

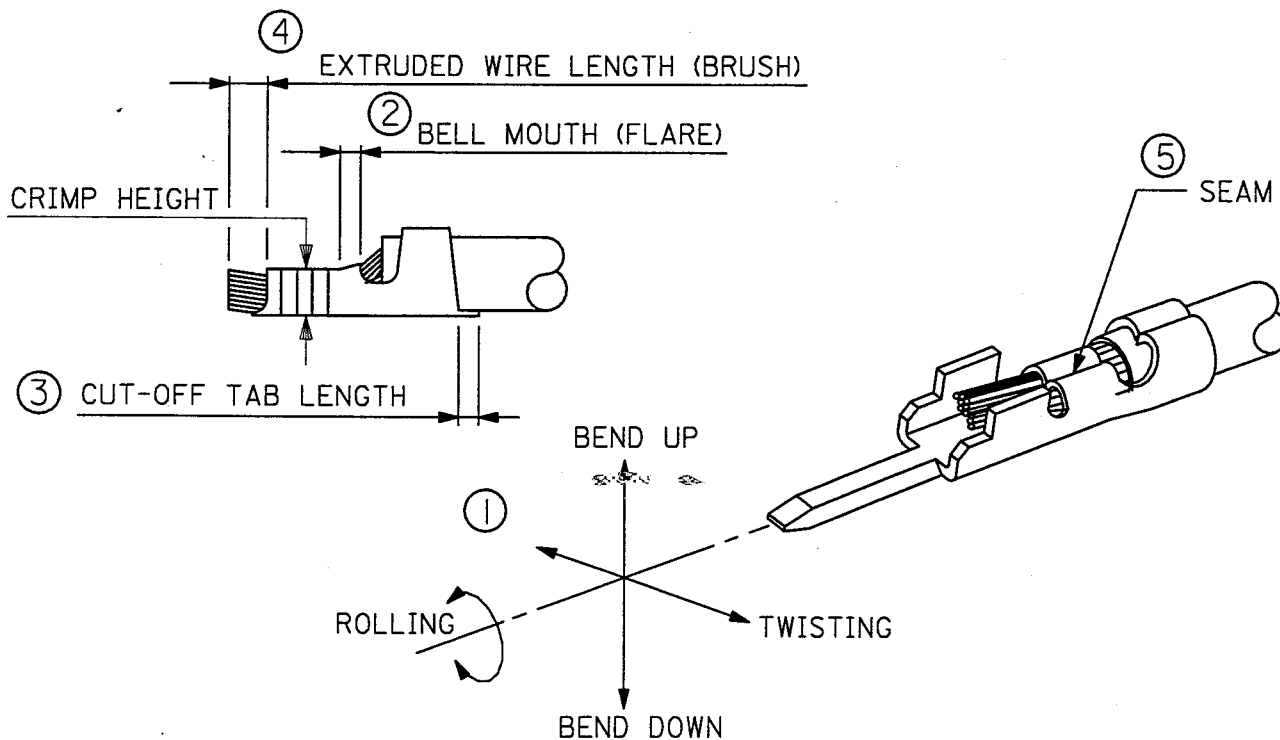
APPLICATION TOOLING TERMINATOR SPECIFICATION SHEET

A. SCOPE

THIS STANDARD SPECIFIES THE DIMENSIONS AFTER CRIMPING OF THE TERMINALS UNDERMENTIONED.

[illegible]

B. DEFINITION (TERMS)



CRIP

DD-MMM-YYYY HH:MM WORK AREA RE BILLS OF MATERIAL E.O. #12812-570 GRP-000006-22-97 USER NAME		DIMENSIONS SHOWN (METRIC) INCH		▽ = ▼ =		REVISE ONLY ON CAD SYSTEM	
		UNLESS OTHERWISE SPECIFIED TOLERANCES: ANGULAR ± 1/2°		Specification Sheet Terminator			
		INCH METRIC					
		3 PLACE	± ---				
		2 PLACE	± ---	± 0.13			
		1 PLACE	---	± 0.25			
		DRAFT WHERE APPLICABLE MUST REMAIN WITHIN DIMENSIONS					
MFG. SH. REVISIONS		DRWG. BY SMT		CHK'D. BY		FILE NAME 6384150 580 THIS DRAWING CONTAINS INFORMATION THAT IS PROPRIETARY TO MOLEX INC. AND SHOULD NOT BE USED WITHOUT WRITTEN PERMISSION. DIV. SIZE AT A	
		APP'D. BY		SCALE			
PART NO. 63841-5000		DRWG. NO. 638415000		MOLEX INCORPORATED		SHEET NO. 1 of 4	
				LISLE, ILL. 60532 U.S.A.		DATE 12 / 13 / 95	

C. SPECIFICATION

NO. OF FIG.	ITEM	REQUIREMENT
1	BEND UP	0°
	BEND DOWN	8°
	TWISTING	6°
	ROLLING	10°
2	BELL MOUTH (FLARE)	0.05-0.2 (.002"-.008")
3	CUT-OFF TAB LENGTH	max 0.2 (.008")
4	EXTRUDED WIRE LENGTH (BRUSH)	0-1.0 (0-.039")
5	SEAM	SEAM SHALL NOT BE OPENED AND
		NO WIRE ALLOWED OUT OF THE CRIMPING AREA.

