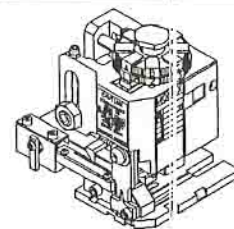




APPLICATION TOOLING MINI-MAC APPLICATOR SPECIFICATION SHEET



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

SET	WIRE AWG	CRIMP HEIGHT		CRIMP WIDTH (REF.)		PULL FORCE MINIMUM	
		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 UNDER POWER. 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.

DD-MINI-MAC PROD.
HUMAN MADE
NO FOR PRODUCTION
RELEASE FOR PRODUCTION
DATE 1999/02/18
GOC 638303070

REVISIONS

MFG. SH. BY: A
L.T.R. BY: A

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	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 MOLEX INCORPORATED SHEET NO. DATE
LISLE, ILL. 60532 U.S.A. 1 OF 4 03/15/99

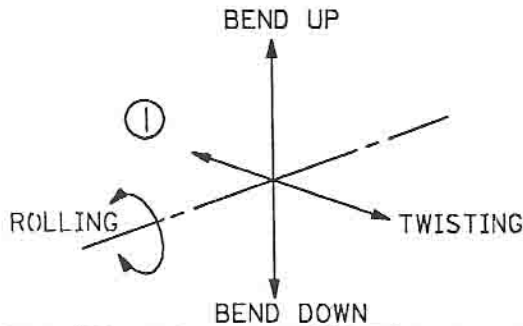
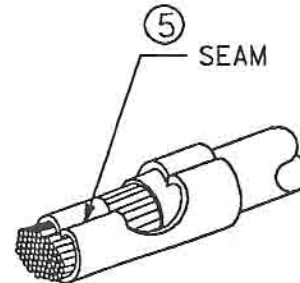
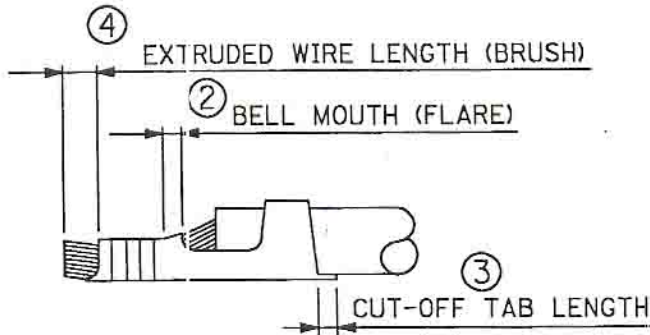
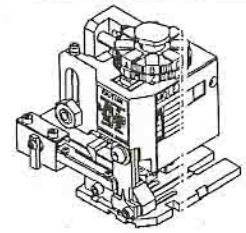
PART NO. DRWG. NO.
638303000 638303000

FILE NAME: 6383030 S80
THIS DRAWING CONTAINS INFORMATION THAT IS PROPRIETARY TO MOLEX INC. AND SHOULD NOT BE USED WITHOUT WRITTEN PERMISSION.
DIV. SIZE: AT A

UC



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.

DD-MMM-YY
 HMM
 WORK AREA
 PLEASE KEEP
 #UNT 1995025A
 GOC
 #1108/04/13
 REVISIONS
 MFG. SH. RE. A
 LTR. BY

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: JPM 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.

DATE

2 OF 4

03/15/99

PART NO.

DRWG. NO.

638303000

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FILE NAME
 6383030
 S81

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DIV.

SIZE

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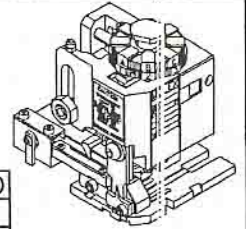
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UC



