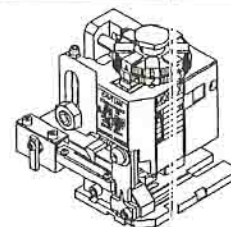




APPLICATION TOOLING MINI-MAC APPLICATOR SPECIFICATION SHEET



TERMINAL SPECIFICATION

TERMINAL SERIES	WIRE SIZE		INSULATION DIAMETER		STRIP LENGTH	
	MIN	MAX	ENGLISH	(METRIC)	ENGLISH	(METRIC)
43375-1001	DBL 18		.110 X 2	(2.8 X 2)	.156 - .218	(3.96 - 5.54)
43374-1001	DBL 18		.110 X 2	(2.8 X 2)	.156 - .218	(3.96 - 5.54)
			-	(-)	-	(-)
			-	(-)	-	(-)
			-	(-)	-	(-)
			-	(-)	-	(-)
			-	(-)	-	(-)
			-	(-)	-	(-)

TOOLING INFORMATION

ITEM	ORDER NO.	SIZE	ENG. NO.	DESCRIPTION	REQ'D
4	634430002	B	634430002	FRONT CUT-OFF PLUNGER.	1
6	1-18-5418	B	60843A106	CONDUCTOR PUNCH.	1
7	634452562	B	634452562	CONDUCTOR ANVIL.	1
8	1-18-5414	B	60842A108	INSULATION PUNCH.	1
9	634453947	B	634453947	INSULATION ANVIL.	1
10	631430012	B	634430012	CUT-OFF PLUNGER RETAINER.	1
...	638303070		638303070	TOOL KIT (ALL THE ABOVE ITEMS)	1

CRIMP SPECIFICATION

WIRE		CRIMP HEIGHT		CRIMP WIDTH (REF.)		PULL FORCE MINIMUM	
SET	AWG	ENGLISH	(METRIC)	ENGLISH	(METRIC)	LBS.	(N)
	DBL 18	.058 - .062	(1.47 - 1.57)	.098	(2.50)	20	(88.9)
		-	(-)		()		()
		-	(-)		()		()
		-	(-)		()		()
		-	(-)		()		()

NOTES:

1. WE RECOMMEND AN EXTRA SET OF PERISHABLE TOOLING BE MAINTAINED IN YOUR FACTORY.
2. VERIFY TOOLING ALIGNMENT BY MANUALLY CYCLING THE PRESS AND DIE BEFORE CRIMPING UNDERPOWER. CHECK THAT ALL SCREWS ARE TIGHT.
3. SLUGS, TERMINALS, DIRT AND OIL SHOULD BE KEPT CLEAR OF WORK AREA.
4. TO USE THE ABOVE SETTINGS, YOUR PRESS SHOULD HAVE A SHUT HEIGHT OF 135.8 MM. CRIMP HEIGHT MAY STILL VARY DEPENDING ON STYLE AND WIRE TYPE. SHIMMING COULD BE NECESSARY TO ACHIEVE CRIMP HEIGHTS.
5. TO PREVENT INJURY - NEVER OPERATE THIS TOOL WITHOUT THE GUARDING SUPPLIED WITH THE PRESS IN PLACE.



DIMENSIONS SHOWN (METRIC) INCH

UNLESS OTHERWISE SPECIFIED
TOLERANCES: ANGULAR ± 1/2°

	INCH	METRIC
3 PLACE	±	---
2 PLACE	±	±
1 PLACE	---	±

DRAFT WHERE APPLICABLE MUST
REMAIN WITHIN DIMENSIONS

DRWG. BY JMP
APP'D. BY GOC
SCALE NA

▽ =

▽ =

REVISE ONLY ON CAD SYSTEM

TITLE

SPECIAL DOUBLES APPLICATOR
FOR HOUSING PART NOS.
6313, 43275 & 41644-24

Molex

MOLEX INCORPORATED
LISLE, ILL. 60532 U.S.A.

SHEET NO.

1 OF 4

DATE

03/15/99

PART NO.

638303000

DRWG. NO.

638303000

FILE NAME
6383030
S80

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DIV.

