



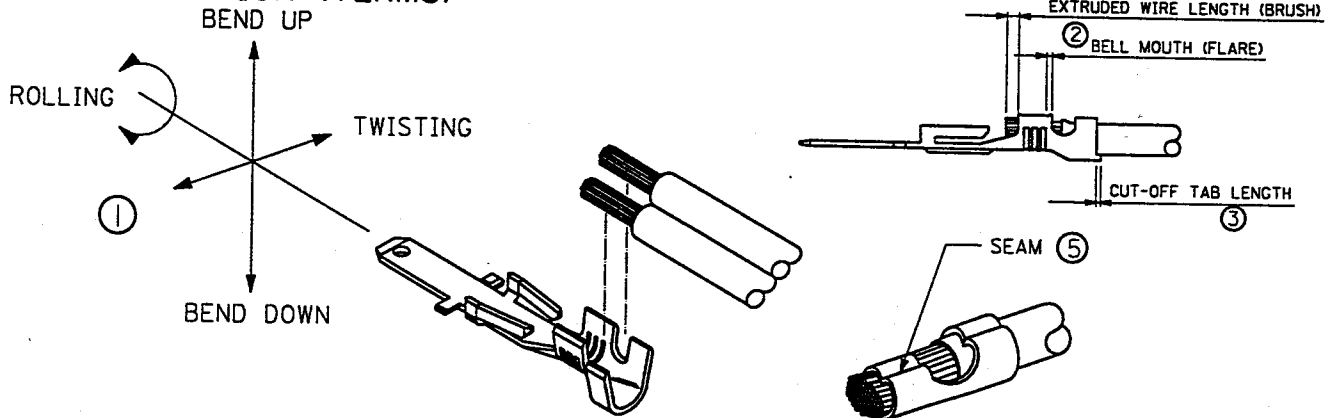
APPLICATION TOOLING TERMINATOR SPECIFICATION SHEET

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 MFS #12/04/96 MFG. SH. REWORK APP. GRP. ***** REVISIONS LTR.	DIMENSIONS SHOWN (METRIC) INCH		▽ =	▼ =	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		
		INCH	METRIC														
3 PLACE	± ---	---															
2 PLACE	± ---	± ---															
1 PLACE	---	± ---															
DRAFT WHERE APPLICABLE MUST REMAIN WITHIN DIMENSIONS		Terminator															
MFG. SH.	A	DRWG. BY MFS	CHK'D. BY MFS	FILE NAME	6384063												
APP'D. BY		SCALE	/: /	THIS DRAWING CONTAINS INFORMATION THAT IS PROPRIETARY TO MOLEX INC. AND SHOULD NOT BE USED WITHOUT WRITTEN PERMISSION.	880												
				MOLEX INCORPORATED	SHEET NO. 1 OF 4												
				LISLE, ILL. 60532 U.S.A.	DATE 96/03/06												
				PART NO. 638406300	DRWG. NO. 638406300												
				SIZE AT 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.

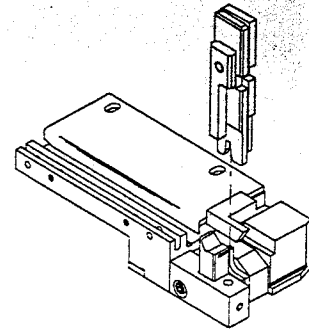
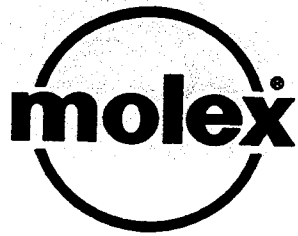
TERMINAL SERIES	WIRE AWG	CRIMP HEIGHT		CRIMP WIDTH (REF.)		PULL FORCE MINIMUM	
		ENGLISH	(METRIC)	ENGLISH	(METRIC)	LBS.	(N)
43178-2001	14	.078 - .082	(1.98 - 2.08)	.126	(3.20)	50	(222)
	16	.074 - .078	(1.88 - 1.98)			30	(133)
	18	.070 - .074	(1.78 - 1.88)			20	(88.9)
	18 DBL	.077 - .081	(1.96 - 2.06)			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		REVISIONS		TITLE		REVISE ONLY ON CAD SYSTEM	
						UNLESS OTHERWISE SPECIFIED TOLERANCES: ANGULAR ± 1/2°		3 PLACE ± ---		SPECIFICATION SHEET		SHEET NO. DATE	
						INCH METRIC		2 OF 4		96/12/05			
						DRAFT WHERE APPLICABLE MUST REMAIN WITHIN DIMENSIONS		MOLEX INCORPORATED		LISLE, ILL. 60532 U.S.A.		PART NO. DRWG. NO.	
								638406300		638406300			
								FILE NAME		THIS DRAWING CONTAINS INFORMATION THAT IS PROPRIETARY TO MOLEX INC. AND SHOULD NOT BE USED WITHOUT WRITTEN PERMISSION.		DIV. SIZE	
								6384063		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

