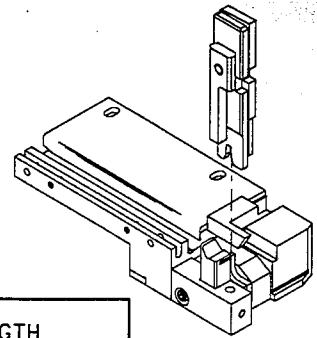




# APPLICATION TOOLING TERMINATOR DIE SPECIFICATION SHEET



## TERMINAL SPECIFICATION

| TERMINAL SERIES | WIRE SIZE |     | INSULATION DIAMETER |               | STRIP LENGTH |               |
|-----------------|-----------|-----|---------------------|---------------|--------------|---------------|
|                 | AWG       |     | ENGLISH             | (METRIC)      | ENGLISH      | (METRIC)      |
| - VER.          | MIN       | MAX |                     |               |              |               |
| 43375-0001      | 18        | 14  | .093 - .140         | (2.36 - 3.56) | .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    | 634442513  | B    | 634442513  | CONDUCTOR PUNCH                | 1     |
| 7    | 634452562  | B    | 634452562  | CONDUCTOR ANVIL                | 1     |
| 8    | 634463937  | B    | 634463937  | INSULATION PUNCH               | 1     |
| 9    | 634453947  | B    | 634453947  | INSULATION ANVIL               | 1     |
| ***  | 6384050-70 |      | 6384050-70 | TOOL KIT (ALL THE ABOVE ITEMS) | 1     |

## CRIMP SPECIFICATION

| WIRE AWG | CRIMP HEIGHT |               | CRIMP WIDTH (REF.) |          | PULL FORCE MINIMUM |        |
|----------|--------------|---------------|--------------------|----------|--------------------|--------|
|          | ENGLISH      | (METRIC)      | ENGLISH            | (METRIC) | LBS.               | (N)    |
| 14       | .065 - .069  | (1.65 - 1.75) | .098               | (2.50)   | 60                 | (266)  |
| 16       | .058 - .062  | (1.47 - 1.57) | .098               | (2.50)   | 30                 | (133)  |
| 18       | .053 - .056  | (1.35 - 1.43) | .098               | (2.50)   | 20                 | (88.9) |
|          | -            | ( - )         |                    | ( )      |                    | ( )    |
|          | -            | ( - )         |                    | ( )      |                    | ( )    |

## NOTES:

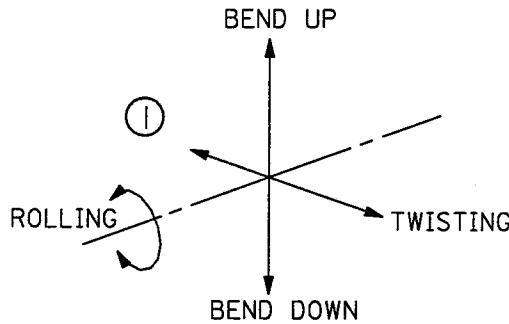
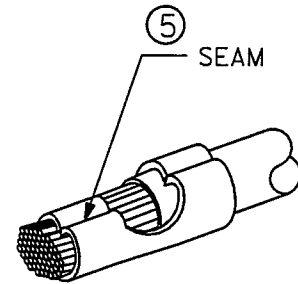
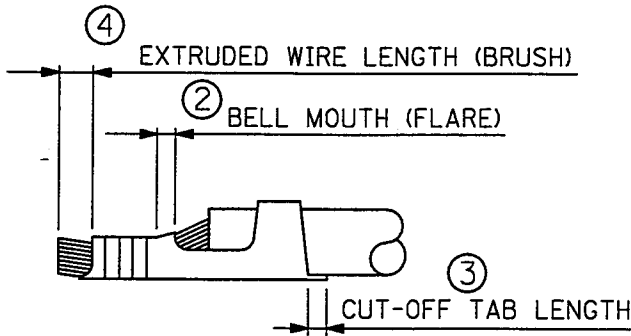
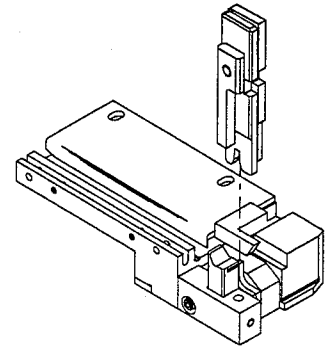
1. WE RECOMMEND AN EXTRA SET OF PERISHABLE TOOLING BE MAINTAINED IN YOUR FACTORY.
2. VERIFY TOOLING ALIGNMENT BY MANUALLY CYCLING THE PRESS AND DIE BEFORE CRIMPING UNDERPOWER. CHECK THAT ALL SCREWS ARE TIGHT.
3. SLUGS, TERMINALS, DIRT AND OIL SHOULD BE KEPT CLEAR OF WORK AREA.
4. CRIMP HEIGHT MAY VARY DEPENDING ON STYLE AND WIRE TYPE.
5. TO PREVENT INJURY - NEVER OPERATE THIS TOOL WITHOUT THE GUARDING SUPPLIED WITH THE PRESS IN PLACE.