D. CONDITIONS

AFTER CRIMPING , THE CRIMPED CONDUCTOR AREA SHOULD BE AS FOLLOWS.

TERMINAL SERIES	WIRE AWG	CRIMP HEIGHT		CRIMP WIDTH (REF.)		PULL FORCE MINIMUM	
		ENGLISH	(METRIC)	ENGLISH	(METRIC)	LBS.	(N)
50012-8000 50013-8000	24	.026 - .028	(0.65 - 0.72)	.047	(1.2)	5.0	()
	26	.024 - .026	(0.60 - 0.67)			3.0	()
	28	.023 - .025	(0.58 - 0.64)			2.0	()
		-	(-)				()
		-	(-)		()		()
		-	(-)				()
		-	(-)				()
		-	(-)				()
		-	(-)		()		()
		-	(-)				()
		-	(-)				()
		-	(-)				()
		-	(-)		()		()
		-	(-)				()
		-	(-)				()
		-	(-)				()

E. 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.

CRIMP

WORK AREA DD-MMM-YYYY HH:MM REV. BILL E. MATL. ECK/UC9/NO GRP *****6-25/97 OBSERVE		DIMENSIONS SHOWN (METRIC) INCH		C = ▼ =		REVISE ONLY ON CAD SYSTEM													
		UNLESS OTHERWISE SPECIFIED TOLERANCES: ANGULAR ± 1/2°		TITLE															
		<table border="1"> <thead> <tr> <th></th> <th>INCH</th> <th>METRIC</th> </tr> </thead> <tbody> <tr> <td>3 PLACE</td> <td>± ---</td> <td>---</td> </tr> <tr> <td>2 PLACE</td> <td>± ---</td> <td>± ---</td> </tr> <tr> <td>1 PLACE</td> <td>---</td> <td>± ---</td> </tr> </tbody> </table>			INCH	METRIC	3 PLACE	± ---	---	2 PLACE	± ---	± ---	1 PLACE	---	± ---	Specification Sheet Terminator			
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3 PLACE	± ---	---																	
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DRAFT WHERE APPLICABLE MUST REMAIN WITHIN DIMENSIONS																			
MFG. SH. RE. B	LTR.	DRWG. BY SMT	CHK'D. BY	MOLEX INCORPORATED LISLE, ILL. 60532 U.S.A. SHEET NO. 2 of 4 DATE 12/13/95															
		APP'D. BY	SCALE /: /	PART NO. 63841-5000 DRWG. NO. 638415000															
		FILE NAME 6384150 S81		THIS DRAWING CONTAINS INFORMATION THAT IS PROPRIETARY TO MOLEX INC. AND SHOULD NOT BE USED WITHOUT WRITTEN PERMISSION.															
				DIV. AT	SIZE A														

