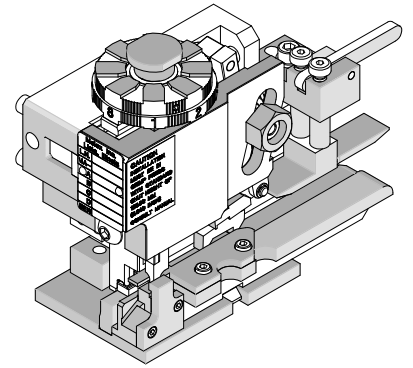




# Rear Feed Mini-Mac Applicator Mechanical Feed Specification Sheet Order No. 63802-7700



## FEATURES

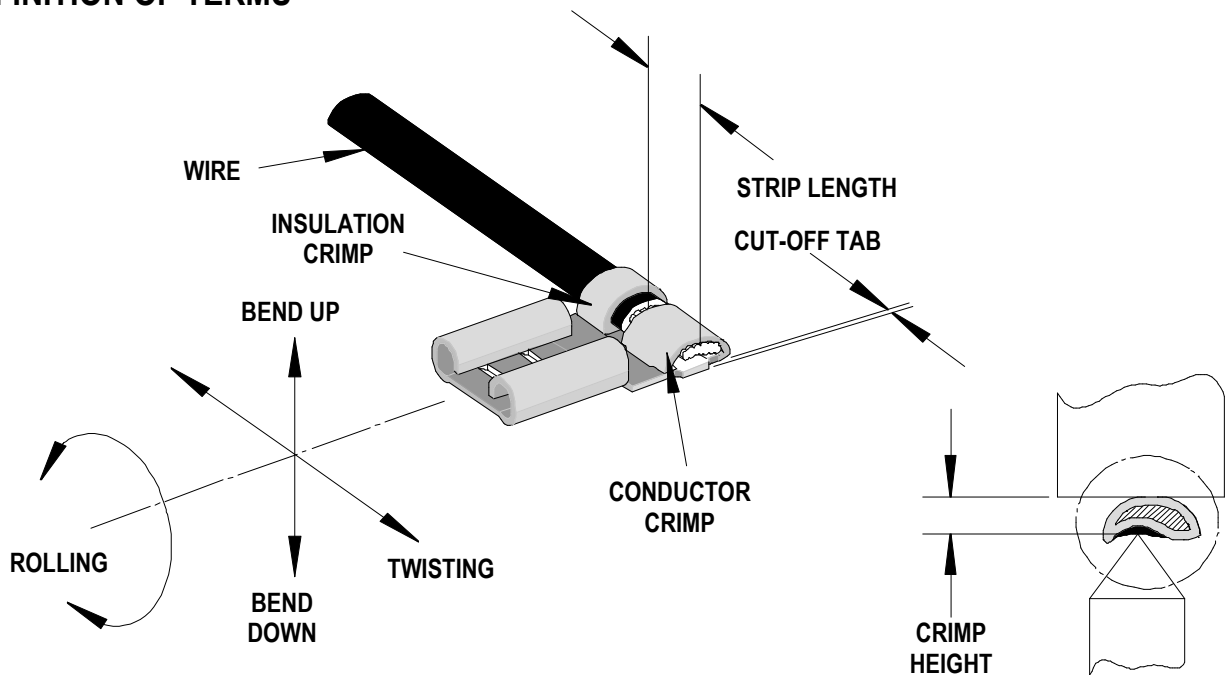
- Quick set-up time; plus the crimp height, track and feed adjustments can be preset in applicator
- Conductor and insulation rings allow quick adjustment for conductor and insulation diameter change
- Applicator designed to industry standard mounting and shut height 135.80mm (5.346")
- Directly adapts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

## SCOPE

Products: VibraKrimp™ Quick Disconnect Female Flag Terminals, 14-16 AWG.

