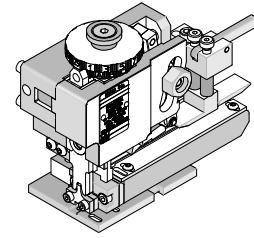


**Rear Feed  
Mini-Mac  
Applicator**



**Application Tooling  
Specification Sheet**



**Order No. 63806-3800**

**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

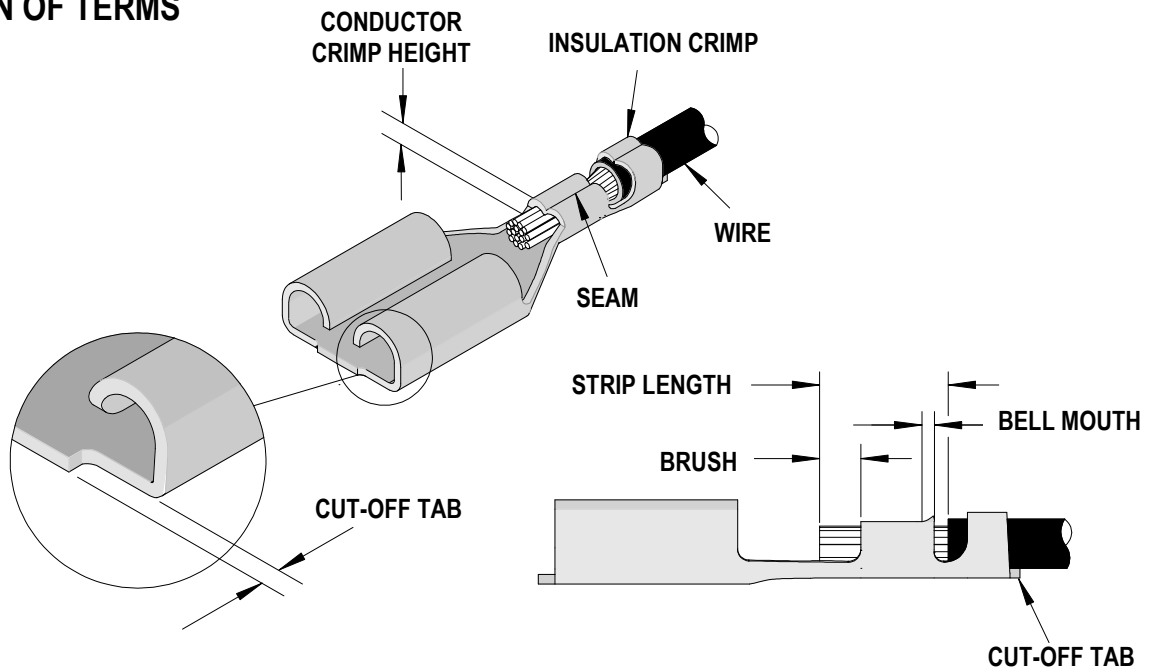
**SCOPE**

Products: .250 Slip-on Receptacle Terminals, for 10-14 AWG UL1015 wires.

Terminal Series No.	Terminal Order No.	Wire Size		Insulation Diameter				Strip Length	
				IPC/WHMA-A620 (1)		Terminal (2)			
		AWG	mm <sup>2</sup>	mm	In.	mm	In.	mm	In.
35725	35725-2700 35725-2710 35725-2740	10-14	5.26-2.08	3.80-4.80	.150-.189	3.80-5.30	.150-.209	5.20-5.80	.205-.228

- (1) To achieve optimum IPC-A620 Class 2 insulation crimps, use this insulation OD.  
 (2) Overall insulation OD specification for terminal.  
 (3) Terminal will accommodate the UL1015 wires.

**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				Seam Seam shall not be open and no wire allowed out of the crimping area
	Degree Max.		Degree Max.		Conductor		Insulation		
	mm	In.	mm	In.	mm	In.	mm	In.	
35725	3	3	3	5	3.70	.146	4.90	.193	

After crimping, the crimp profile should measure the following.

Terminal Series No.	Wire Size		Conductor				Insulation				Pull Force Minimum	
			Crimp Height		Crimp Width		Crimp Height (Ref)		Crimp Width			
	AWG	mm <sup>2</sup>	mm	In.	mm	In.	mm	In.	mm	In.	N	Lb.
35725	10	5.26	2.60-2.70	.102-.106	3.70-3.90	.146-.154	5.20	.205	4.85-5.15	.191-.203	342.9	77.2
	12	3.31	2.15-2.25	.085-.089	3.70-3.90	.146-.154	4.90	.193	4.85-5.15	.191-.203	290.0	65.3
	14	2.08	1.90-2.00	.075-.079	3.70-3.90	.146-.154	4.60	.181	4.85-5.15	.191-.203	190.1	42.8

