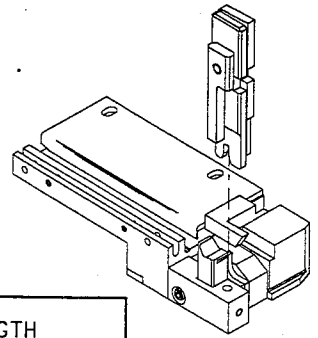




APPLICATION TOOLING TERMINATOR DIE SPECIFICATION SHEET



TERMINAL SPECIFICATION

TERMINAL SERIES	WIRE SIZE		INSULATION DIAMETER		STRIP LENGTH	
	MIN	MAX	ENGLISH	(METRIC)	ENGLISH	(METRIC)
43375-1001	18	14	.120 - .180	(3.05 - 4.57)	.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	634464817	B	634464817	INSULATION PUNCH	1
9	634454814	B	634454814	INSULATION ANVIL	1
***	6384052-70		6384052-70	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)
	-	(-)	()	()	()	()
DBL 18	.058 - .062	(1.47 - 1.57)	.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.

DD-MMM-YYY
 HH:MM
 WORK AREA
 REV. BY: JUS
 ECN: 009
 02-04887 KDP
 REVISIONS
 MFC. SH. RE
 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: / : /

▽ =

REVISIONS

TITLE

TERMINATOR DIE ASSEMBLY

molex MOLEX INCORPORATED
LISLE, ILL. 60532 U.S.A.

SHEET NO. 1 of 4
DATE 03/07/95

PART NO. 6384052-00

DRWG. NO. 6384052-00

FILE NAME
6384052
580

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MOLEX INC. AND SHOULD NOT BE USED WITHOUT WRITTEN PERMISSION.

DIV. AT
SIZE A

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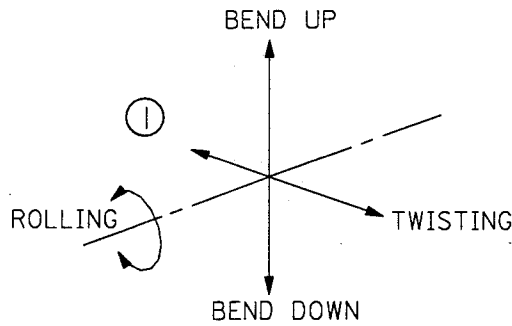
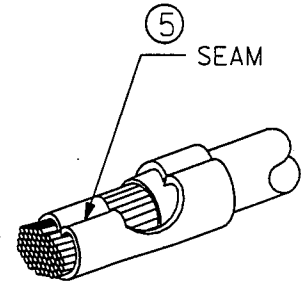
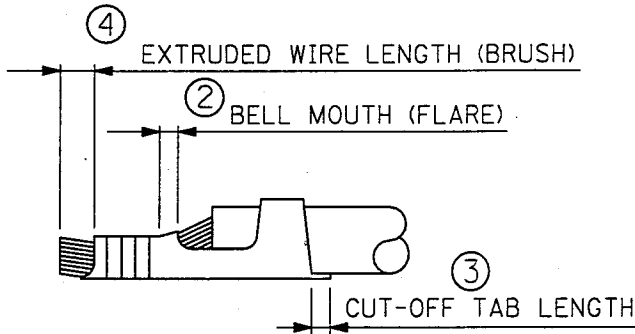
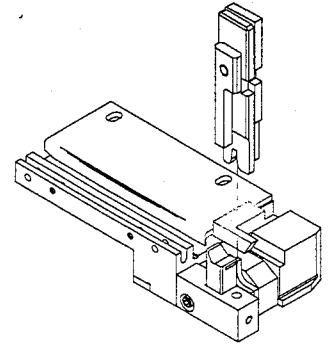
B

C

D



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.

DD-MMM-YY
HH:MM
REV. BDL
ECN # 105
02-01-97
KDP
REVISIONS
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 / : /

▽ =
▲ =
TITLE

REVISE ONLY ON CAD SYSTEM

TERMINATOR DIE ASSEMBLY

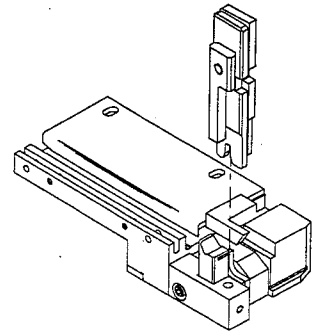
MOLEX INCORPORATED SHEET NO. DATE
LISLE, ILL. 60532 U.S.A. 2 of 4 03/07/95

PART NO. DRWG. NO.
6384052-00 6384052-00

FILE NAME 6384052 S81
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DIV. SIZE
AT A



APPLICATION TOOLING TERMINATOR DIE SPECIFICATION SHEET



TOOLING INFORMATION

ITEM	ORDER NO.	SIZE	ENG. NO.	DESCRIPTION	REQ'D
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9	634454814	B	634454814	INSULATION ANVIL	1
***	6384052-70		6384052-70	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					

	DIMENSIONS SHOWN (METRIC) INCH UNLESS OTHERWISE SPECIFIED TOLERANCES: ANGULAR ± 1/2°	INCH METRIC 3 PLACE = --- --- 2 PLACE = --- ± --- 1 PLACE = --- ± ---	▽ = ▼ = TITLE	REVISE ONLY ON CAD SYSTEM TERMINATOR DIE ASSEMBLY
	DRAFT WHERE APPLICABLE MUST REMAIN WITHIN DIMENSIONS	Molex MOLEX INCORPORATED SHEET NO. DATE LISLE, ILL. 60532 U.S.A. 3 of 4 03/07/95		
	DRWG. BY SMT CHK'D. BY VS APP'D. BY SCALE / : /	PART NO. DRWG. NO. 6384052-00 6384052-00		
	FILE NAME 6384052 S82	THIS DRAWING CONTAINS INFORMATION THAT IS PROPRIETARY TO MOLEX INC. AND SHOULD NOT BE USED WITHOUT WRITTEN PERMISSION.		DIV. SIZE AT A