| Terminal Order No. | Terminal Eng. No. | Wire Size |                 | Tab Size     |              | Insulation Diameter |      | Strip Length |      |
|--------------------|-------------------|-----------|-----------------|--------------|--------------|---------------------|------|--------------|------|
|                    |                   | AWG       | mm <sup>2</sup> | mm           | In.          | mm                  | In.  | mm           | In.  |
| 19009-0016         | BBZ-4169          | 14-16     | 2.00-1.30       | 6.35 by 0.81 | .250 by .032 | 3.70                | .145 | 5.94         | .234 |
| 19009-0017         | BBZ-4171          | 14-16     | 2.00-1.30       | 4.75 by 0.51 | .187 by .020 | 3.70                | .145 | 5.94         | .234 |
| 19009-0018         | BBZ-4171-032      | 14-16     | 2.00-1.30       | 4.75 by 0.81 | .187 by .032 | 3.70                | .145 | 5.94         | .234 |

## 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 <sup>2</sup> | mm                     | In.  | mm   | In.  | mm    | In.  | N                  | Lb.  |
| 19009-0016  | BBZ-4169          | 14        | 2.00            | 1.62                   | .064 | 1.55 | .061 | 1.68  | .066 | 222.6              | 50.0 |
|   |                   | 16        | 1.30            | 1.62                   | .064 | 1.55 | .061 | 1.68  | .066 | 133.5              | 30.0 |
| 19009-0017  | BBZ-4171          | 14        | 2.00            | 1.62                   | .064 | 1.55 | .061 | 1.68  | .066 | 222.6              | 50.0 |
|   |                   | 16        | 1.30            | 1.62                   | .064 | 1.55 | .061 | 1.68  | .066 | 133.5              | 30.0 |
| 19009-0018  | BBZ-4171-032      | 14        | 2.00            | 1.62                   | .064 | 1.55 | .061 | 1.68  | .066 | 222.6              | 50.0 |
|   |                   | 16        | 1.30            | 1.62                   | .064 | 1.55 | .061 | 1.68  | .066 | 133.5              | 30.0 |
| <b>Seam</b><br>Seam shall not be open and no wire allowed out of the crimping |                   |           |                 |                        |      |      |      |       |      |                    |      |

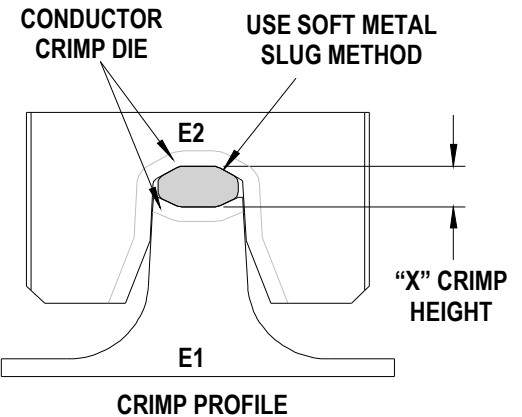
Pull Force should be measured with no influence from the insulation crimp. The above specifications are guidelines to an optimum crimp.

### Tool Calibration

To recalibrate this applicator, make sure the power is completely shut off on the press.

1. The Applicator must be properly installed in the press.
2. Crimping dies must be properly installed in the Applicator.
3. The recommended method of measuring the crimp height of the conductor dies is the soft metal slug method. See Figure 1.
4. The slug must have a diameter 0.51mm (.020") larger than the "X" No Go dimension before crimping.
5. Place the soft metal slug (solder) into the nest of the bottom die and crimp (by hand cycling the press) similar to a terminal. The crimp height can be measured with a blade type micrometer or dial caliper, (Dimension "X").
6. Adjustment of the crimp height can be accomplished by indexing the conductor cam. The letter "A" gives the loosest position and "K" gives the tightest position. A total adjustment of 0.50mm (.020") can be achieved by adjusting the conductor cam.

Note: If the crimp height is too tight on the setting "A", check the shut height of the press. See the Industrial Mini-Mac Applicator Manual Section 2.1 for adjustments.



Use 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.

