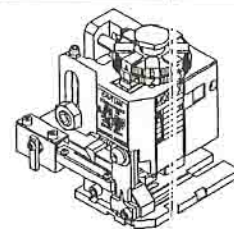




# APPLICATION TOOLING MINI-MAC APPLICATOR SPECIFICATION SHEET



## 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

WARRANTY  
RELEASE FOR  
USE 1999/02/18  
GOC 1997/10/4

REVISEMENTS

MFG. SH. REVISIONS

A

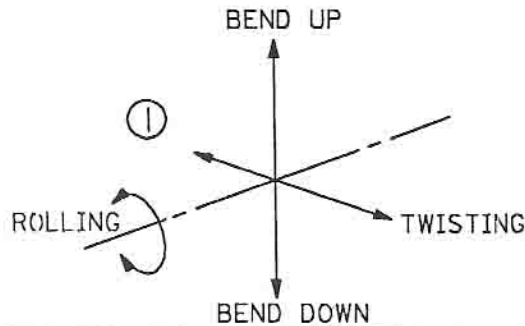
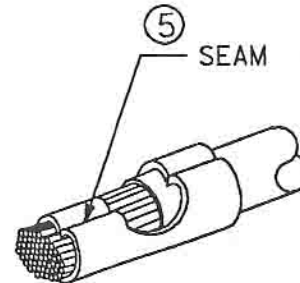
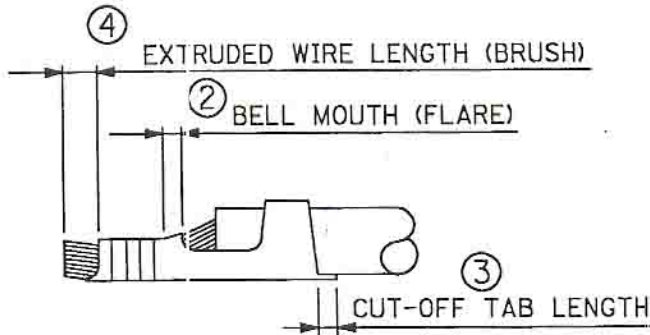
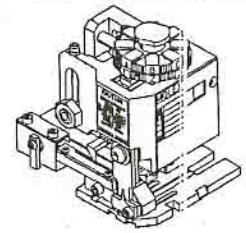
DIMENSIONS SHOWN (METRIC) INCH	
UNLESS OTHERWISE SPECIFIED TOLERANCES: ANGULAR ± 1/2°	
INCH	METRIC
3 PLACE ±	---
2 PLACE ±	±
1 PLACE	---
DRAFT WHERE APPLICABLE MUST REMAIN WITHIN DIMENSIONS	
DRWG. BY JMP	CHK'D. BY GOC
APP'D. BY	SCALE NA:

▽ =	▼ =	REVISE ONLY ON CAD SYSTEM
TITLE SPECIAL DOUBLES APPLICATOR FOR HOUSING PART NOS. 6313, 43275 & 41644-24		
MOLEX INCORPORATED LISLE, ILL. 60532 U.S.A.		SHEET NO. DATE 1 OF 4 03/15/99
PART NO. 638303000		DRWG. NO. 638303000
FILE NAME 6383030 S80	THIS DRAWING CONTAINS INFORMATION THAT IS PROPRIETARY TO MOLEX INC. AND SHOULD NOT BE USED WITHOUT WRITTEN PERMISSION.	
DIV. AT	SIZE 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  
HHMM  
MFG. SH. RE. WORK AREA  
PLEASE APPR. PROD.  
#UNIT 19950251  
GOC  
#11/1995/04/13  
REVISIONS

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  
LISLE, ILL. 60532 U.S.A.

SHEET NO.

DATE

2 OF 4

03/15/99

PART NO.

DRWG. NO.

638303000

638303000

FILE NAME  
6383030  
S81

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DIV.

SIZE

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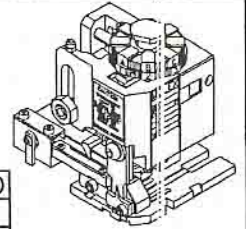
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# MINI-MAC APPLICATOR

