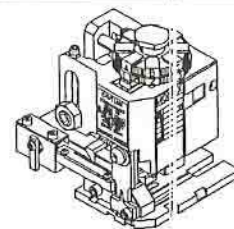




# APPLICATION TOOLING MINI-MAC APPLICATOR SPECIFICATION SHEET



### 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 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.

DD-MINI-MAC PROD.  
HUMAN MADE

NO PRODUCTION  
RELEASE FOR  
DATE 1999 02 18  
GOC 638303070

REVISEMENTS

MFG. SH. REVISIONS

L.T.R.

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

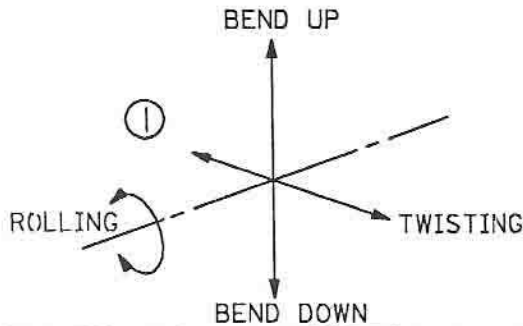
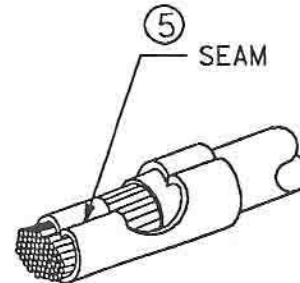
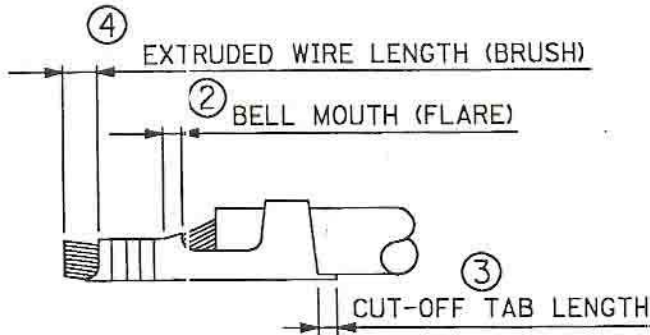
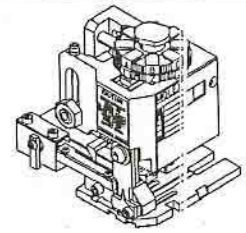
PART NO.    DRWG. NO.  
**638303000**    **638303000**

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

WORK AREA  
PLEASE KEEP  
#UNT 1995025A  
GOC  
#1108/04/13

RELEASE  
REVISIONS

MFG. SH. RE  
APP'D. BY  
L.T.R.

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.    2 OF 4    03/15/99

PART NO.    DRWG. NO.  
638303000    638303000

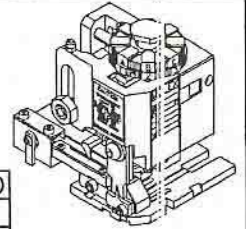
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63830300    MOLEX INC. AND SHOULD NOT BE USED WITHOUT WRITTEN PERMISSION.    DTI    SIZE  
S81    AT    A

