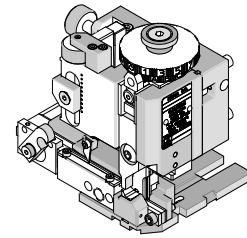


**Mini-Mac
Applicator**



**Application Tooling
Specification Sheet**



Order No. 63893-4200

FEATURES

- Directly adapts to most automatic wire processing machines
- Applicator designed to industry standard mounting and shut height 135.80mm (5.346")
- Quick set-up time; plus the crimp height, track and feed adjustments can be set without removing the applicator from the press
- Fine adjustment allows users to achieve target with little effort by adjusting in increments of .015mm (.0006") for barrel crimp height and .063mm (.0025") for insulation height. See notes on Page 2.
- Independent adjustment rings allow users to quickly adjust the barrel or insulation crimp height without affecting each other.

SCOPE

Products: Board-In Crimp Terminal Male, 16-18 AWG.

Terminal Series No.	Terminal Order No.	Wire Size		Insulation Diameter Maximum		Strip Length	
		AWG	mm ²	mm	In.	mm	In.
4706	02-09-2105	16-18	1.30-0.80	3.05	.120	5.97-6.35	.235-.250

DEFINITION OF TERMS

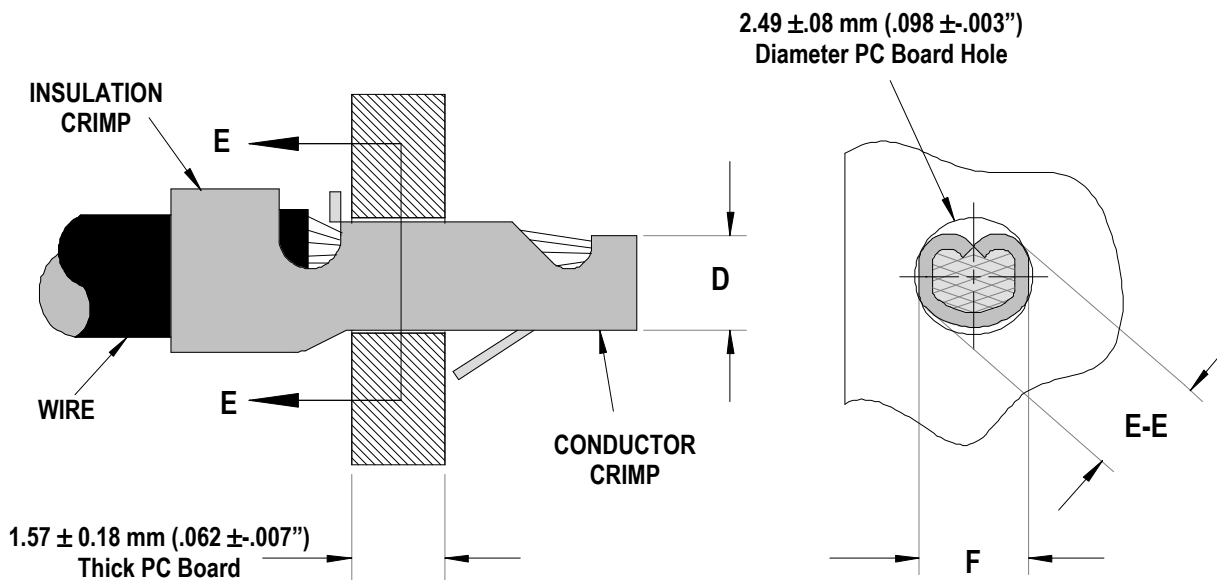


Figure 1

Section E-E

CRIMP SPECIFICATIONS

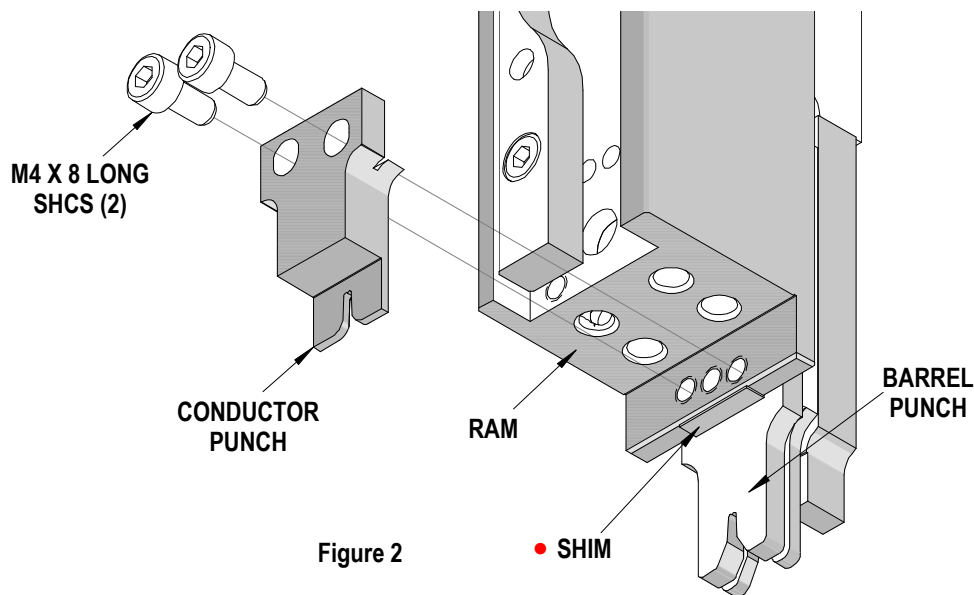
After crimping, the conductor profiles should measure the following (See Figure 1).

Terminal Series No.	Wire Size		Dimensions (Figure 1)						Pull Force Minimum	
			D (Conductor)		E-E (Barrel)		F (Ref.)			
	AWG	mm ²	mm	In.	mm	In.	mm	In.	N	Lb.
4706	16	1.30	1.22-1.27	.048-.050	2.29-2.39	.090-.094	1.93-1.98	.076-.078	13.34	3.0
	18	0.80	1.22-1.27	.048-.050	2.16-2.26	.085-.089	1.93-1.98	.076-.078	13.34	3.0

*The crimp on this terminal is not an electrical crimp; the final soldering operation is the electrical connection. This minimum force is what should be expected when pulling the terminal with both insulation and conductor crimped.

Notes:

1. The Conductor crimp (D dimension on Figure 1) should be set at the maximum height to contain all wire strands, meet minimum pull, and fit into the PCB Hole. The insulation and barrel crimps are adjustable, by the cams (rings) on top of the Mini-Mac ram. The conductor crimp height is not adjustable. Shimming may be required of the conductor punch to optimize this for different wire types.
2. To achieve the reference "D" dimension listed in the chart above, a shim is required. These shims are not supplied with the applicator. The shim should be located between the ram and the conductor punch. See Figure 2.



• Shim location for Conductor Punch.