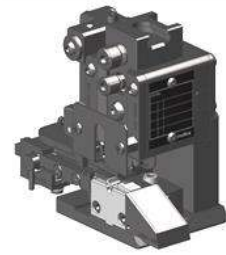




**S-1
Applicator**

**Application Tooling
Specification Sheet**



Order No. 217362-3710

FEATURES

- Directly adapts to most automatic wire processing machines.
- Simplified terminal feed mechanism provides improved accuracy.
- Conductor crimp height and insulation crimp height can achieve an aim by slight labor by the adjustment of each 10 steps.
- Adjustments to the bell mouth can be made without detaching the applicator.
- Changeable feed cam supports pre-feed and post-feed operation.

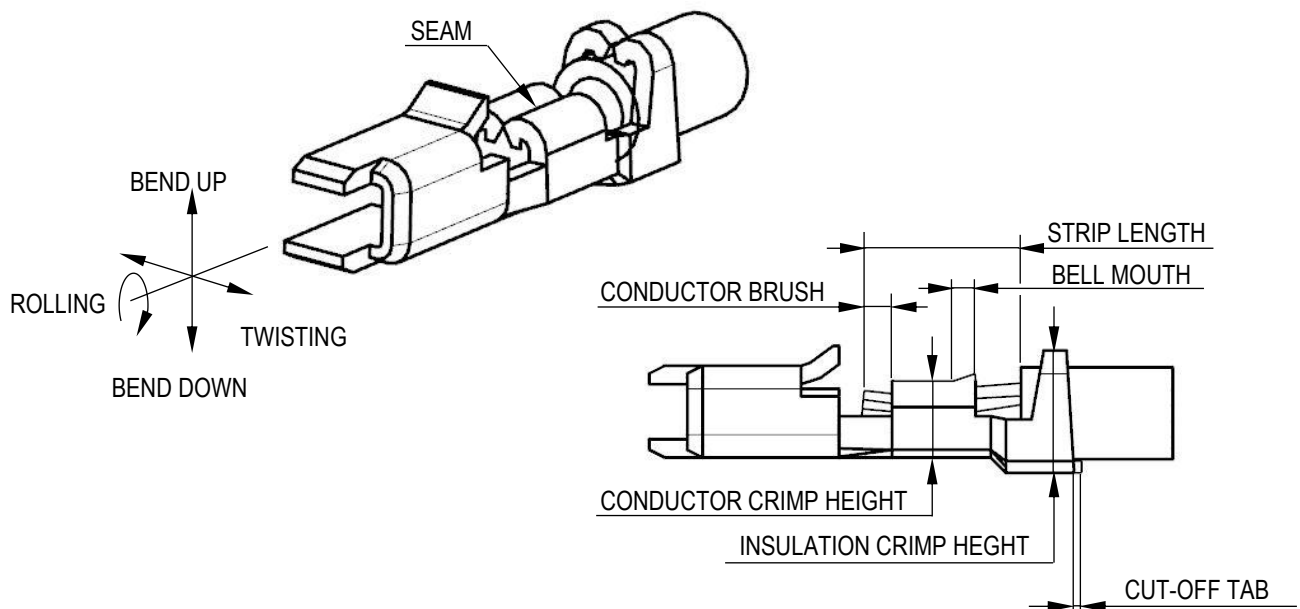
SCOPE

Products: ZERO-HACHI 0.8 WTB Crimp Terminal, 28-32 AWG (UL3767).

Terminal Series No.	Terminal No.	Wire Size		Insulation Diameter		Strip Length(Ref)	
		AWG	mm ²	mm	In.	mm	In.
214720	214720-5000	28-30	0.04-0.08	0.5-0.6	.019-.023	0.9-1.1	.035-.043
	214720-5001	30-32	0.03-0.05	0.44-0.5	.017-.019		

This Applicator will AWG30-32 of crimp small wire insulation diameter shown above.
 Applicator 217362-3700 should be used for larger insulation diameter.
 Note: Oiler (578053-6000) required to crimp terminals. See IS-578053-6000 (OIL POT HOLDER) Manual.

DEFINITION OF TERMS



CRIMP SPECIFICATION

Terminal No.	Bell Mouth		Cut-Off Tab(Max)		Conductor Brush	
	mm	In.	mm	In.	mm	In.
214720-5000 214720-5001	0.05-0.15	.002-.006	0.05	.002	0.05-0.3	.002-.012

Terminal No.	Bend Up	Bend Down	Twist	Roll	Seam
	Degree(Max)		Degree(Max)		
214720-5000 214720-5001	3	3	2	3	Seam shall not be open and no wire allowed out of the crimping area

After crimping the wire (equivalent to UL3767), the crimp profiles should measure the following.