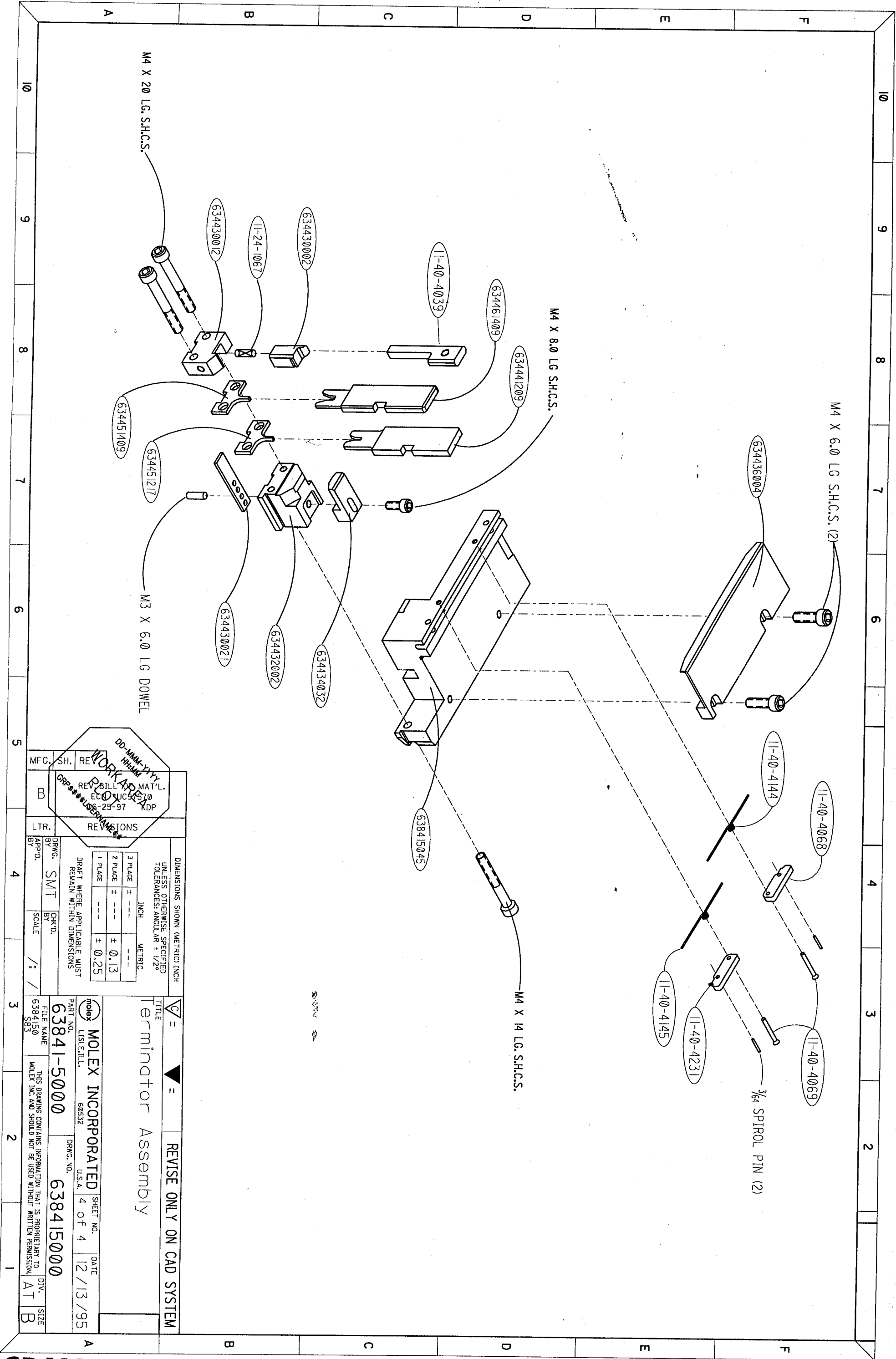
APPLICATOR ASSEMBLY - PARTS LIST

ITEM	ORDER NO.	SIZE	ENG. NO.	DESCRIPTION	REQ'D
6	634430012	b	634430012	Front Plunger Retainer	1
7	11-24-1067	a	4996-4	Cut-off Plunger Spring	1
8	11-40-4039	b	8302-5	Front Plunger Striker	1
9	634430021	b	634430021	Lower Tooling Key	1
10	634432002	b	634432002	Anvil Mount	1
11	634434032	B	634434032	Wire Stop	1
13	634436004	B	634436004	Rear Cover	1
40	11-40-4145	b	8302-111	Torsion Spring	1
41	11-40-4144	b	8302-110	Torsion Spring	1
42	11-40-4069	b	8302-103	Pivot Pin	2
43	11-40-4068	b	8302-102	Drag Finger	1
44	11-40-4231	b	8329-10	Stop Finger	1
45	638415045	c	638415045	Terminal Track	1

TOOLING INFORMATION

ITEM	ORDER NO.	SIZE	ENG. NO.	DESCRIPTION	REQ'D
1	634441209	b	634441209	Conductor Punch	1
2	634451217	b	634451217	Conductor Anvil	1
3	634461409	b	634461409	Insulation Punch	1
4	634451409	b	634451409	Insulation Anvil	1
5	634430002	B	634430002	Cut-off Plunger	1
70	638415070		638415070	ToolKit For Above	1

DD-MMM-YYYY HHMM REWORK AREA REVISIONS GRP: 6-25-97 ESN: UC30SY0 638415045		DIMENSIONS SHOWN (METRIC) INCH		C = ▼ =		REVISE ONLY ON CAD SYSTEM													
		UNLESS OTHERWISE SPECIFIED TOLERANCES: ANGULAR = 1/2°		TITLE Bill of Material Terminator															
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DRAFT WHERE APPLICABLE MUST REMAIN WITHIN DIMENSIONS		MOLEX INCORPORATED LISLE, ILL. 60532 U.S.A. SHEET NO. 3 of 4 DATE 12/13/95																	
DRWG. BY SMT APP'D. BY CHK'D. BY SCALE /: /		PART NO. 63841-5000 FILE NAME 6384150 S82		DRWG. NO. 638415000 THIS DRAWING CONTAINS INFORMATION THAT IS PROPRIETARY TO MOLEX INC. AND SHOULD NOT BE USED WITHOUT WRITTEN PERMISSION.		DIV. AT SIZE A													



DD-MMM-YY REV. BILL OF MAT'L. ECCN: 6A001 6-25-97 REV. NAME LTR. BY		DIMENSIONS SHOWN (METRIC) INCH UNLESS OTHERWISE SPECIFIED TOLERANCES: ANGULAR ± 1/2° INCH METRIC 3 PLACE ± --- ± 0.13 2 PLACE ± --- ± 0.13 1 PLACE --- ± 0.25 DRAFT: WHERE APPLICABLE MUST REMAIN WITHIN DIMENSIONS		TITLE Terminator Assembly	
MFG. SH. REV. B		DRWG. SMT BY G.K.D. SCALE /% /		PART NO. 63841-5000	
Molex INCORPORATED U.S.A.		SHEET NO. 4 of 4		DATE 12/13/95	
FILE NAME 6384150		DRWG. NO. 638415000		DIV. AT B	
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