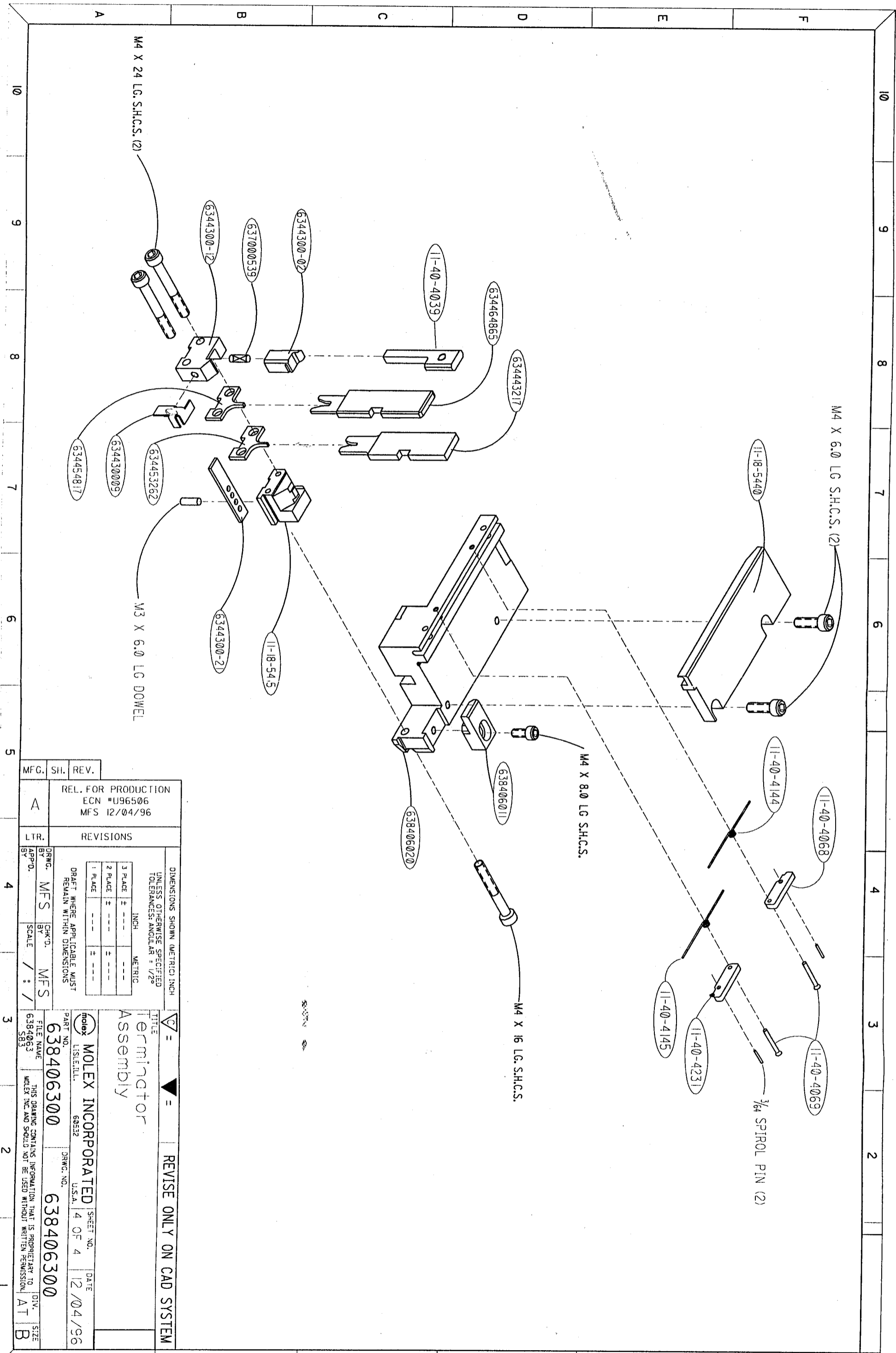
Collect THIS (no spec)

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 ---	± ---	LISE, ILL. 60532 U.S.A. 3 OF 4	
			DRAFT WHERE APPLICABLE MUST REMAIN WITHIN DIMENSIONS		DATE 2/04/96	
			DRWC. BY MFS	CHK'D. BY MFS	PART NO. 638406300	
			APP'D. BY	SCALE /: /	DRWC. NO. 638406300	
					FILE NAME 6384063 S82	
			THIS DRAWING CONTAINS INFORMATION THAT IS PROPRIETARY TO MOLEX INC. AND SHOULD NOT BE USED WITHOUT WRITTEN PERMISSION.			DIV. AT
						SIZE A



MFG.	SII.	REV.
A		
REL. FOR PRODUCTION ECN #U96506 MFS 12/04/96		
LTR.	REVISIONS	
BY	APPD.	SCALE
DRWG. MFS	CHK'D. MFS	
DIMENSIONS SHOWN (METRIC) INCH UNLESS OTHERWISE SPECIFIED TOLERANCES: ANGULAR = 1/2°		
1 PLACE	±	---
2 PLACE	±	---
3 PLACE	±	---
DRAFT WHERE APPLICABLE MUST REMAIN WITHIN DIMENSIONS		
TITLE Terminator Assembly		
MOLEX INCORPORATED		
PART NO.	DRWG. NO.	SHEET NO.
638406300	638406300	4 OF 4
FILE NAME	DATE	
638406300	12/04/96	
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DRWG. NO.	DATE	SIZE
638406300	12/04/96	AT B

CRIMP