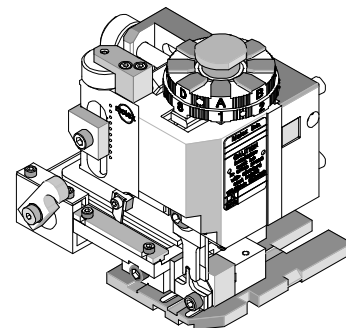




Mini-Mac Applicator Specification Sheet Part No. 11-18-2109 Eng No. MA60756A



FEATURES

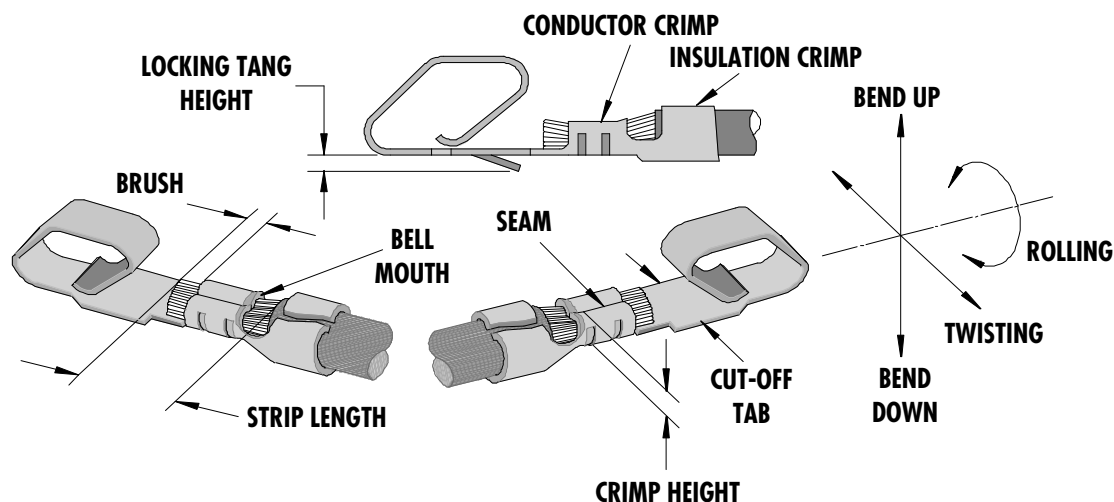
- Quick set-up time; plus the crimp height, track and feed adjustments can be preset in applicator
- Conductor and insulation rings allow quick adjustment for conductor and insulation diameter change
- Applicator designed to industry standard mounting and shut height 135.80mm (5.346")
- Directly adapts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

SCOPE

KK® Cat Ear and Anti Fish Hook Crimp Terminals, 22-30 AWG

Terminal Series No	Terminal Order No.		Wire Size		Insulation Diameter		Strip Length	
			AWG	mm ²	mm	In.	mm	In.
4809	08-50-0030	08-55-0112	22-30	0.35-0.05	1.12-1.57	.044-.062	2.54-3.18	.100-.125
	08-50-0031	08-56-0120						
	08-50-0033	08-56-0158						
	08-50-0135	40-01-0829						
	08-55-0110	97-00-0450						
8088	08-52-0103	40-07-0812	22-30	0.35-0.05	1.12-1.57	.044-.062	2.54-3.18	.100-.125
	08-52-0105	97-00-0225						
	08-52-0107	97-00-0227						
	08-65-0105							

DEFINITION OF TERMS



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

CRIMP SPECIFICATIONS

Terminal Series No.	Locking Tang Height		Bend up Bend down		Twist Roll		Punch Width (Ref)				Seam
							Conductor		Insulation		
	mm	In	Degree		Degree		mm	In	mm	In	
4809	0.64	.025	3	3	4	8	1.60	.063	1.68	.066	Seam shall not be open and no wire allowed out of the crimping area
8088	0.64	.025	3	3	4	8	1.60	.063	1.68	.066	

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.
4809	22	0.35	0.79-0.84	.031-.033	44.88	10.0
4809	24	0.20	0.74-0.79	.029-.031	35.59	8.0
4809	26	0.12	0.68-0.74	.027-.029	26.69	6.0
4809	28	0.08	0.66-0.71	.026-.028	17.79	4.0
4809	30	0.05	0.63-0.66	.026-.027	13.34	3.0
8088	22	0.35	0.79-0.84	.031-.033	44.88	10.0
8088	24	0.20	0.74-0.79	.029-.031	35.59	8.0
8088	26	0.12	0.68-0.74	.027-.029	26.69	6.0
8088	28	0.08	0.66-0.71	.026-.028	17.79	4.0
8088	30	0.05	0.63-0.66	.026-.027	13.34	3.0

