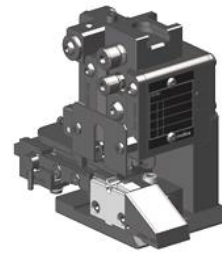




**S-1
Applicator**

**Application Tooling
Specification Sheet**



Order No. 578047-3700

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.

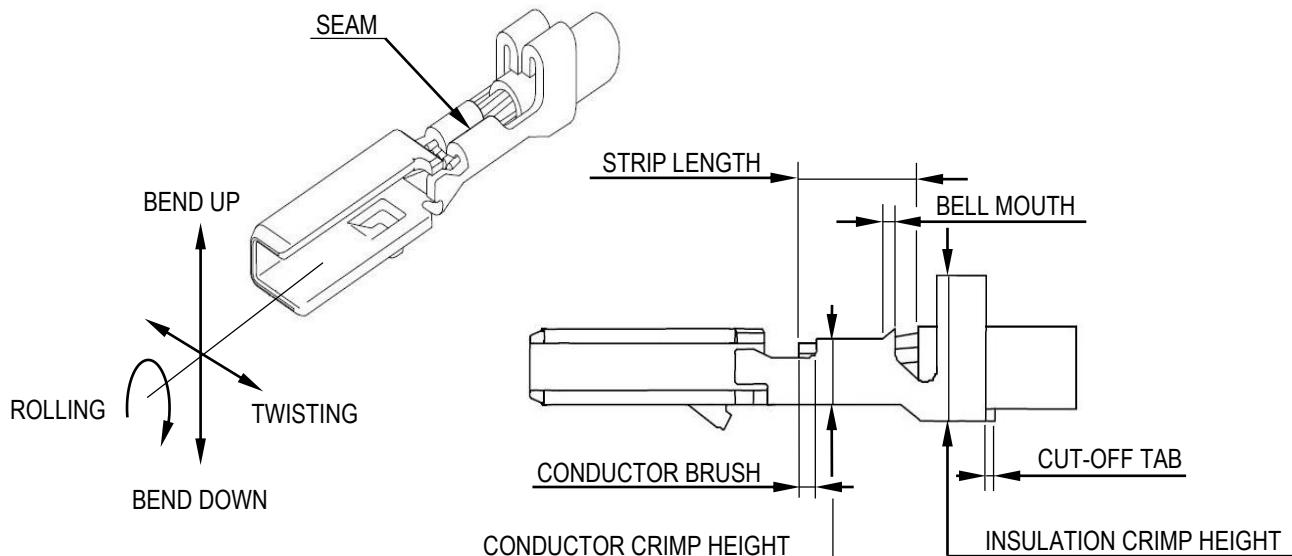
SCOPE

Products: CLIK-Mate Terminals, 24-28 AWG(TIN), 24-26 AWG(GOLD).

Terminal Series No.	Terminal Order No.	Wire Size		Insulation Diameter		Strip Length(Ref)	
		AWG	mm ²	mm	In.	mm	In.
502579	502579-0000	24-28	0.079-0.22	0.78-1.28	.031-.050	1.50-1.90	.059-.075
	502579-1000						
213028	213028-1000	24-26	0.126-0.22	0.95-1.20	.037-.047		
	213028-3000						
	213028-7000						

Note: Oiler (578053-6000) required to crimp terminals. See IS-578053-6000 (OIL POT HOLDER) Manual.

DEFINITION OF TERMS



INSULATION CRIMP FORM

Is not problem having on the function though does piercing and there is a situation.

CRIMP SPECIFICATION

Terminal Series No.	Bell Mouth(Ref)		Cut-Off Tab		Conductor Brush	
	mm	In.	mm	In.	mm	In.
502579 213028	0.10-0.40	.004-.016	0-0.10	0-.004	0.10-0.60	.004-.024

Terminal Series No.	Bend Up	Bend Down	Twist	Roll	Seam
	Degree(Max)		Degree(Max)		
502579 213028	3	3	3	8	Seam shall not be open and no wire allowed out of the crimping area

After crimping the wire (equivalent to UL1061/ UL1571), the crimp profiles should measure the following.

Terminal Series No.	Wire Size		Conductor Crimp Height		Insulation Crimp Height(Ref)		Pull Force (Min)	
	AWG	mm ²	Mm	In.	mm	In.	N	kgf
502579	24 (UL1061)	0.079-0.220	0.60-0.65	.024-.026	1.65	.065	29.4	3.0
	26 (UL1061)		0.59-0.64	.023-.025	1.55	.061	19.6	2.0
	28 (UL1061)		0.56-0.61	.022-.024	1.45	.057	9.8	1.0
	28 (UL1571)		0.56-0.61	.022-.024	1.40	.055	9.8	1.0

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

Terminal Series No.	Wire Size		Conductor Crimp Height		Insulation Crimp Height(Ref)		Pull Force (Min)	
	SHKV	mm ²	Mm	In.	mm	In.	N	kgf
502579	0.2 (7 ϕ 0.18)	0.079-0.220	0.60-0.65	.024-.026	1.65	.065	24.5	2.5
	0.08		0.56-0.61	.022-.024	1.35	.053	9.8	1.0

After crimping the wire (equivalent to UL1061), the crimp profiles should measure the following.