**\* 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**

<b>Mini-Mac Applicator 63806-3800</b>				
<b>Item</b>	<b>Order No</b>	<b>Engineering No.</b>	<b>Description</b>	<b>Quantity</b>
<b>Perishable Tooling</b>				
	63806-3870	63806-3870	Tool Kit (All "Y" Items)	REF
1	63806-3801	63806-3801	Conductor Punch	1 Y
2	63455-0113	63455-0113	Conductor Anvil	1 Y
3	63806-3803	63806-3803	Insulation Punch	1 Y
4	63456-0095	63456-0095	Insulation Anvil	1 Y
5	63485-1122	63485-1122	Cut-off Punch	1 Y
6	63485-1322	63485-1322	Cut-off Die-Front	1 Y
7	63485-1401	63485-1401	Cut-off Die-Rear	1 Y
<b>Other Components</b>				
8	11-18-5130	60817A112	Guide Rail-R.H.	1
9	11-18-5467	60817A121	Guide Rail-L.H.	1
10	63485-1808	63485-1808	Hold-down Blade	1
11	63485-7603	63485-7603	Feed Finger	1
12	63700-4411	63700-4411	Compression Spring	1
13	63801-4133	63801-4133	Tooling Washer	1
14	63801-5013	63801-5013	Wire Stop	1
15	63801-7151	63801-7151	Terminal Track	1
16	63803-5139	63803-5139	Conductor Bushing	1
<b>Frame</b>				
17	63801-2600	63801-2600	Rear Feed Applicator Frame Head	1
18	63801-2603	63801-2603	Base	1
19	63801-7160	63801-7160	Terminal Drag Assembly	1
<b>Hardware</b>				
20	N/A	N/A	M4 by 8 Long BHCS	5**
21	N/A	N/A	M4 by 10 Long SHCS	2**
22	N/A	N/A	M4 by 45 Long SHCS	2**
23	N/A	N/A	M5 by 12 Long BHCS	2**
24	N/A	N/A	M6 by 10 Long BHCS	4**
25	N/A	N/A	M6 by 12 Long BHCS	2**
26	N/A	N/A	M8 by 20 Long BHCS	1**
27	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

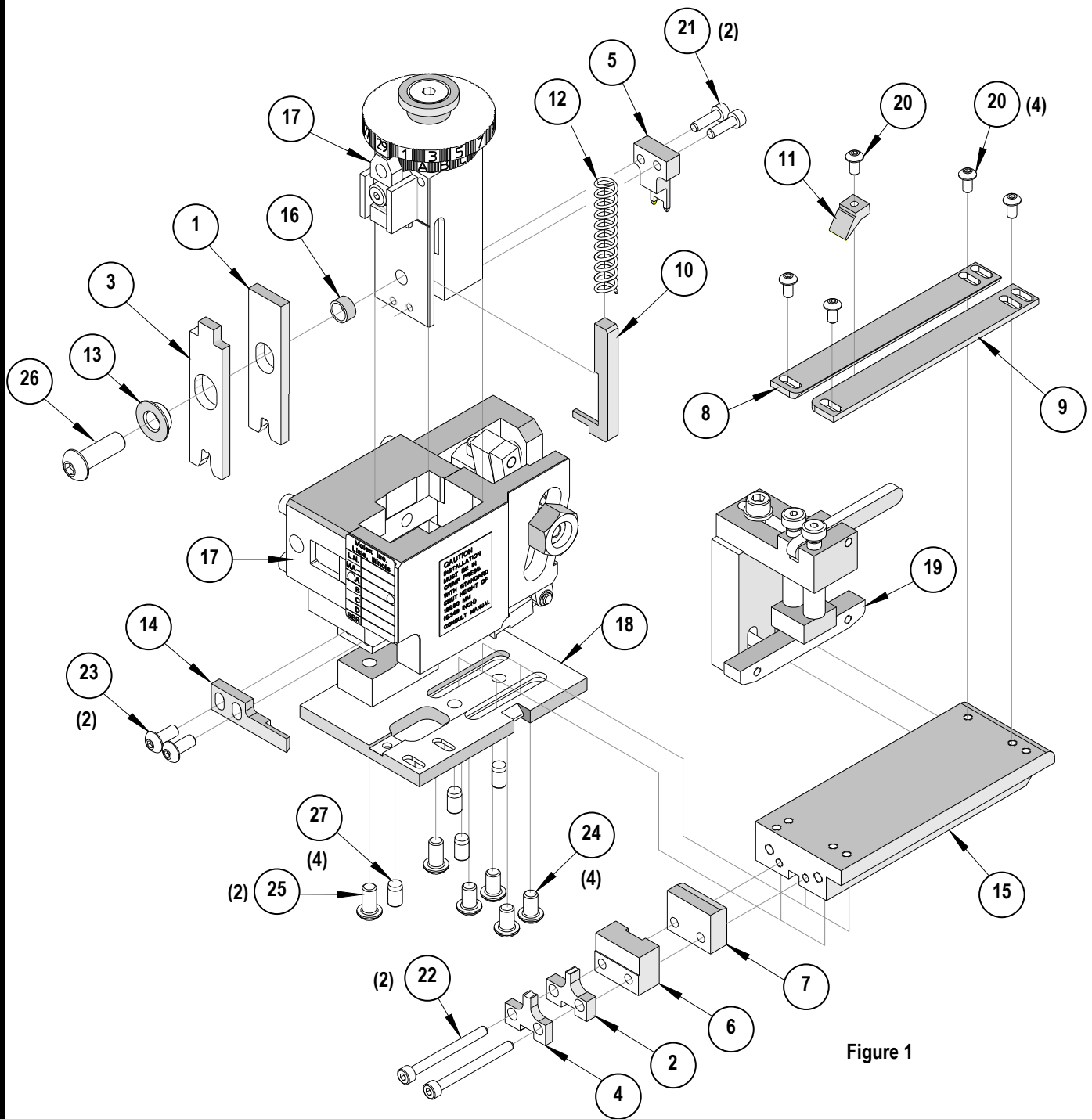


Figure 1

## 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 135.8 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.

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