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

PARTS LIST

Mini-Mac Applicator MA60756A (11-18-2109)				
Item	Order No	Engineering No.	Description	Quantity
Perishable Tooling				
	11-18-3103	K60756A	Tool Kit (All "Y" Items)	REF
1	11-18-4684	60756A101	Conductor Punch	1 Y
2	11-18-4685	60756A102	Conductor Anvil	1 Y
3	11-18-4686	60756A103	Insulation Punch	1 Y
4	11-18-4687	60756A104	Insulation Anvil	1 Y
5	11-18-4688	60756A105	Cut-Off Insert	1 Y
6	11-18-4689	60756A106	Cut-off Punch	1 Y
Other Components				
7	11-18-4001	60703-3	Cover Plate	1
8	11-18-4003	60703-5	Front Cover	1
9	11-18-4348	60722A108	Tooling Washer	1
10	11-18-4469	60703-20	Retainer Block	1
11	11-18-4678	60756A111	Stripper and Wire Stop	1
12	11-18-4754	60756A118	Terminal Stop and Scrap Shield	1
13	11-40-4566	8350-4	Wire Gathering Spring	1
14	63820-0012	63820-0012	Cover-Drag Frame	1
Frame				
15	63800-0100	63800-0100	Mini-Mac Applicator Frame	1
16	11-17-1174	4151-21	Terminal Drag Plate Frame	1
17	11-18-4251	60712-1	Base Plate	1
18	11-18-5090	60800A169	Drag Springs	2
19	11-18-4253	60703-2	Terminator Track	1
20	69028-0806	69028-0806	Conductor Cam	1
Hardware				
21	N/A	N/A	#6-32 by 3/16" Lg. SHCS	2**
22	N/A	N/A	#6-32 by 1/2" Lg. BHCS	2**
23	N/A	N/A	#10-32 by 1-1/4" Lg. SHCS	1**
24	N/A	N/A	M3 by 8 Lg. BHCS	2**
25	N/A	N/A	M4 by 8 Lg. SHCS	2**
26	N/A	N/A	M4 by 12 Lg. BHCS	2**
27	N/A	N/A	M5 by 8 Lg. SHCS	1**
28	N/A	N/A	M8 by 25 Lg. BHCS	1**
** Available from an industrial supply company such as MSC (1-800-645-7270).				

Assembly Drawing

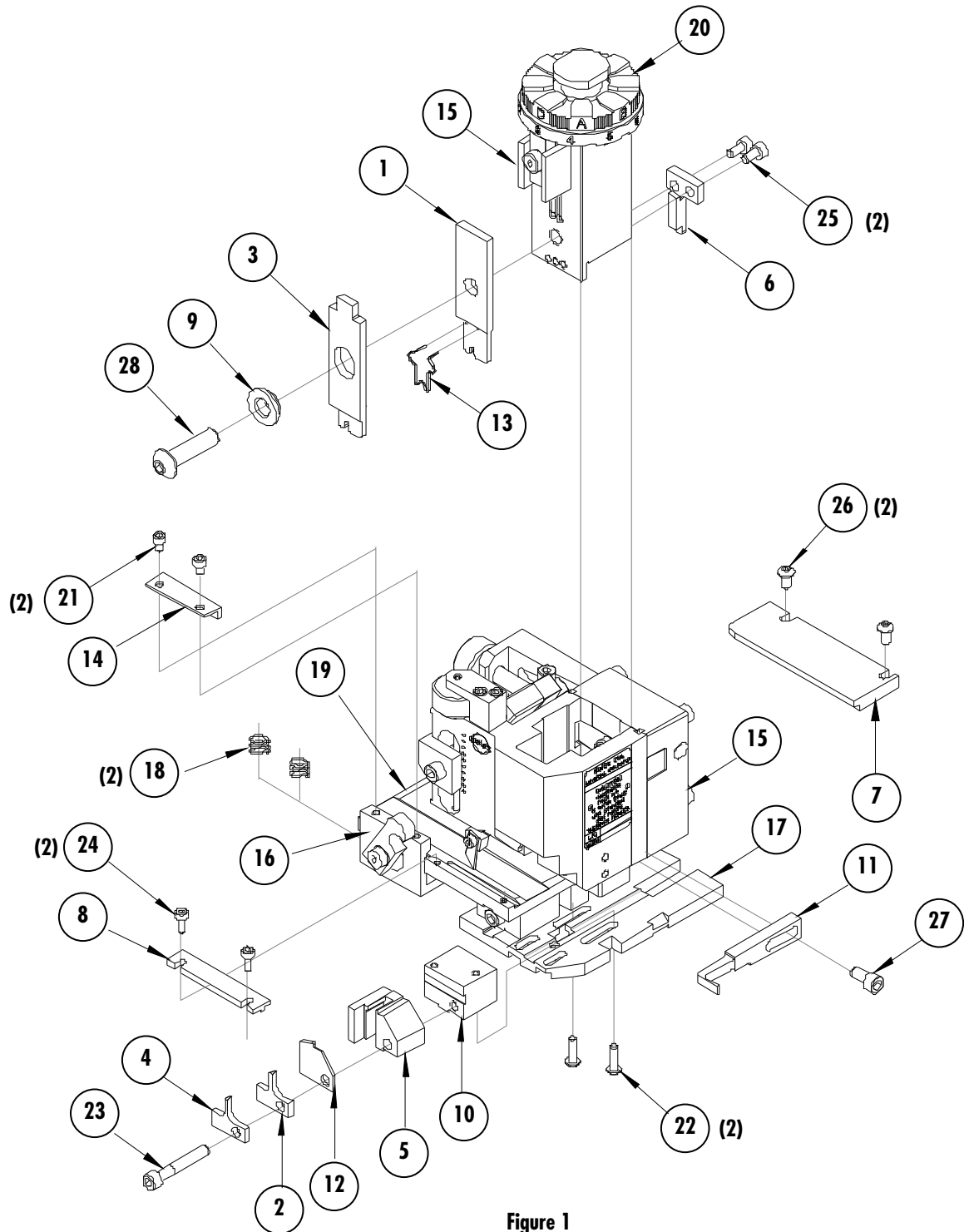


Figure 1

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 housing Part No. 6313, 43275 and 41644-24 use the special doubles applicator 63830-3000.
6. 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.

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