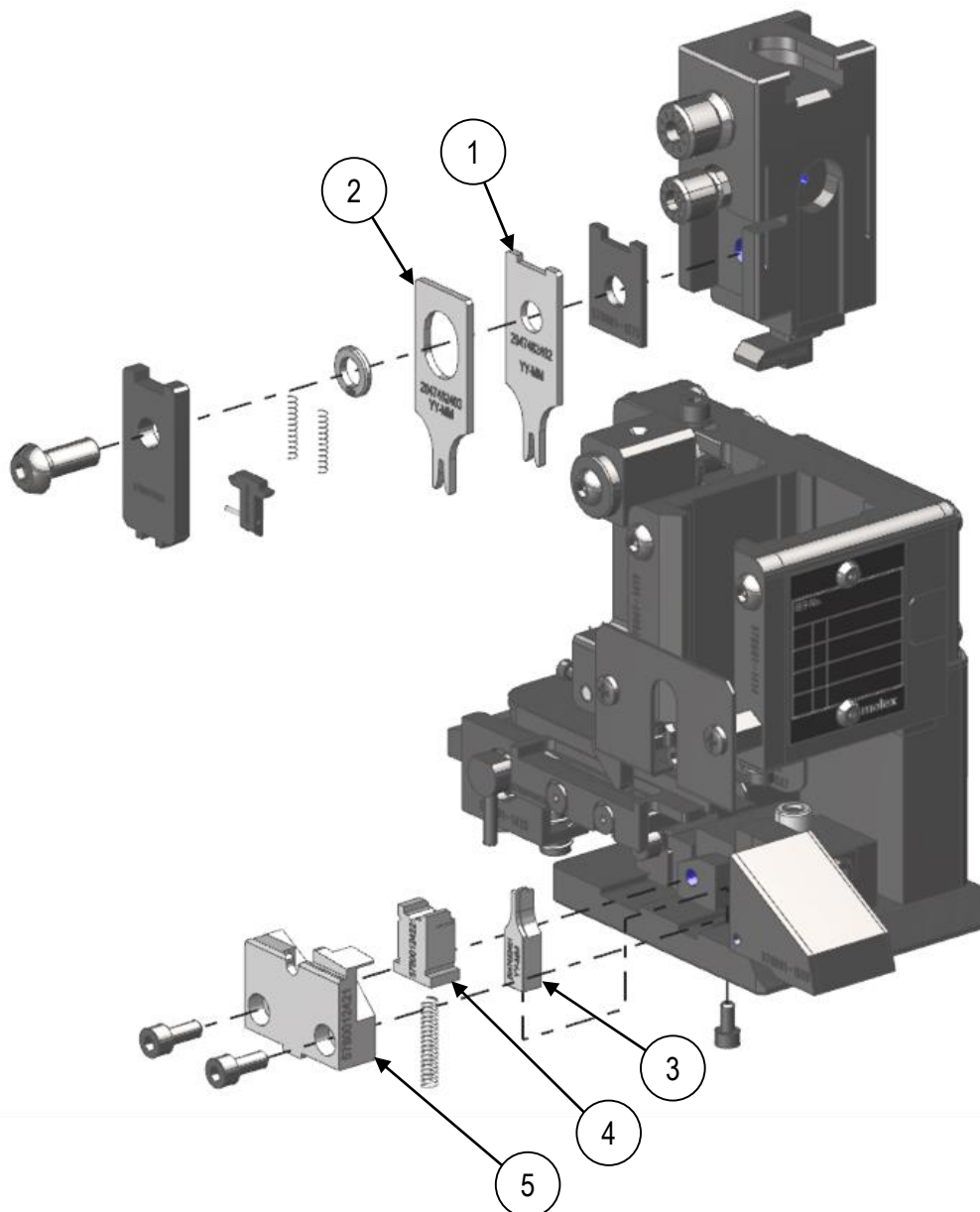
Terminal Series No.	Wire Size		Conductor Crimp Height		Insulation Crimp Height(Ref)		Pull Force (Min)	
	AWG	mm ²	Mm	In.	mm	In.	N	kgf
213028	24	0.126-0.220	0.60-0.65	.024-.026	1.65	.065	29.4	3.0
	26		0.55-0.60	.022-.024	1.55	.061	19.6	2.0

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 578047-3700				
Item	Order No	Engineering No.	Description	Quantity
Perishable Tooling				
1	578047-2422	578047-2422	Conductor Punch	1
2	578047-2423	578047-2423	Insulation Punch	1
3	578047-2421	578047-2421	Anvil	1
4	578047-2424	578047-2424	Floating Shear	1
5	578001-2415	578001-2415	Front Holder	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.

Visit our website at www.molex.com

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