Figure 1

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

**PARTS LIST**

| <b>Rear Feed Applicator 63802-7700</b>                                       |                 |                        |  |                 |
|--|-----------------|------------------------|--|-----------------|
| <b>Item</b>  | <b>Order No</b> | <b>Engineering No.</b> | <b>Description</b>                     | <b>Quantity</b> |
| <b>Perishable Tooling</b>  |                 |                        |  |                 |
|  | 63802-7770      | 63802-7770             | Tool Kit (All "Y" Items)               | REF             |
| 1  | 63801-5518      | 63801-5518             | Conductor Punch ( E2 Die)              | 1 Y             |
| 2  | 63801-5617      | 63801-5617             | Insulation Punch (I2 Die)              | 1 Y             |
| 3  | 19031-0311      | 19031-0311             | Conductor/Insulation Anvil (E1/I1 Die) | 1 Y             |
| 4  | 19229-0120      | 19229-0120             | Cutter Housing                         | 1 Y             |
| 5  | 19229-0121      | 19229-0121             | Cutter Plunger                         | 1 Y             |
| <b>Other Components</b>  |                 |                        |  |                 |
| 6  | 19229-0095      | 19229-0095             | Cutter Back Plate                      | 1               |
| 7  | 19230-0038      | 19230-0038             | Feed Finger                            | 1               |
| 8  | 19230-0101      | 19230-0101             | Guide Rail                             | 1               |
| 9  | 19230-0106      | 19230-0106             | Guide and Hold Down                    | 1               |
| 10   | 19250-0038      | 19250-0038             | Compression Spring                     | 1               |
| 11   | 63801-2695      | 63801-2695             | Terminal Drag Assembly                 | 1               |
| 12   | 63801-7701      | 63801-7701             | Cutter Striker                         | 1               |
| 13   | 63802-7401      | 63802-7401             | Shoulder Bushing                       | 1               |
| 14   | 63803-5109      | 63803-5109             | Conductor Bushing                      | 1               |
| <b>Frame</b>   |                 |                        |  |                 |
| 15   | 19230-0084      | 19230-0084             | Slide (Terminal Track)                 | 1               |
| 16   | 63801-2600      | 63801-2600             | Rear Feed Frame                        | 1               |
| 17   | 63801-2603      | 63801-2603             | Base                                   | 1               |
| <b>Hardware</b>  |                 |                        |  |                 |
| 18   | N/A             | N/A                    | M3 by 10 Long SHCS                     | 2**             |
| 19   | N/A             | N/A                    | M4 by 8 Long SHCS                      | 6**             |
| 20   | N/A             | N/A                    | M4 by 10 Long BHCS                     | 2**             |
| 21   | N/A             | N/A                    | M4 by 12 Long SHCS                     | 2**             |
| 22   | N/A             | N/A                    | M6 by 10 Long BHCS                     | 6**             |
| 23   | N/A             | N/A                    | M8 by 25 Long BHCS                     | 1**             |
| 24   | 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

