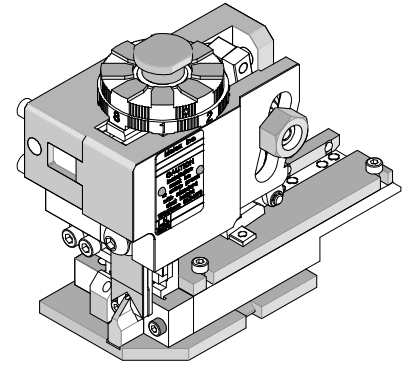




**Mini-Mac Applicator
Specification Sheet
Order No. 11-18-2130
Engineering No. MA60771A**



FEATURES

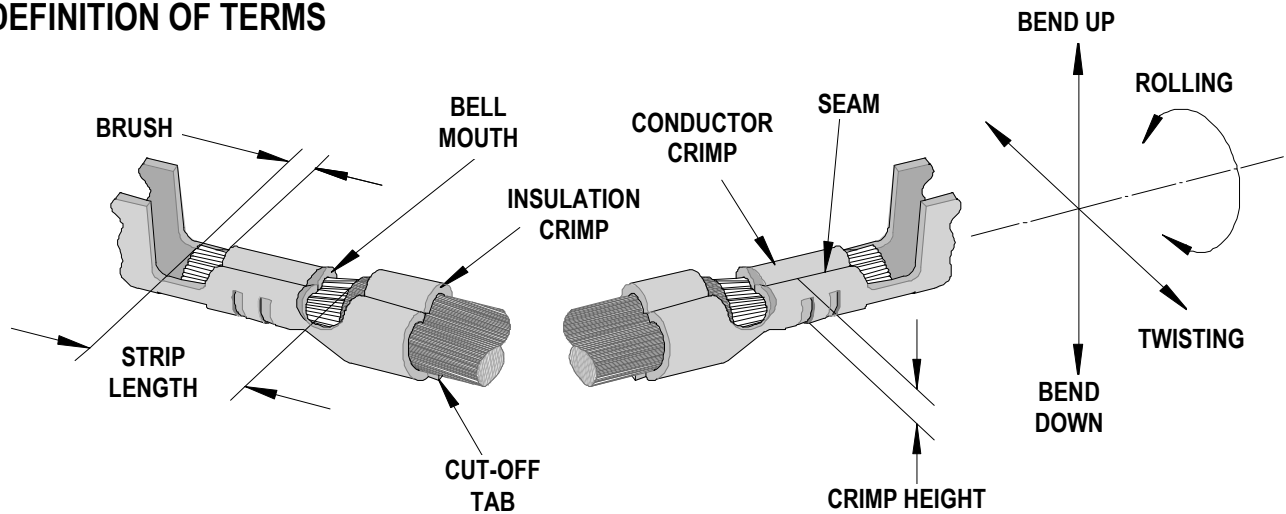
- Quick set-up time; plus the crimp height, track and feed adjustments can be preset in applicator
- Conductor and insulation rings allow quick adjustment for conductor and insulation diameter change
- Applicator designed to industry standard mounting and shut height 135.80mm (5.346")
- Directly adapts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

SCOPE

Products: Right Angle Crimp Terminals Modified for Edge Connectors, 18-24 AWG.

Terminal Series No.	Terminal Order No.		Wire Size		Insulation Diameter		Strip Length	
			AWG	mm ²	mm	In.	mm	In.
1799	08-30-0109	08-34-0105	18-24	0.80-0.20	1.52-3.05	.060-.120	3.17-4.76	.125-.187
	08-34-0109	08-35-0105						

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.	Punch Width (REF)				Seam Seam shall not be open and no wire allowed out of the crimping area
	Conductor		Insulation		
	mm	In	mm	In	
1799	1.92	.076	2.82	.111	

After crimping, the conductor profile should measure the following.

Terminal Series No.	Wire Size		Conductor Crimp Height		Pull Force Minimum	
	AWG	mm ²	mm	In.	N	Lb.
1799	18	0.80	1.07-1.16	.042-.046	111.2	25.0
	20	0.50	1.02-1.12	.040-.044	66.7	15.0
	22	0.35	0.94-1.04	.037-.041	53.4	12.0
	24	0.20	0.89-0.99	.035-.039	35.6	8.0

