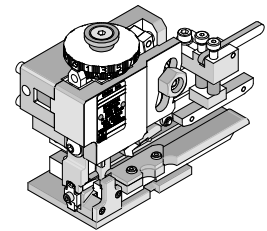




**Mini-Mac Applicator
Rear Feed**

**Application Tooling
Specification Sheet**



Order No. 63802-7500

FEATURES

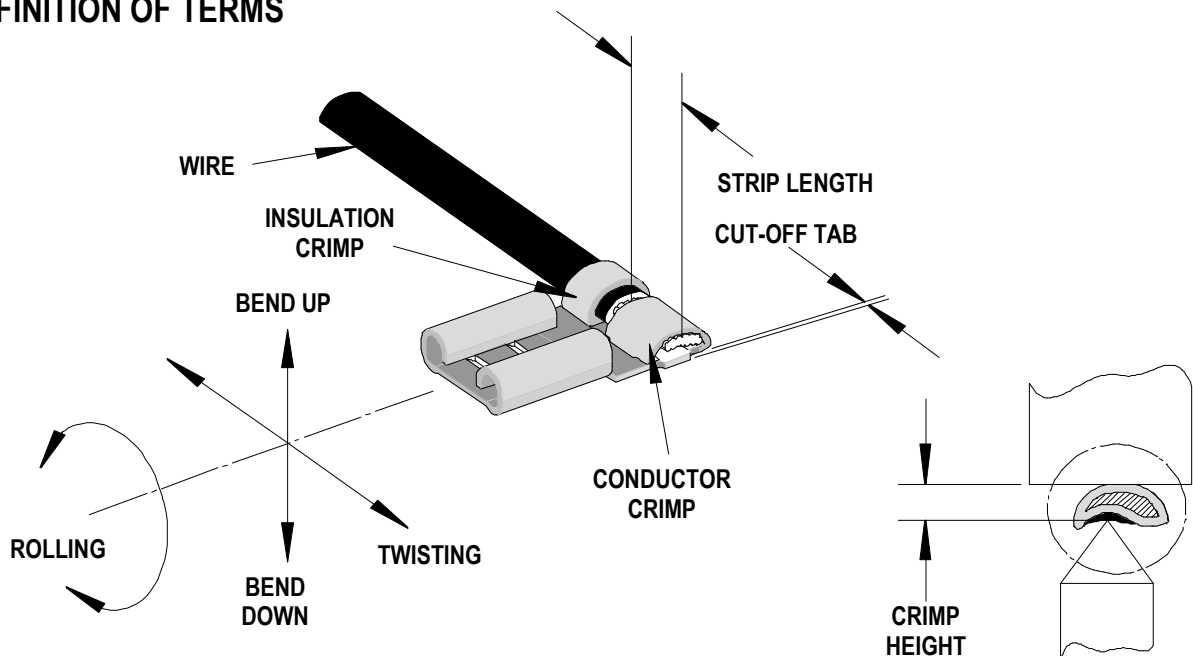
- Quick set-up time; plus the crimp height, track and feed adjustments can be preset in applicator
- Conductor and insulation rings allow quick adjustment for conductor and insulation diameter change
- Applicator designed to industry standard mounting and shut height 135.80mm (5.346")
- Directly adapts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

SCOPE

Products: Flag Krimptite™ Quick Disconnect Female Terminals, 18-22 AWG.

| Terminal Order No. | Terminal Eng. No. | Wire Size | | Tab Size | | Insulation Diameter | | Strip Length | |
|--------------------|-------------------|-----------|-----------------|--------------|--------------|---------------------|-----|--------------|------|
| | | AWG | mm ² | 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



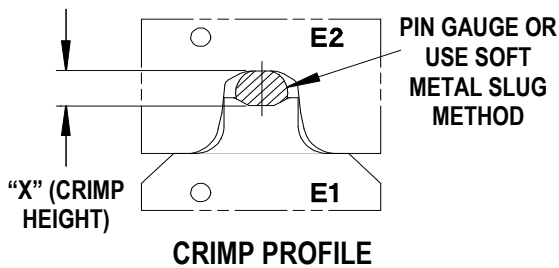
The above terminal drawing is a generic terminal representation. It is not an image of a terminal listed in the scope.