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

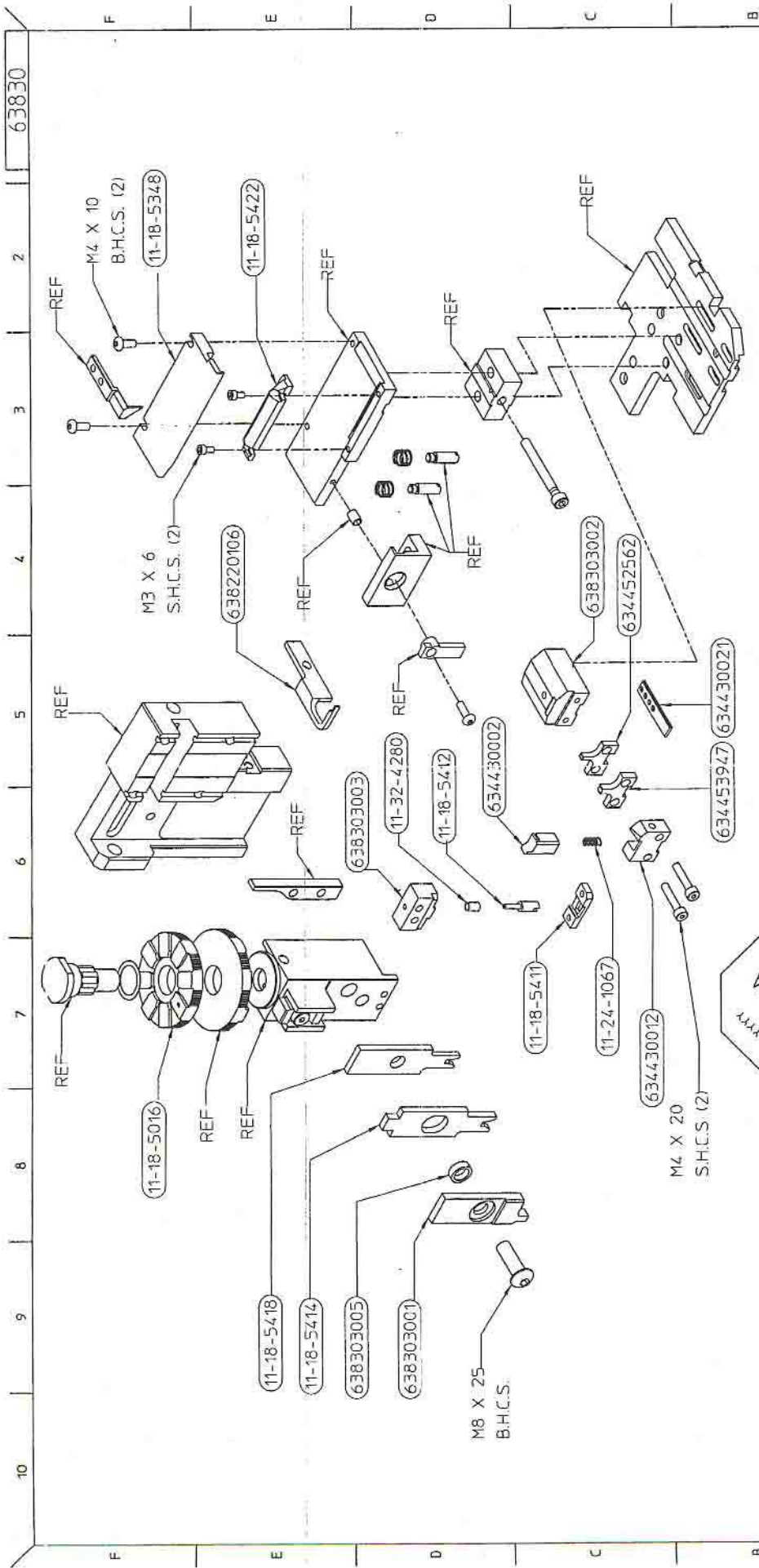
ITEM	ORDER NO.	SIZE	ENG. NO.	DESCRIPTION	REQ'D
	63800-0100	B	63800-0100	FRAME ASSY	1
	11-18-5016	B	60812A105	CONDUCTOR ADJUSTING CAM	1

DD-MMM-YY  
 HH:MM:SS  
 WORK AREA  
 PLEASE FOR RETURN  
 #1A 0999  
 #1A 0999  
 GOC 04/25/99  
 REVISIONS  
 MFG. SH. REV. DATE  
 A  
 LTR.

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	
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 LISLE, ILL. 60532 U.S.A.		SHEET NO. 3 OF 4	DATE 02/23/95
PART NO. 638303000		DRWG. NO. 638303000	
FILE NAME 6383030582	THIS DRAWING CONTAINS INFORMATION THAT IS PROPRIETARY TO MOLEX INC. AND SHOULD NOT BE USED WITHOUT WRITTEN PERMISSION.		DIV. SIZE AT A

UC



DD-MNH-YYY  
 WORKAREA  
 PLOT  
 GR-33333333333333333333

QUALITY SYMBOLS	DESCRIPTION	REV
▲ 0		
▽ 0		
EC NO: UAT199-0234	DRWN: GOC	99/04/12
	CHK:	
	APPR: GOC	99/04/12
GENERAL TOLERANCES (UNLESS SPECIFIED)		
mm	INCH	
4 PLACES ±	+	
2 PLACES ±	+	
1 PLACE ±	+	
ANGULAR ± 1/2°		
SCALE DESIGN UNITS		
1:1	MM	
DIMENSION STYLE		
MM ONLY		
THIRD ANGLE PROJECTION		
REVISE ON CAD ONLY		
SPECIAL DOUBLES APPLICATOR FOR HOUSING PART NOS. 6313, 4321/5 & 41644-24		
MOLEX INCORPORATED		
MATERIAL NO		DOCUMENT NO
638303000	638303000	
APPROVED BY DATE		SHEET NO
GOC	99/04/14	1 OF 1
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