



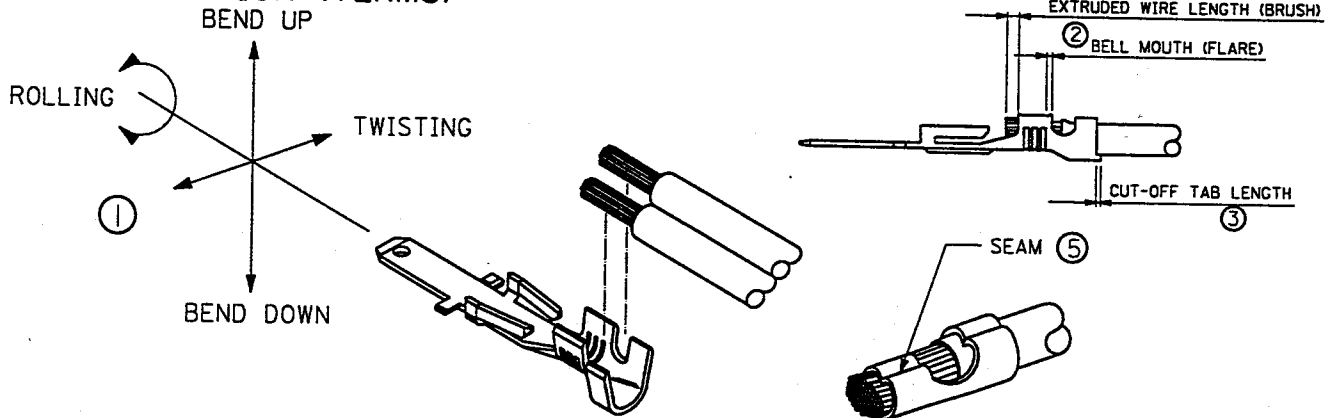
APPLICATION TOOLING TERMINATOR SPECIFICATION SHEET

A. SCOPE

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

TERMINAL SERIES	WIRE SIZE	INSULATION DIAMETER		STRIP LENGTH	
		AWG	ENGLISH	(METRIC)	ENGLISH
43178-2001	14-18	.119 - .180	(3.02 - 4.57)	.156 - .218	(3.96 - 5.54)
43178-2001	18-DBL	.119 - .180	(3.02 - 4.57)	.156 - .218	(3.96 - 5.54)
-	-	-	(-)	-	(-)
-	-	-	(-)	-	(-)

B. DEFINITION (TERMS)



(2) 18 awg DBL WIRES
POSITION WIRES AT 45°
FROM ONE ANOTHER AS SHOWN
OR ON TOP OF EACH OTHER
DO **NOT** POSITION SIDE BY SIDE

INSULATION GRIP

CONDUCTOR GRIP

CORRECT POSITION

CORRECT POSITION

WRONG POSITION

NOTE:

*) IF THE CORRECT POSITION IS USED THEN YOU SHOULD NOT GET ANY WIRE STRANDS OUT OF THE CONDUCTOR CRIMP AREA.

*) IF THE WRONG POSITION IS USED THEN YOU ARE AT RISK OF STRANDS OF WIRE OUT OF THE CONDUCTOR CRIMP AREA.

DD-MM-YY HH-MM-YY Release App. Prod. ECD #12/03/06 GRP ***** MFG. SH. REWORK AREA LTR. REMOVES	DIMENSIONS SHOWN (METRIC) INCH		▽ =	▼ =	REVISE ONLY ON CAD SYSTEM												
	UNLESS OTHERWISE SPECIFIED TOLERANCES: ANGULAR ± 1/2°		TITLE		Specification Sheet Terminator												
	<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	---	± ---	MOLEX INCORPORATED	
		INCH	METRIC														
3 PLACE	± ---	---															
2 PLACE	± ---	± ---															
1 PLACE	---	± ---															
DRAFT WHERE APPLICABLE MUST REMAIN WITHIN DIMENSIONS		LISLE, ILL. 60532 U.S.A.		1 OF 4 96/03/06													
DRWG. BY MFS	CHK'D. BY MFS	PART NO. 638406300		DRWG. NO. 638406300													
APP'D. BY	SCALE	FILE NAME 6384063 S80		THIS DRAWING CONTAINS INFORMATION THAT IS PROPRIETARY TO MOLEX INC. AND SHOULD NOT BE USED WITHOUT WRITTEN PERMISSION.													
				DIV. AT	SIZE A												

CRIMP

C. SPECIFICATION

NO. OF FIG.	ITEM	REQUIREMENT
1	BEND UP	3°
	BEND DOWN	3°
	TWISTING	4°
	ROLLING	8°
2	BELL MOUTH (FLARE)	0.10-0.40
3	CUT-OFF TAB LENGTH	0.5 MAX.
4	EXTRUDED WIRE LENGTH (BRUSH)	1.50 MAX
5	SEAM	SEAM SHALL NOT BE OPENED AND NO WIRE ALLOWED OUT OF THE CRIMPING AREA.
6		
7		

