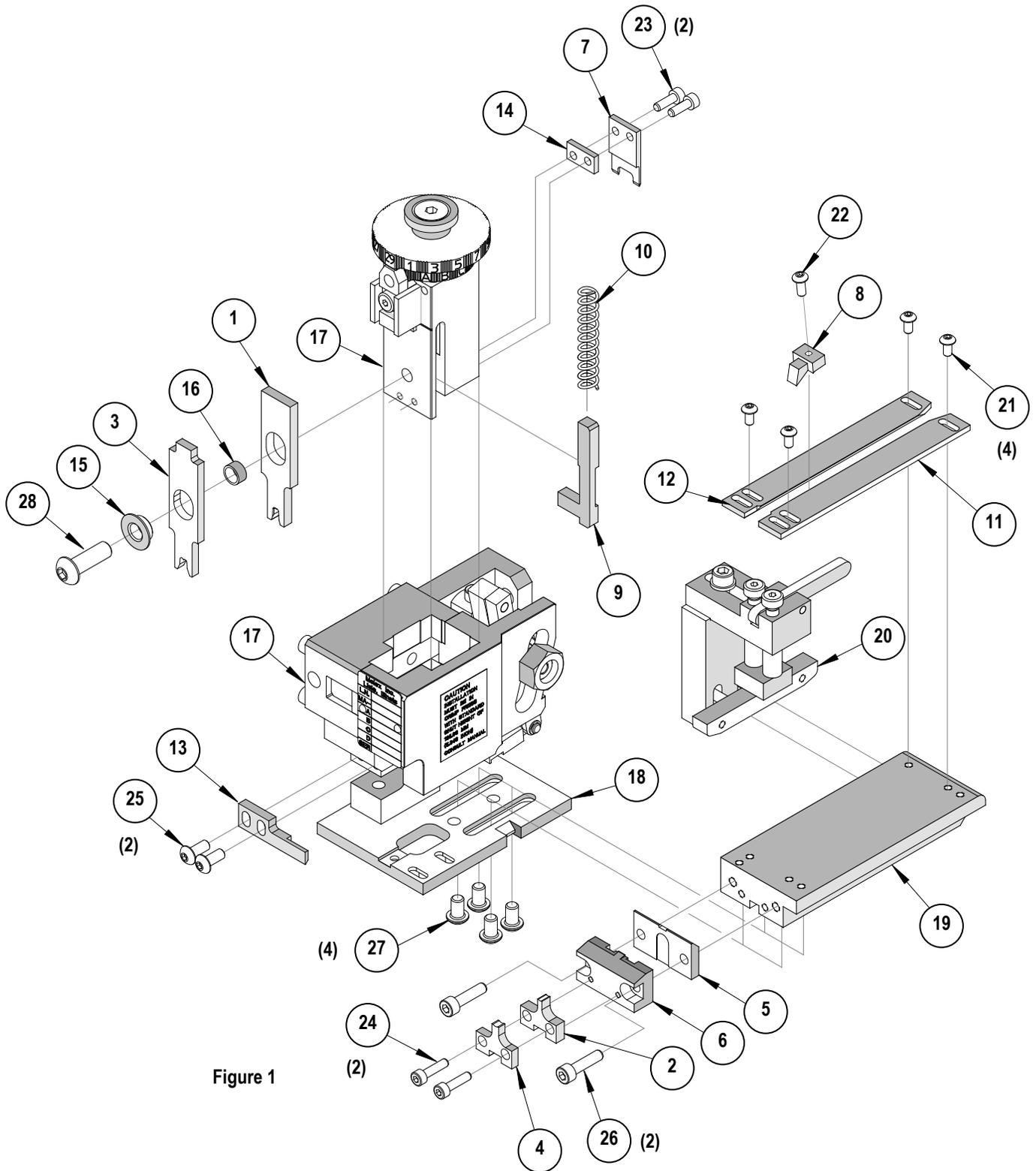


Figure 1

NOTES

1. Molex recommends an extra perishable tooling kit be maintained at your facility.
2. Verify tooling alignment by manually cycling the press 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 135.8mm (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.

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