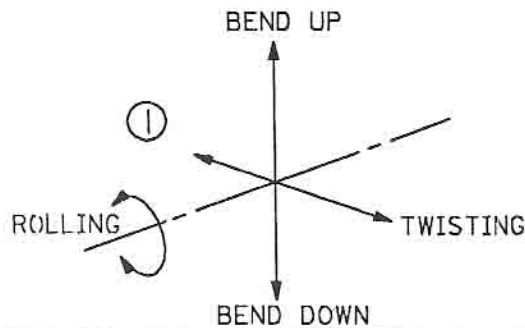
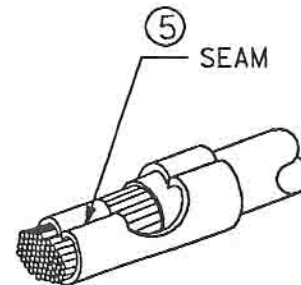
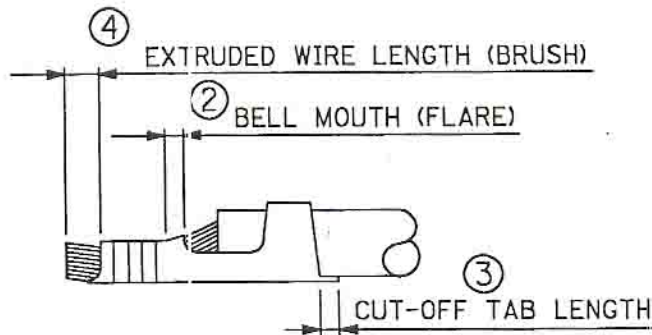
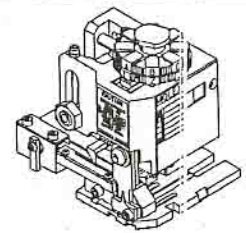
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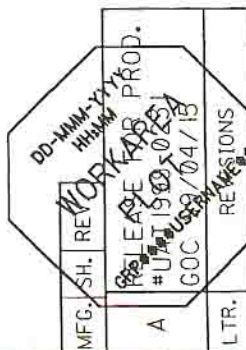


APPLICATION TOOLING MINI-MAC APPLICATOR SPECIFICATION SHEET



CRIMP SPECIFICATION

NO. OF FIG.	ITEM	REQUIREMENT
1	BEND UP	3°
	BEND DOWN	3°
	TWISTING	4°
	ROLLING	8°
2	BELL MOUTH (FLARE)	.20 - .50mm
3	CUT-OFF TAB LENGTH	.012" MAX. (.30mm MAX.)
4	EXTRUDED WIRE LENGTH (BRUSH)	.030" MAX. (.76mm MAX.)
5	SEAM	SEAM SHALL NOT BE OPENED AND NO WIRE ALLOWED OUT OF THE CRIMPING AREA.



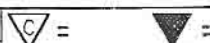
DIMENSIONS SHOWN (METRIC) INCH

UNLESS OTHERWISE SPECIFIED
TOLERANCES: ANGULAR $\pm 1/2^\circ$

	INCH	METRIC
3 PLACE	$\pm$	---
2 PLACE	$\pm$	$\pm$
1 PLACE	---	$\pm$

DRAFT WHERE APPLICABLE MUST
REMAIN WITHIN DIMENSIONS

DRWG. BY JMP CHK'D. BY GOC
APP'D. BY SCALE NA



REVISE ONLY ON CAD SYSTEM

TITLE
SPECIAL DOUBLES APPLICATOR
FOR HOUSING PART NOS.
6313, 43275 & 41644-24

MOLEX INCORPORATED
LISLE, ILL. 60532 U.S.A.