**CRIMP**

| <div style="border: 2px solid black; padding: 5px; transform: rotate(-45deg); display: inline-block;">             DD-MMM-YY<br/>HH:MM<br/>REV. BDL OF MATERIALS<br/>PER FCN 049160A<br/>09-13-97 KDP<br/>REVISIONS<br/>MFG. SH. REV. WORK<br/>L.T.R.           </div> | DIMENSIONS SHOWN (METRIC) INCH   |  | $\nabla =$ $\blacktriangledown =$ |           | REVISE ONLY ON CAD SYSTEM |           |           |       |         |            |           |            |     |           |  |  |                    |           |      |                          |        |          |
|--|--|--|-----------------------------------|-----------|---------------------------|-----------|-----------|-------|---------|------------|-----------|------------|-----|-----------|--|--|--------------------|-----------|------|--------------------------|--------|----------|
|  | UNLESS OTHERWISE SPECIFIED TOLERANCES: ANGULAR $\pm 1/2^\circ$   |  | TITLE                             |           | TERMINATOR DIE ASSEMBLY   |           |           |       |         |            |           |            |     |           |  |  |                    |           |      |                          |        |          |
|  | <table border="1"> <thead> <tr> <th></th> <th>INCH</th> <th>METRIC</th> </tr> </thead> <tbody> <tr> <td>3 PLACE</td> <td><math>\pm</math> ---</td> <td>---</td> </tr> <tr> <td>2 PLACE</td> <td><math>\pm</math> ---</td> <td><math>\pm</math> ---</td> </tr> <tr> <td>1 PLACE</td> <td>---</td> <td><math>\pm</math> ---</td> </tr> </tbody> </table> |  |                                   | INCH      | METRIC                    | 3 PLACE   | $\pm$ --- | ---   | 2 PLACE | $\pm$ ---  | $\pm$ --- | 1 PLACE    | --- | $\pm$ --- | <table border="1"> <tr> <td>MOLEX INCORPORATED</td> <td>SHEET NO.</td> <td>DATE</td> </tr> <tr> <td>LISLE, ILL. 60532 U.S.A.</td> <td>1 of 4</td> <td>03/03/95</td> </tr> </table> |  | MOLEX INCORPORATED | SHEET NO. | DATE | LISLE, ILL. 60532 U.S.A. | 1 of 4 | 03/03/95 |
|  |  | INCH   | METRIC                            |           |                           |           |           |       |         |            |           |            |     |           |  |  |                    |           |      |                          |        |          |
| 3 PLACE  | $\pm$ ---  | ---  |                                   |           |                           |           |           |       |         |            |           |            |     |           |  |  |                    |           |      |                          |        |          |
| 2 PLACE  | $\pm$ ---  | $\pm$ ---  |                                   |           |                           |           |           |       |         |            |           |            |     |           |  |  |                    |           |      |                          |        |          |
| 1 PLACE  | ---  | $\pm$ ---  |                                   |           |                           |           |           |       |         |            |           |            |     |           |  |  |                    |           |      |                          |        |          |
| MOLEX INCORPORATED   | SHEET NO.  | DATE   |                                   |           |                           |           |           |       |         |            |           |            |     |           |  |  |                    |           |      |                          |        |          |
| LISLE, ILL. 60532 U.S.A.   | 1 of 4   | 03/03/95   |                                   |           |                           |           |           |       |         |            |           |            |     |           |  |  |                    |           |      |                          |        |          |
| DRAFT WHERE APPLICABLE MUST REMAIN WITHIN DIMENSIONS   |  | PART NO.   |                                   | DRWG. NO. |                           |           |           |       |         |            |           |            |     |           |  |  |                    |           |      |                          |        |          |
| <table border="1"> <tr> <td>DRWG. BY</td> <td>SMT</td> <td>CHK'D. BY</td> <td>VS</td> </tr> <tr> <td>APP'D. BY</td> <td></td> <td>SCALE</td> <td>/ : /</td> </tr> </table>   |  | DRWG. BY   | SMT                               | CHK'D. BY | VS                        | APP'D. BY |           | SCALE | / : /   | 6384050-00 |           | 6384050-00 |     |           |  |  |                    |           |      |                          |        |          |
| DRWG. BY   | SMT  | CHK'D. BY  | VS                                |           |                           |           |           |       |         |            |           |            |     |           |  |  |                    |           |      |                          |        |          |
| APP'D. BY  |  | SCALE  | / : /                             |           |                           |           |           |       |         |            |           |            |     |           |  |  |                    |           |      |                          |        |          |
| FILE NAME  |  | THIS DRAWING CONTAINS INFORMATION THAT IS PROPRIETARY TO MOLEX INC. AND SHOULD NOT BE USED WITHOUT WRITTEN PERMISSION. |                                   | DIV. SIZE |                           |           |           |       |         |            |           |            |     |           |  |  |                    |           |      |                          |        |          |
| 6384050-00   |  | S80  |                                   | AT A      |                           |           |           |       |         |            |           |            |     |           |  |  |                    |           |      |                          |        |          |