CRIMP SPECIFICATIONS

| Terminal Order No. | Terminal Eng. No. | Wire Size | | Conductor Crimp Height | | | | | | Pull Force Minimum | |
|--------------------|-------------------|-----------|-----------------|------------------------|------|------|------|-------|------|--------------------|------|
| | | | | Mean | | Go | | No Go | | | |
| | | AWG | mm ² | 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.



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.

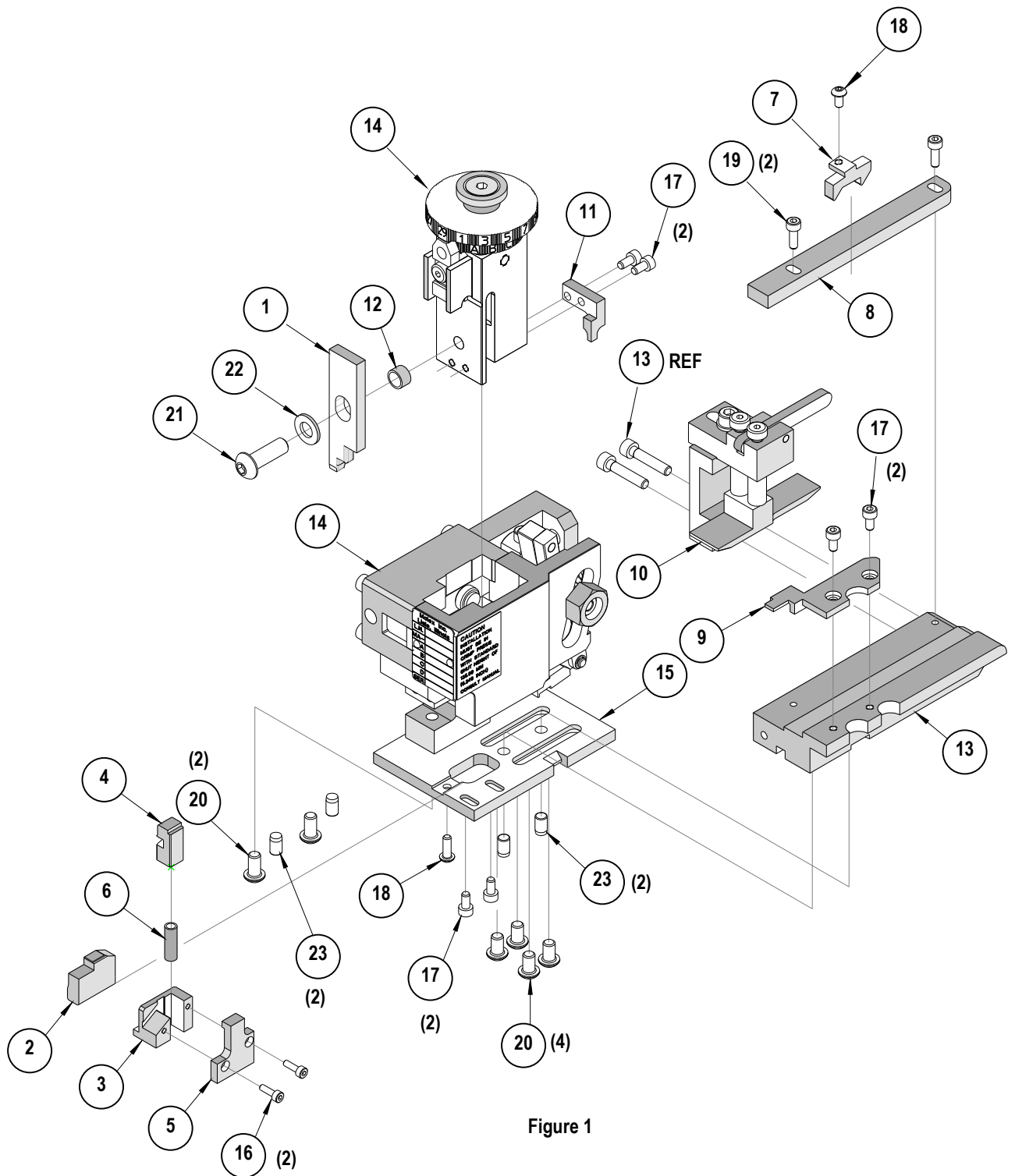
Molex does not sell gauge pins contact your local industrial supplier.

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



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>