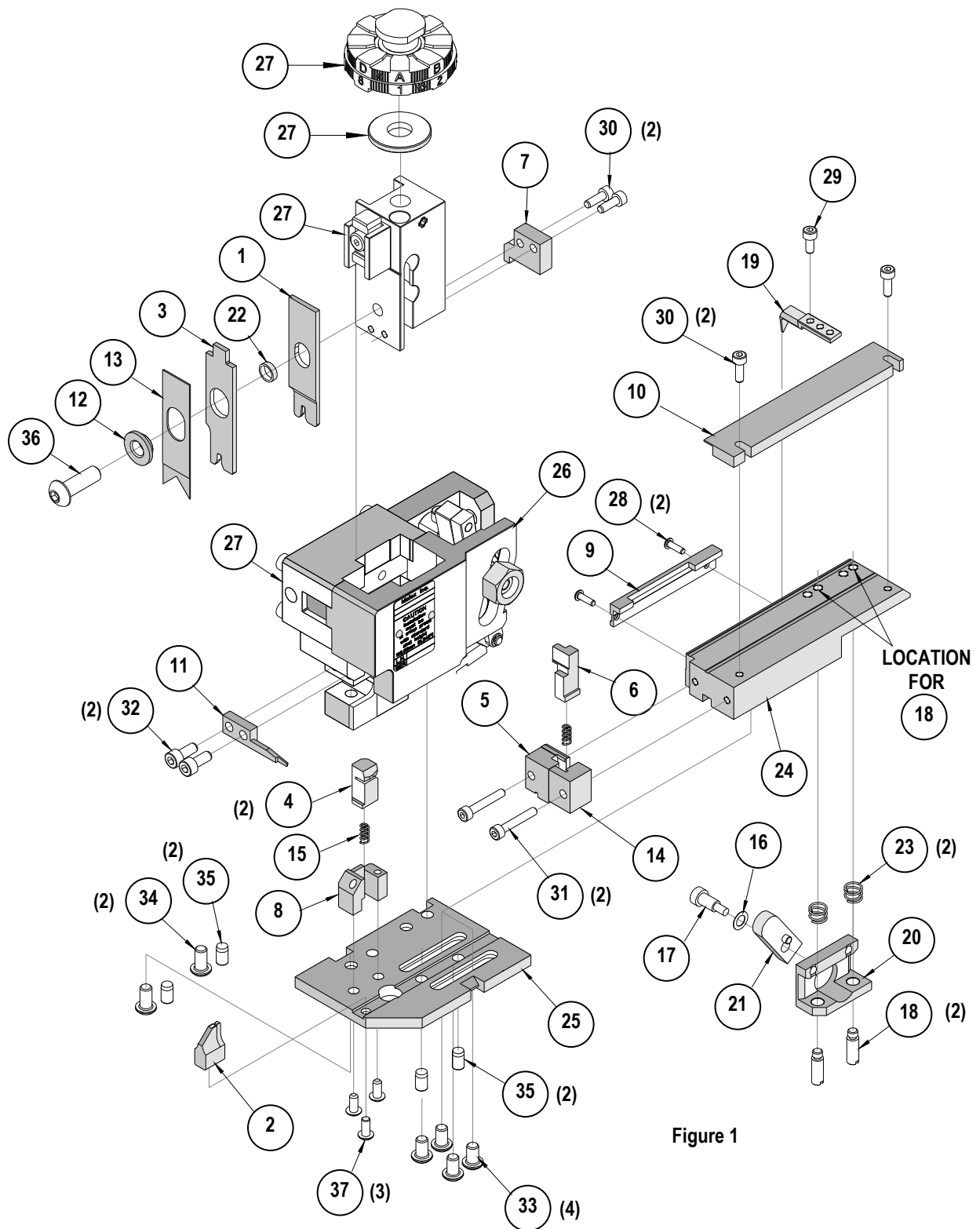
Pull Force should be measured with no influence from the insulation crimp.

The above specifications are guidelines to an optimum crimp.

PARTS LIST

Mini-Mac Applicator MA60771A (11-18-2130)				
Item	Order No	Engineering No.	Description	Quantity
Perishable Tooling				
	11-18-3121	K60771A	Tool Kit (All "Y" Items)	REF
1	11-18-4701	60759A101	Conductor Punch	1 Y
2	11-18-4703	60759A103	Combination Anvil	1 Y
3	11-18-4077	60707-2	Insulation Punch	1 Y
4	11-18-4876	60759A120	Cut-off Plunger	1 Y
5	11-18-4880	60771A106	Cut-Off Die	1 Y
6	11-18-4881	60771A107	Cut-off Plunger	1 Y
7	11-18-4882	60771A108	Cut-off Striker	1 Y
8	11-18-4033	60705A107	Cut-off Plunger Retainer	1 Y
Other Components				
9	11-18-4704	60759A104	Carrier Cover	1
10	11-18-4705	60759A105	Right Cover	1
11	11-18-4711	60759A111	Wire Stop and Ejector	1
12	11-18-4712	60759A112	Insulation Punch Spacer	1
13	11-18-4874	60759A118	Wire Hold Down Blade	1
14	11-18-4883	60771A109	Cut-off Plunger Guide	1
15	11-24-1067	4996-4	Cut-off Plunger Spring	2
16	63600-1561	63600-1561	Shim Washer	1
17	63600-2644	63600-2644	M4 Stripper Bolt	1
18	63800-0116	63800-0116	Guide Pin Drag Frame	2
19	63800-0119	63800-0119	Feed Finger	1
20	63800-0312	63800-0312	Drag Frame	1
21	63801-5862	63801-5862	Drag Cam Lever	1
22	63803-5123	63803-5123	Conductor Bushing	1
23	69028-0660	69028-0660	Drag Spring	2
Frame				
24	11-18-4713	60759A113	Terminal Track	1
25	11-18-4908	60771A130	Base Plate	1
26	11-18-4911	60771A133	Body Upright	1
27	63801-2600	63801-2600	Back Feed Applicator Frame	1
Hardware				
28	N/A	N/A	M3 by 10 Long BHCS	2**
29	N/A	N/A	M4 by 10 Long SHCS	1**
30	N/A	N/A	M4 by 12 Long SHCS	4**
31	N/A	N/A	M4 by 25 Long SHCS	2**
32	N/A	N/A	M5 by 12 Long SHCS	2**
33	N/A	N/A	M6 by 10 Long BHCS	4**
34	N/A	N/A	M6 by 12 Long BHCS	2**
35	N/A	N/A	6mm by 10 Long Dowel Pin	4**
36	N/A	N/A	M8 by 25 Long BHCS	1**
37	N/A	N/A	#8-32 by 3/8 Long BHCS	3**
** Available from an industrial supply company such as MSC (1-800-645-7270).				

Assembly Drawing



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 135.8 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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