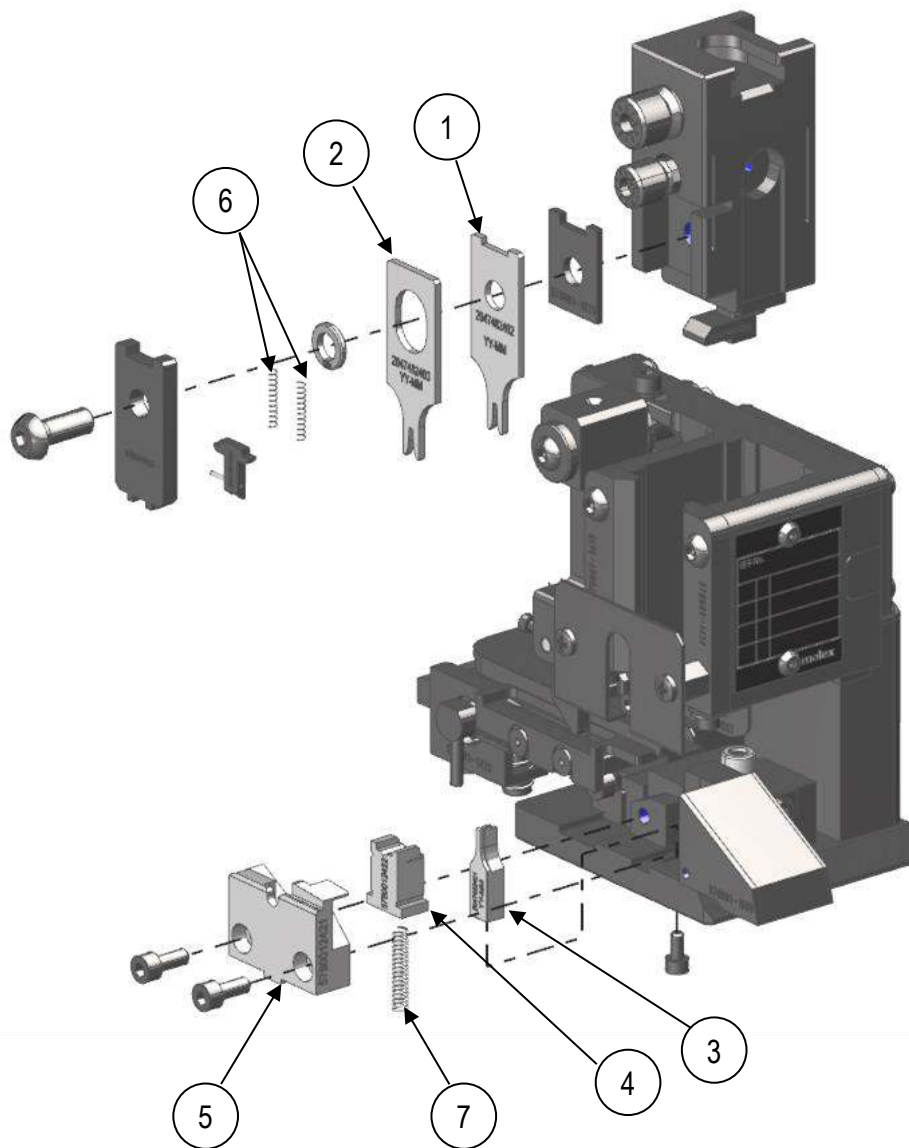
Terminal No.	Wire Size		Conductor Crimp Height		Insulation Crimp Height		Pull Force (Min)	
	AWG	mm ²	mm	In.	mm	In.	N	Kgf
214720-5000	28	0.04-0.08	0.47-0.51	.0185-.020	0.775-0.825	.031-.033	9.8	1.0
	30		0.44-0.48	.017-.019	0.725-0.775	.029-.031	4.9	0.5
214720-5001	30	0.03-0.05	0.4-0.44	.016-.017	0.675-0.725	.027-.028	4.9	0.5
	32		0.38-0.42	.015-.016	0.65-0.7	.026-.028	3.4	0.3

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

PARTS LIST

S-1 Applicator 217362-3710			
Item	Engineering No.	Description	Quantity
Perishable Tooling			
1	217362-2412	Conductor Punch	1
2	217362-2413	Insulation Punch	1
3	217362-2411	Anvil	1
4	217362-2408	Floating Shear	1
5	578001-2414	Front Holder	1
6	578001-1508	SPRING (WIRE HOLDER)	2
7	578001-1503	SPRING (FLOATING SHEAR)	1

Assembly Drawing



NOTES

1. Molex recommends that an extra perishable tooling 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 the work area.
4. Wear safety glasses at all times.
5. For recommended maintenance, refer to the 5780013700IS manual.

CAUTION: This applicator should only be used in a press with a shut height of 119.70 mm (4.712"). 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 manufactured by Molex and sold by Molex or authorized distributors ("Molex Tooling"). When using tooling other than Molex Tooling with Molex-specific connector systems listed in our ATS documents, the Molex tooling qualification does not apply and the responsibility for full qualification of the connector system is that of the customer. Molex accepts no liability for connector performance or tooling support where tooling other than Molex Tooling is used or where Molex Tooling is modified.

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