D. CONDITIONS

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

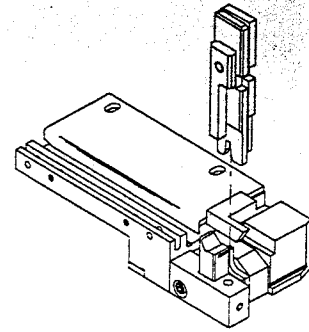
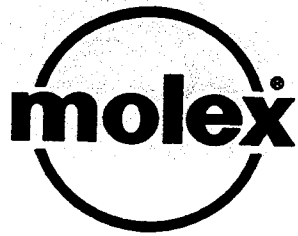
TERMINAL SERIES	WIRE AWG	CRIMP HEIGHT		CRIMP WIDTH (REF.)		PULL FORCE MINIMUM	
		ENGLISH	(METRIC)	ENGLISH	(METRIC)	LBS.	(N)
43178-2001	14	.078 - .082	(1.98 - 2.08)	.126	(3.20)	50	(222)
	16	.074 - .078	(1.88 - 1.98)			30	(133)
	18	.070 - .074	(1.78 - 1.88)			20	(88.9)
	18 DBL	.077 - .081	(1.96 - 2.06)			20	(88.9)
		-	(-)				()
		-	(-)		()		()
		-	(-)		()		()
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		-	(-)		()		()

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

MFG. SII. REV.	A	L IR.	DRWG. BY KDP	CHK'D. BY MFS	SCALE :	DIMENSIONS SHOWN (METRIC) INCH		= = REVISE ONLY ON CAD SYSTEM											
						UNLESS OTHERWISE SPECIFIED TOLERANCES: ANGULAR ± 1/2°		TITLE											
Release for Prod. ECN #096506 12-05-96 KDP		<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		SHEET NO. DATE	
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		DRAFT WHERE APPLICABLE MUST REMAIN WITHIN DIMENSIONS		MOLEX INCORPORATED		2 OF 4 96/12/05													
				LISLE, ILL. 60532 U.S.A.															
				PART NO. 638406300		DRWG. NO. 638406300													
				FILE NAME 6384063		THIS DRAWING CONTAINS INFORMATION THAT IS PROPRIETARY TO MOLEX INC. AND SHOULD NOT BE USED WITHOUT WRITTEN PERMISSION.													
				S8		DIV. SIZE AT A													



APPLICATOR ASSEMBLY - PARTS LIST

ITEM	ORDER NO.	SIZE	ENG. NO.	DESCRIPTION	REQ'D
4	634430021	b	634430021	Mounting Key	1
5	11-18-5415	b	60842a111	Anvil Mount	1
10	11-40-4039	b	8302-5	Plunger Striker	1
11	638406011	b	638406011	Wire Stop	1
13	11-40-4068	b	8302-102	Drag Finger	1
14	11-40-4231	b	8329-10	Stop Finger	1
15	11-18-5440	b	60842a117	Rear Cover	1
16	11-40-4069	b	8302-103	Pivot Pin	2
17	11-40-4144	b	8302-110	Torsion Spring, Drag Finger	1
18	11-40-4145	b	8302-111	Torsion Spring, Stop Finger	1
19	637000539	b	637000539	HEAVY DUTY CUT-OFF PLUNGER SPRING	1
21	634430009	b	634430009	SCRAP CHUTE	1

TOOLING INFORMATION

ITEM	ORDER NO.	SIZE	ENG. NO.	DESCRIPTION	REQ'D
2	634430012	B	634430012	Front Plunger Retainer	1
3	634430002	B	634430002	Front Cutoff Plunger	1
6	634443217	b	634443217	Conductor Punch	1
7	634453262	b	634453262	Conductor Anvil	1
8	6344648-65	b	6344648-65	Insulation Punch (non-tip)	1
9	634454817	b	634454817	Insulation Anvil	1
10	638406370	/	638406370	Toolkit (above items)	0