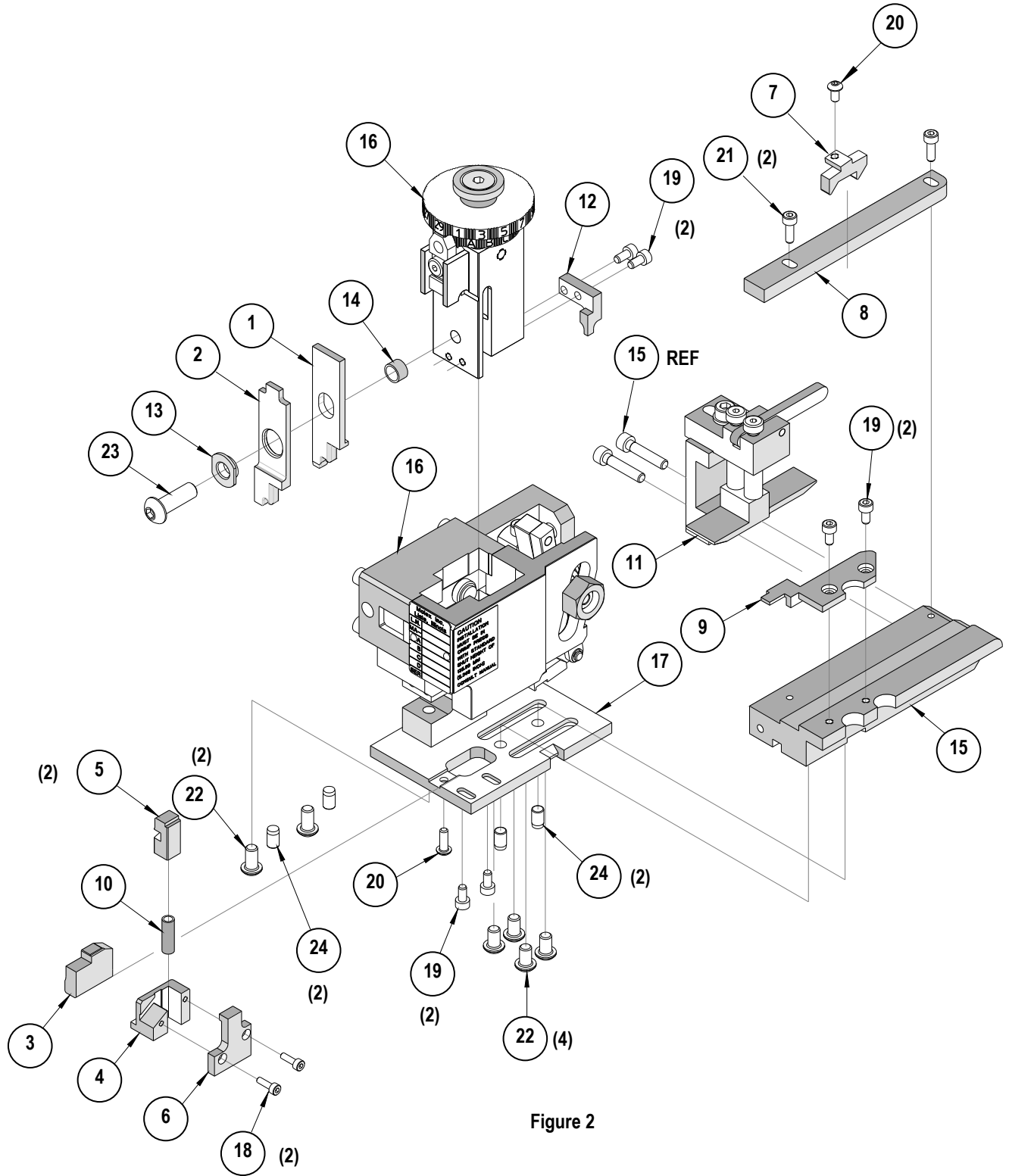


Figure 2

## 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.**

**Americas Headquarters**  
Lisle, Illinois 60532 U.S.A.  
1-800-78MOLEX  
amerinfo@molex.com

**Far East North Headquarters**  
Yamato, Kanagawa, Japan  
81-462-65-2324  
feninfo@molex.com

**Far East South Headquarters**  
Jurong, Singapore  
65-6-268-6868  
fesinfo@molex.com

**European Headquarters**  
Munich, Germany  
49-89-413092-0  
eurinfo@molex.com

**Corporate Headquarters**  
2222 Wellington Ct.  
Lisle, IL 60532 U.S.A.  
630-969-4550  
Fax: 630-969-1352

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



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#### Как с нами связаться

**Телефон:** 8 (812) 309 58 32 (многоканальный)

**Факс:** 8 (812) 320-02-42

**Электронная почта:** [org@eplast1.ru](mailto:org@eplast1.ru)

**Адрес:** 198099, г. Санкт-Петербург, ул. Калинина, дом 2, корпус 4, литера А.