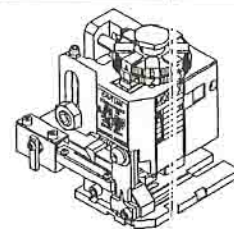




# APPLICATION TOOLING MINI-MAC APPLICATOR SPECIFICATION SHEET



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

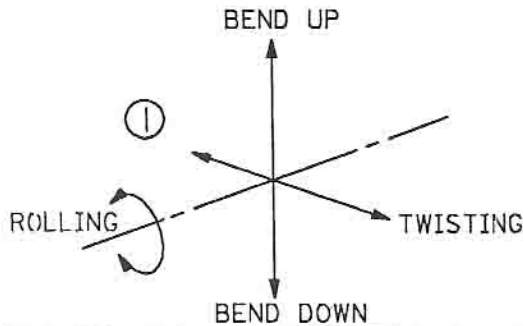
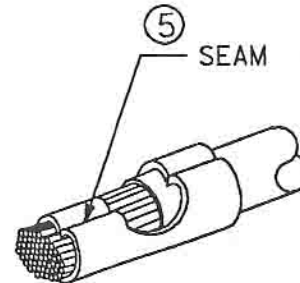
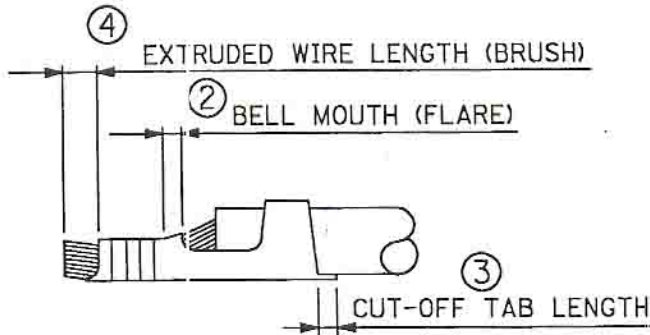
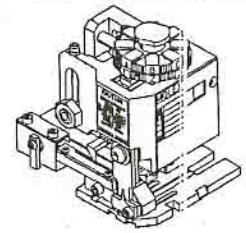
PART NO. DRWG. NO.  
638303000 638303000

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6383030 S80 AT A

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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.

DD-MMM-YY  
HHMM  
MFG. SH. RE. WORK AREA  
PLEASE USE  
#UNIT 1905025A  
GOC  
REVISIONS  
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 INCORPORATED  
LISLE, ILL. 60532 U.S.A.

SHEET NO.

DATE

2 OF 4

03/15/99

PART NO.

DRWG. NO.

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FILE NAME  
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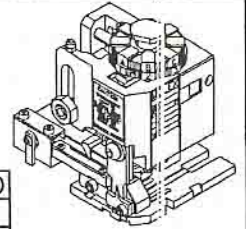
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# MINI-MAC APPLICATOR