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

DD-MMM-YY
HH:MM:SS
WORK AREA
PLEASE FOR RETURN
#1JA 0999
#1JA 0999/99
GOC 04/28/99

MFG. SH. REV. 1
L.T.R. REVISIONS

DIMENSIONS SHOWN (METRIC) INCH

UNLESS OTHERWISE SPECIFIED
TOLERANCES: ANGULAR ± 1/2°

	INCH	METRIC
3 PLACE	± ---	---
2 PLACE	± ---	± 0.13
1 PLACE	---	± 0.25

DRAFT WHERE APPLICABLE MUST
REMAIN WITHIN DIMENSIONS

▽ = ▼ = REVISE ONLY ON CAD SYSTEM

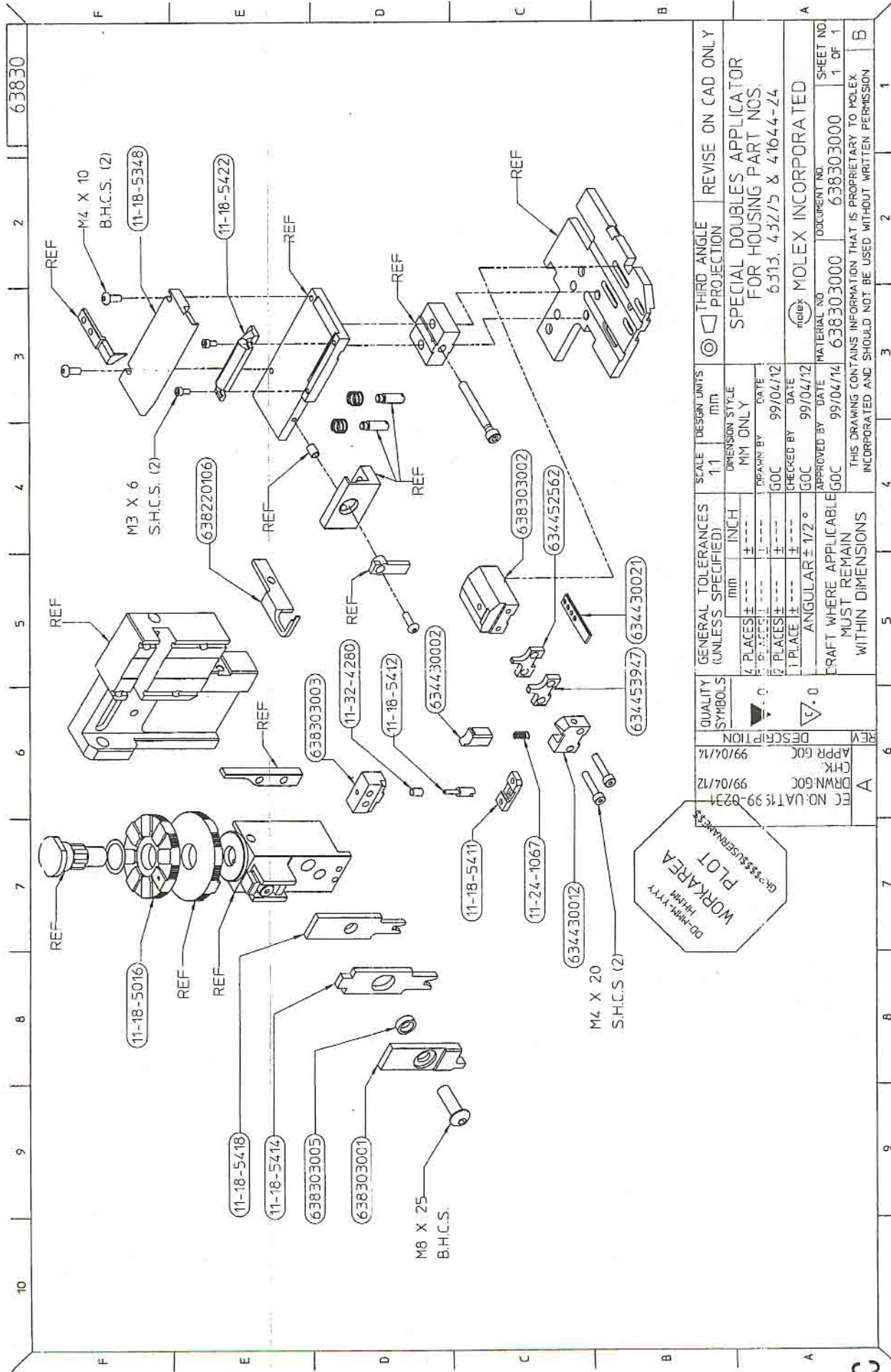
TITLE
**SPECIAL DOUBLES APPLICATOR
FOR HOUSING PART NOS.
6313, 43275 & 41644-24**

MOLEX INCORPORATED SHEET NO. DATE
LISLE, ILL. 60532 U.S.A. 3 OF 4 02/23/95

PART NO. DRWG. NO.
638303000 **638303000**

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6383030 MOLEX INC. AND SHOULD NOT BE USED WITHOUT WRITTEN PERMISSION. DIV. SIZE
582 AT A

UC



REV	DESCRIPTION
A	DRWN:GOC 99/04/12
	CHK: 99/04/12
	APP:GOC 99/04/12

QUALITY SYMBOLS	
	0.1
	0.05
	0.2

GENERAL TOLERANCES (UNLESS SPECIFIED)	
PLACES ±	mm
PLACES ±	inch
PLACES ±	mm
PLACES ±	inch
PLACES ±	mm
PLACES ±	inch
ANGULAR ± 1/2°	

SCALE	DESIGN UNITS	THIRD ANGLE PROJECTION	REVISE ON CAD ONLY
1:1	MM	AS SHOWN	
DIMENSION STYLE: MM ONLY			
DRAWN BY: GOC		DATE: 99/04/12	
CHECKED BY: GOC		DATE: 99/04/12	
APPROVED BY: GOC		DATE: 99/04/12	
MATERIAL NO: 638303000		DOCUMENT NO: 638303000	
SHEET NO: 1 OF 1		SHEET NO: 1 OF 1	

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