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1 Purpose

This standard covers the acceptance criteria for the use of the Mini-fit series of crimps produced by Molex, used in the manufacture of looms for use within an ASM SMT machine.

2 Glossary, Abbreviations

Term	Description
SMT	Surface Mount Technology
AWG	American Wire Gauge

3 References

Molex (2009)	<i>Quality Crimping Handbook Order No. 63800-0029</i>
Molex (2002)	<i>Mini-Max Applicator Instruction Manual, AS.01.08.02/ISSUE B</i>

4 Parts Affected by This Standard

Part Description	Molex Part Number	ASM Assigned Part Number
Male Crimp Terminal 16AWG	39-00-0081	88233079-01
Female Crimp Terminal 16AWG	39-00-0078	88224707-01
Male Crimp Terminal 18-24AWG	39-00-0040	88229138-01
Female Crimp Terminal 18-24AWG	39-00-0038	88227912-01
Male Crimp Terminal 22-28AWG	39-00-0048	88229139-01
Female Crimp Terminal 22-28AWG	39-00-0047	88227911-01

5 Preferred Tools to be Used

5.1 Handheld

Wire Size	Preferred Crimp Size	Preferred Tool (Molex Part Number)
16AWG	16AWG	2002182200
18-22AWG	18-24AWG	638190901
22-28AWG	22-28AWG	638191000

5.2 Applicator

The preferred applicator for Mini-Fit Molex crimps is Molex Part Number 69037-1131.

6 Finished Crimp Quality

6.1 Conductor Crimp

Finished conductor crimping should achieve optimal crimp quality as close as possible, in accordance with the Molex Crimp Guide.

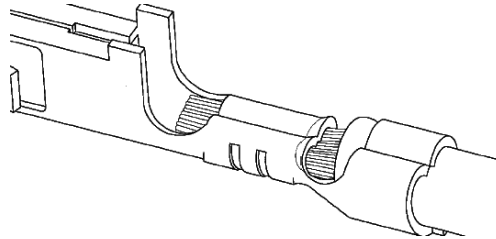


Figure 1 - Optimal Crimp (Molex, 2009, Page 18)

6.2 Insulation Crimp

The target insulation crimping quality should achieve the “Preferred Insulation Crimp” quality as close as possible, in accordance to page 20 of the Molex Crimp Guide.

“Acceptable Insulation Crimp” quality will also be accepted.

“Marginal Insulation Crimp” quality will be classified as defect.

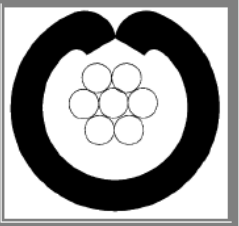
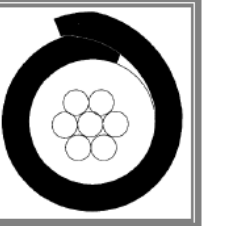
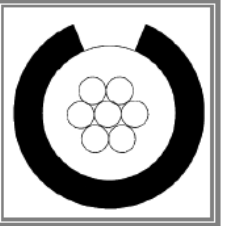
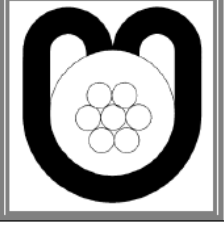
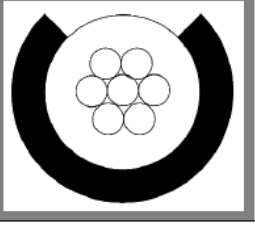
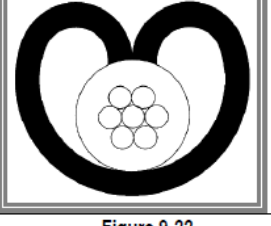
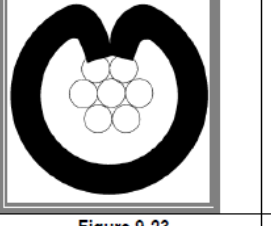
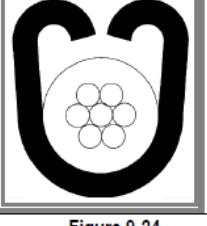
		
Figure 9-17 PREFERRED INSULATION CRIMP	Figure 9-18 PREFERRED INSULATION CRIMP	Figure 9-19 ACCEPTABLE INSULATION CRIMP
		
Figure 9-20 ACCEPTABLE INSULATION CRIMP		Figure 9-21 MARGINAL INSULATION CRIMP
		
Figure 9-22 MARGINAL INSULATION CRIMP	Figure 9-23 MARGINAL INSULATION CRIMP	Figure 9-24 MARGINAL INSULATION CRIMP

Figure 2 - Table of Insulation Crimp Outcomes (Molex, 2009, Page 20)