## 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

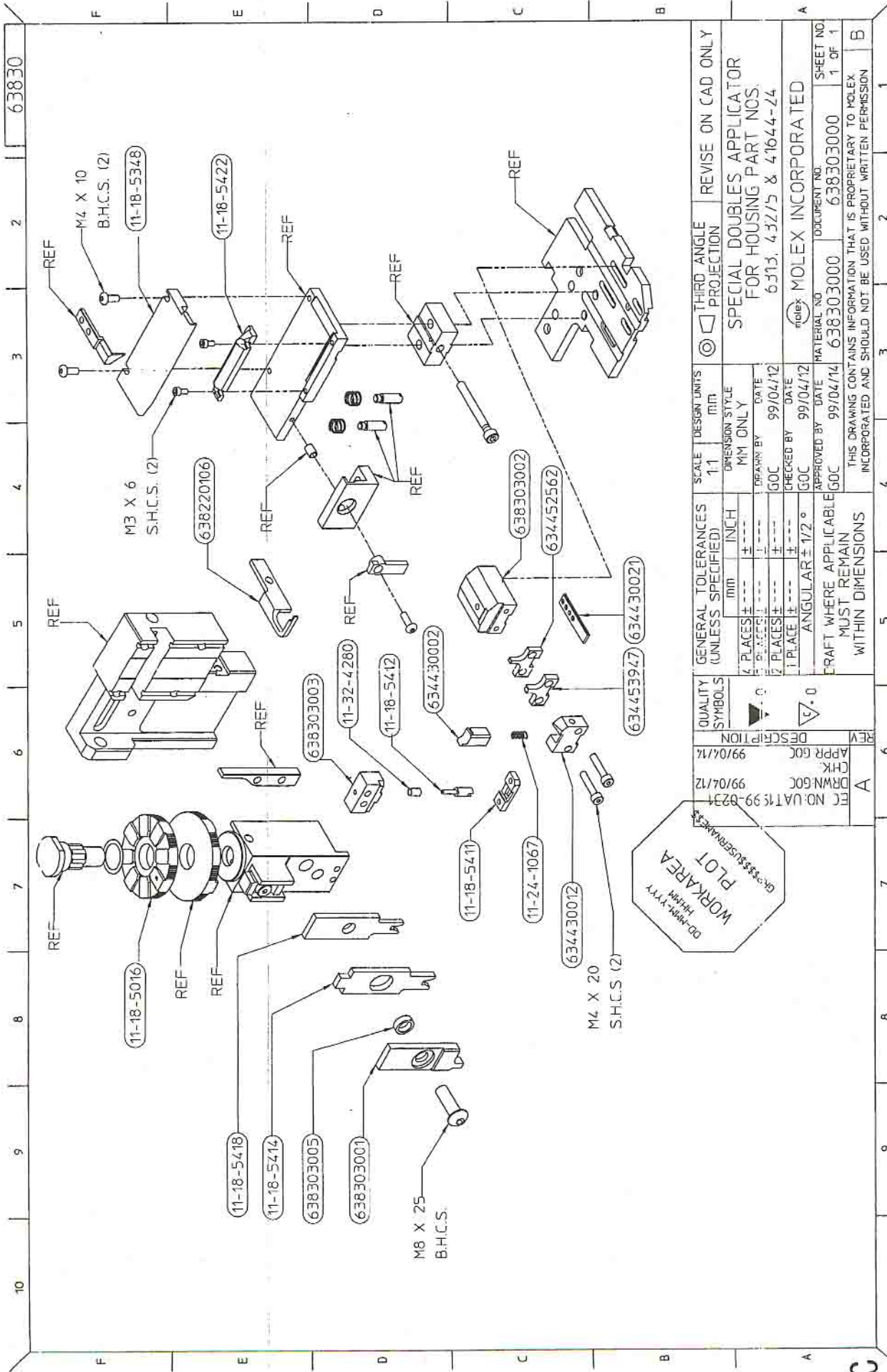
TITLE  
**SPECIAL DOUBLES APPLICATOR  
FOR HOUSING PART NOS.  
6313, 43275 & 41644-24**

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

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

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

UC



DD-MNL-YYY  
 WORKAREA  
 PLOT  
 GR-33453947

QUALITY SYMBOLS	DESCRIPTION	REV
	APPR GOC 99/04/12	6
	CHK 99/04/12	
	DRWN GOC 99/04/12	A
EC NO: UAT199-0234		

GENERAL TOLERANCES (UNLESS SPECIFIED)		SCALE		DESIGN UNITS		THIRD ANGLE PROJECTION		REVISE ON CAD ONLY	
mm	± 0.1	1:1	mm	mm	mm	mm	mm	mm	mm
INCH	± 0.005								
PLACES ±		DIMENSION STYLE		DATE		DATE		DATE	
4	+	MM ONLY		99/04/12		99/04/12		99/04/12	
2	+			GOC		GOC		GOC	
1	+			GOC		GOC		GOC	
ANGULAR ± 1/2°									

CRAFT WHERE APPLICABLE MUST REMAIN WITHIN DIMENSIONS

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 DOCUMENT NO. 638303000  
 SHEET NO. 1 OF 1