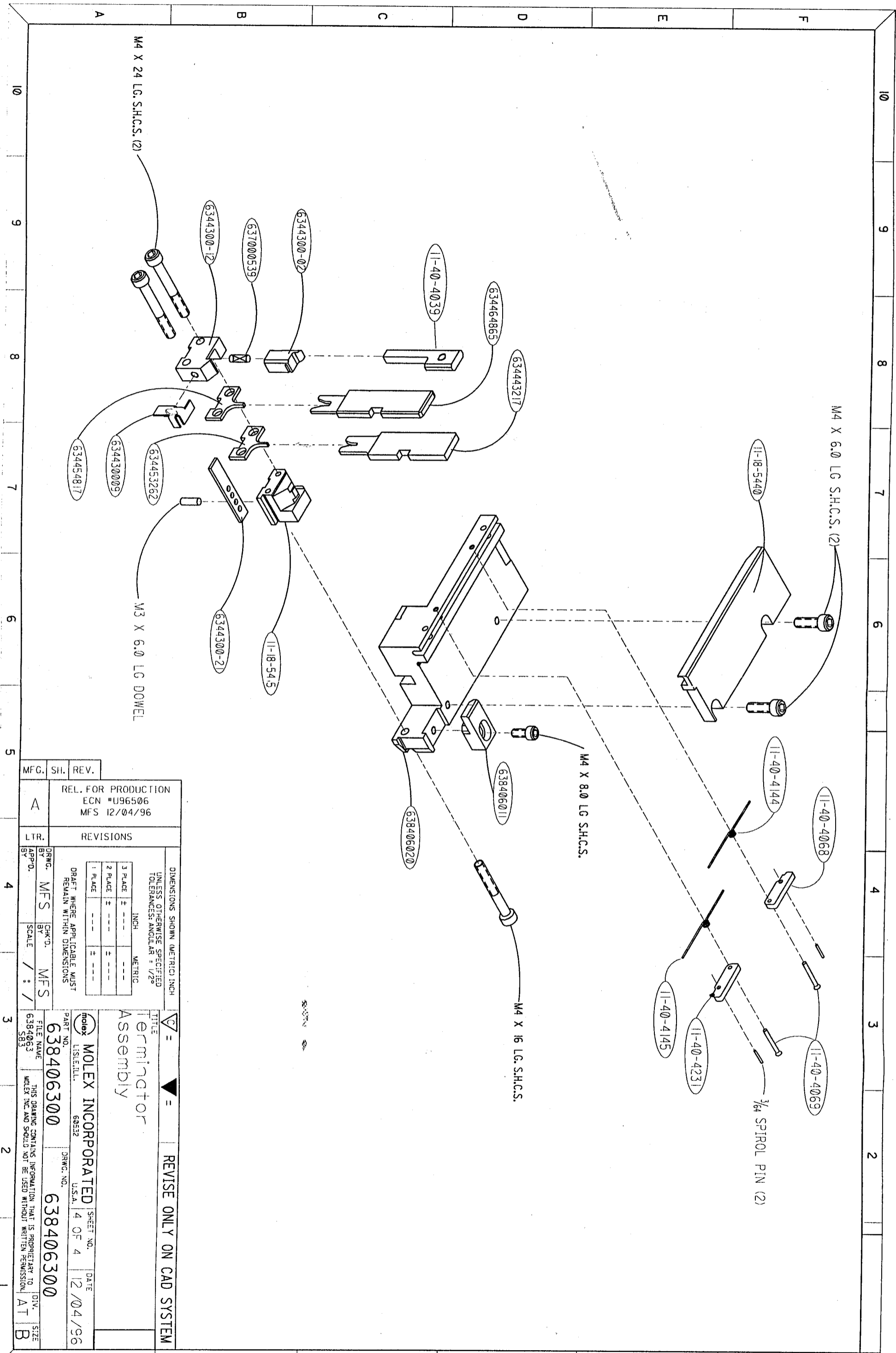
Collect THIS (no spec)

FRAME ASSEMBLY PARTS LIST

ITEM	ORDER NO.	SIZE	ENG. NO.	DESCRIPTION	REQ'D
20	638406020	C	638406020	Terminal Track	1

CRIMP

MFG. SH. REV.	RELEASE FOR PRODUCTION MFS 12-04-96 ECN #U96506	REVISIONS	DIMENSIONS SHOWN (METRIC) INCH		REVISIONS	
			UNLESS OTHERWISE SPECIFIED TOLERANCES: ANGULAR = 1/2°		TITLE	
A			INCH METRIC		BILL OF MATERIALS	
			3 PLACE ± ---	---	TERMINATOR	
			2 PLACE ± ---	± ---	MOLEX INCORPORATED	
			1 PLACE ---	± ---	SHEET NO. DATE	
			DRAFT WHERE APPLICABLE MUST REMAIN WITHIN DIMENSIONS		3 OF 4 2/04/96	
			DRWC. BY MFS	CHK'D. BY MFS	PART NO. DRWG. NO.	
			APP'D. BY	SCALE /: /	638406300 638406300	
					FILE NAME THIS DRAWING CONTAINS INFORMATION THAT IS PROPRIETARY TO MOLEX INC. AND SHOULD NOT BE USED WITHOUT WRITTEN PERMISSION.	
					DIV. SIZE AT A	



MFG.	SII.	REV.
A		
REL. FOR PRODUCTION ECN #U96506 MFS 12/04/96		
LTR.	REVISIONS	
BY	DATE	DESCRIPTION
BY	DATE	DESCRIPTION
DIMENSIONS SHOWN (METRIC) INCH UNLESS OTHERWISE SPECIFIED TOLERANCES: ANGULAR = 1/2°		
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MOLEX INCORPORATED		SHEET NO.
U.S.A.		4 OF 4
DATE		12/04/96
DIV.		AT
SIZE		B

REVISIONS

termiator
Assembly

MOLEX INCORPORATED
U.S.A.

CRIMP