SHEET NO. 2 OF 4 DATE 03/15/99

PART NO. 638303000

DRWG. NO. 638303000

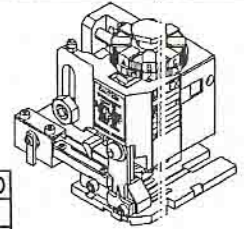
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DIV. AT SIZE A



MINI-MAC APPLICATOR SPECIFICATION SHEET



APPLICATOR ASSEMBLY - PARTS LIST

ITEM	ORDER NO.	SIZE	ENG. NO.	DESCRIPTION	REQ'D
11	638303002	B	638303002	ANVIL MOUNT	1
14	638303001	B	638303001	PLUNGER STRIKER	1
15	638303005	B	638303005	TOOLING WASHER	1
16	11-24-1067	A	4996-4	CUT-OFF PLUNGER SPRING	1
17	11-18-5348	B	60811A126	REAR COVER	1
18					
21	11-18-5016	B	60812A105	CONDUCTOR ADJUSTING CAM	1
22	638220106	B	638220106	TERMINAL STRIPPER	1
23	11-18-5442	B	60843A123	FRONT COVER	1
40	11-18-5007	A	60800D114	HOLD DOWN PLUNGER SPRING	1
41	638303003	B	638303003	HOLD DOWN BLOCK	1
42	11-18-5411	B	60832A142	SPRING RETAINER	1
43	11-18-5412	B	60832A143	HOLD DOWN PLUNGER	1
12	634430021	B	634430021	MOUNTING KEY	1
---	11-18-4795	A	60700-66	WAVE WASHER	1
---	11-18-4238	A	60700-1	FEED CAM (SHORT)	1

TOOLING INFORMATION

ITEM	ORDER NO.	SIZE	ENG. NO.	DESCRIPTION	REQ'D
4	634430002	B	634430002	FRONT CUT-OFF PLUNGER	1
6	11-18-5418	B	60843A106	CONDUCTOR PUNCH	1
7	634452562	B	634452562	CONDUCTOR ANVIL	1
8	11-18-5414	B	60842A108	INSULATION PUNCH	1
9	634453947	B	634453947	INSULATION ANVIL	1
10	634430012	B	634430012	CUT-OFF PLUNGER RETAINER	1
---	638303070		638303070	TOOL KIT (ALL THE ABOVE ITEMS)	1

FRAME ASSY

ITEM	ORDER NO.	SIZE	ENG. NO.	DESCRIPTION	REQ'D
	63800-0100	B	63800-0100	FRAME ASSY	1
	11-18-5016	B	60812A105	CONDUCTOR ADJUSTING CAM	1



DIMENSIONS SHOWN (METRIC) INCH

UNLESS OTHERWISE SPECIFIED
TOLERANCES: ANGULAR $\pm 1/2^\circ$

	INCH	METRIC
3 PLACE	$\pm$ ---	---
2 PLACE	$\pm$ ---	± 0.13
1 PLACE	---	± 0.25

DRAFT WHERE APPLICABLE MUST
REMAIN WITHIN DIMENSIONS

DRWG. BY	GOC	CHK'D. BY	GOC
APP'D. BY		SCALE	NA:



REVISE ONLY ON CAD SYSTEM

TITLE

SPECIAL DOUBLES APPLICATOR
FOR HOUSING PART NOS.
6313, 43275 & 41644-24



MOLEX INCORPORATED
LITLLEJLL. 60532 U.S.A.

SHEET NO.

DATE

3 OF 4

02/23/95

PART NO.

DRWG. NO.