## 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  
LTR. 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

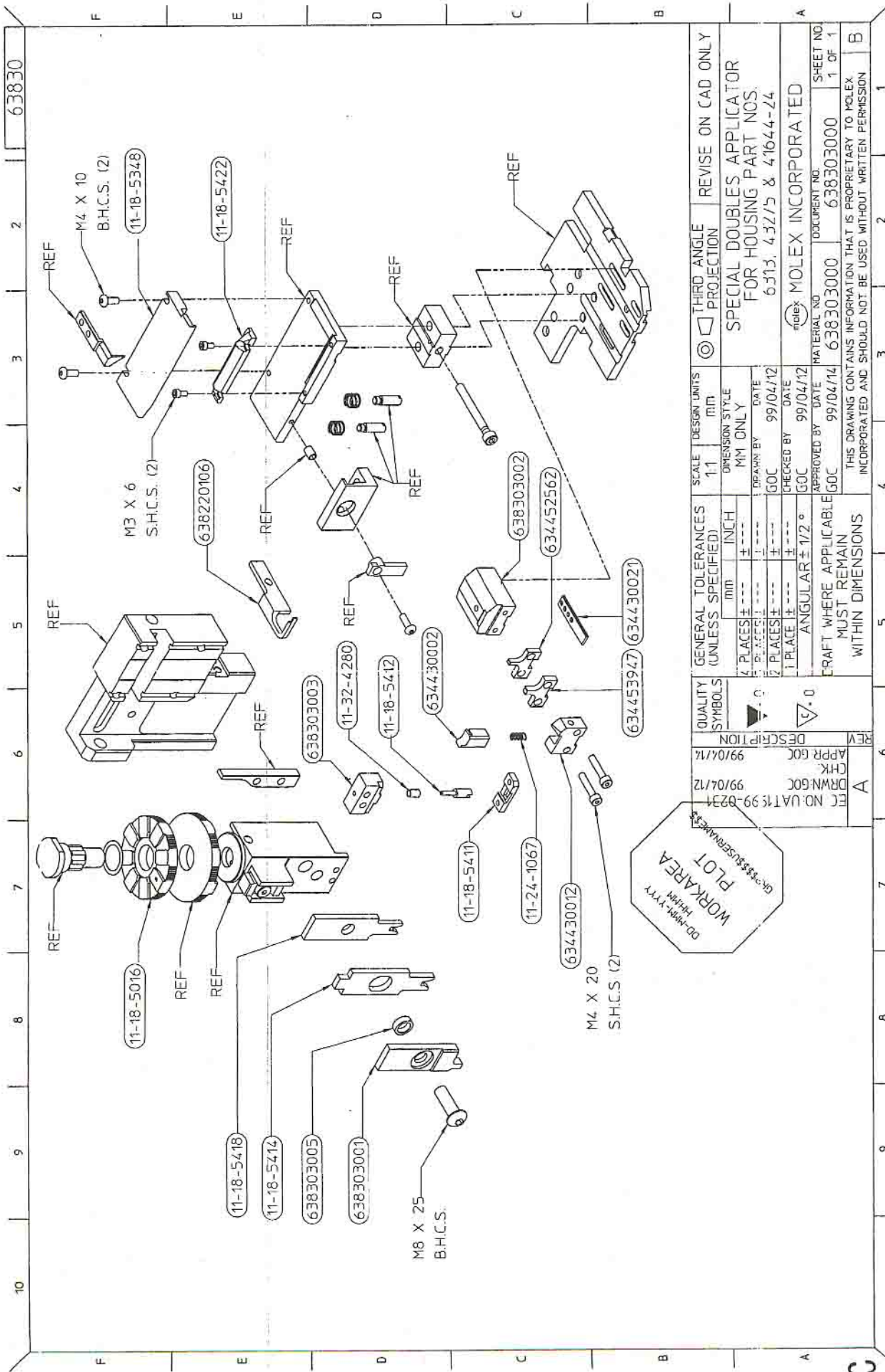
TITLE  
**SPECIAL DOUBLES APPLICATOR  
FOR HOUSING PART NOS.  
6313, 43275 & 41644-24**

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

PART NO.      DRWG. NO.  
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THIRD ANGLE PROJECTION	REVISION ON CAD ONLY
SPECIAL DOUBLES APPLICATOR FOR HOUSING PART NOS. 6313, 4321/5 & 41644-24	
SCALE 1:1	DESIGN UNITS MM
GENERAL TOLERANCES (UNLESS SPECIFIED)	MM ONLY
4 PLACES ±	DATE 99/04/12
2 PLACES ±	DATE 99/04/12
1 PLACE ±	DATE 99/04/12
ANGULAR ± 1/2°	DATE 99/04/12
QUALITY SYMBOLS	DATE 99/04/12
DESCRIPTION	DATE 99/04/12
APPR GOC	DATE 99/04/12
CHK	DATE 99/04/12
DRWN GOC	DATE 99/04/12
EC NO: UAT199-0234	DATE 99/04/12
DD-MMM-YY	DATE 99/04/12
WORKAREA PLOT	DATE 99/04/12
GR-33333333333333333333	DATE 99/04/12
SCALE 1:1	DESIGN UNITS MM
GENERAL TOLERANCES (UNLESS SPECIFIED)	MM ONLY
4 PLACES ±	DATE 99/04/12
2 PLACES ±	DATE 99/04/12
1 PLACE ±	DATE 99/04/12
ANGULAR ± 1/2°	DATE 99/04/12
QUALITY SYMBOLS	DATE 99/04/12
DESCRIPTION	DATE 99/04/12
APPR GOC	DATE 99/04/12
CHK	DATE 99/04/12
DRWN GOC	DATE 99/04/12
EC NO: UAT199-0234	DATE 99/04/12
DD-MMM-YY	DATE 99/04/12
WORKAREA PLOT	DATE 99/04/12
GR-33333333333333333333	DATE 99/04/12

SHEET NO

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