# APPLICATION TOOLING TERMINATOR DIE SPECIFICATION SHEET



## CRIMP SPECIFICATION

| NO. OF FIG. | ITEM                         | REQUIREMENT  |
|-------------|------------------------------|--|
| 1           | BEND UP                      | 5° MAX   |
|             | BEND DOWN                    | 2° MAX   |
|             | TWISTING                     | 5° MAX   |
|             | ROLLING                      | 5° MAX   |
| 2           | BELL MOUTH (FLARE)           | 0.2 - 0.5mm  |
| 3           | CUT-OFF TAB LENGTH           | 0.2mm MAX  |
| 4           | EXTRUDED WIRE LENGTH (BRUSH) | 0.0 - 0.5 mm   |
| 5           | SEAM                         | SEAM SHALL NOT BE OPENED AND NO WIRE ALLOWED OUT OF THE CRIMPING AREA. |

**CRIMP**

DD-MMM-YY  
 HH:MM  
 REV. BRN. OF MATERIALS  
 PENN. ECN 09/16/04  
 09-15387 KDP  
 REV. 08/04  
 WORK IN PROGRESS  
 MFG. SH. C LTR.

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 SMT    CHK'D. BY VS

APP'D. BY    SCALE / : /

▽ =    ▼ =    REVISE ONLY ON CAD SYSTEM

TITLE: TERMINATOR DIE ASSEMBLY

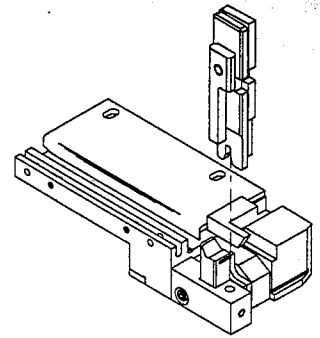
MOLEX INCORPORATED    SHEET NO. 2 of 4    DATE 03/03/95  
 LISLE, ILL. 60532    U.S.A.

PART NO. 6384050-00    DRWG. NO. 6384050-00

FILE NAME 6384050 S81    THIS DRAWING CONTAINS INFORMATION THAT IS PROPRIETARY TO MOLEX INC. AND SHOULD NOT BE USED WITHOUT WRITTEN PERMISSION.    DIV. AT    SIZE A



# APPLICATION TOOLING TERMINATOR DIE SPECIFICATION SHEET



## TOOLING INFORMATION

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| ***  | 6384050-70 |      | 6384050-70 | TOOL KIT (ALL THE ABOVE ITEMS) | 1     |

## TERMINATOR ASSEMBLY - PARTS LIST

| ITEM | ORDER NO.  | SIZE | ENG. NO.  | DESCRIPTION                 | REQ'D |
|------|------------|------|-----------|-----------------------------|-------|
| 5    | 634430012  | B    | 634430012 | CUT-OFF PLUNGER RETAINER    | 1     |
| 10   | 11-40-4039 | B    | 8302-5    | PLUNGER STRIKER             | 1     |
| 11   | 634430021  | B    | 634430021 | MOUNTING KEY                | 1     |
| 12   | 638405012  | B    | 638405012 | ANVIL MOUNT                 | 1     |
| 13   | 11-40-4068 | B    | 8302-102  | DRAG FINGER (L.H.)          | 1     |
| 14   | 638405014  | B    | 638405014 | DRAG FINGER (R.H.)          | 1     |
| 15   |            |      |           |                             |       |
| 16   |            |      |           |                             |       |
| 17   | 638405017  | B    | 638405017 | COVER                       | 1     |
| 18   | 11-24-1067 | A    | 4996-4    | CUT-OFF PLUNGER SPRING      | 1     |
| 19   | 638405019  | B    | 638405019 | WIRE STOP                   | 1     |
| 20   | 638405020  | C    | 638405020 | TERMINAL TRACK              | 1     |
| 21   |            |      |           |                             |       |
| 22   | 11-40-4144 | B    | 8302-110  | TORSION SPRING, DRAG FINGER | 2     |
| 23   |            |      |           |                             |       |
| 24   | 11-40-4069 | B    | 8302-103  | PIVOT PIN                   | 2     |
| 25   |            |      |           |                             |       |
| 26   |            |      |           |                             |       |
| 27   |            |      |           |                             |       |
| 28   |            |      |           |                             |       |
| 29   |            |      |           |                             |       |

**CRIMP**

DD-MMM-YY  
HH:MM

REV. BRD. OF MATERIALS  
PER ECN 0109160A  
09-15-87 KDP

WORK IN PROGRESS

REVISIONS

MFG. SH. REV. C

LTR.

DIMENSIONS SHOWN (METRIC) INCH

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TOLERANCES: ANGULAR ± 1/2°

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DRAFT WHERE APPLICABLE MUST  
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▽ =    ▼ =    REVISE ONLY ON CAD SYSTEM

TITLE

TERMINATOR DIE ASSEMBLY

MOLEX INCORPORATED    SHEET NO.    DATE

LISLE, ILL.    60532    U.S.A.    3 of 4    03/03/95

PART NO.    DRWG. NO.

6384050-00    6384050-00

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6384050    S82    DIV.    SIZE

AT    A