638303000

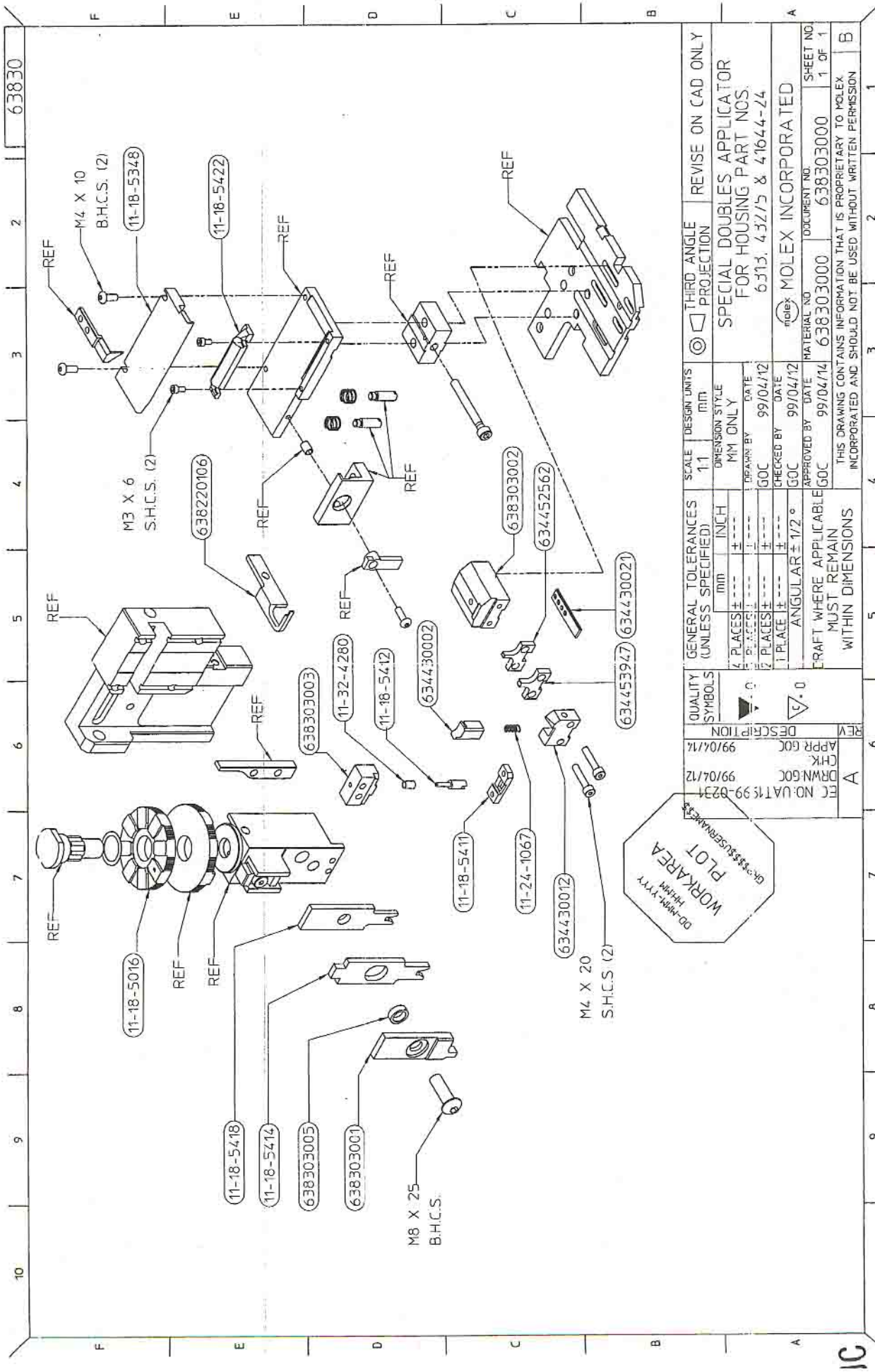
638303000

FILE NAME
6383030
582

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DIV.
AT

SIZE
A



WORKAREA
PLOT
DD-MMM-YY
HHMM

REV	DESCRIPTION	DATE
A	DRWN:GOC	99/04/12
	CHK:	
	APPR:GOC	99/04/14

QUALITY SYMBOLS	GENERAL TOLERANCES (UNLESS SPECIFIED)	SCALE	DESIGN UNITS	THIRD ANGLE PROJECTION	REVISE ON CAD ONLY
0.1 0.05 0.02	mm mm mm mm mm mm mm mm mm mm mm mm	1:1	MM	MM ONLY	
	4 PLACES ±	1	DATE	DATE	
	2 PLACES ±	1	99/04/12	99/04/12	
	1 PLACE ±	1	GOC	GOC	
	ANGULAR ± 1/2°	1	DATE	DATE	
		1	99/04/12	99/04/12	

CRAFT WHERE APPLICABLE MUST REMAIN WITHIN DIMENSIONS	MATERIAL NO	DOCUMENT NO	SHEET NO
	638303000	638303000	1 OF 1
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SPECIAL DOUBLES APPLICATOR
FOR HOUSING PART NOS.
6313, 4321/5 & 41644-24

MOLEX INCORPORATED