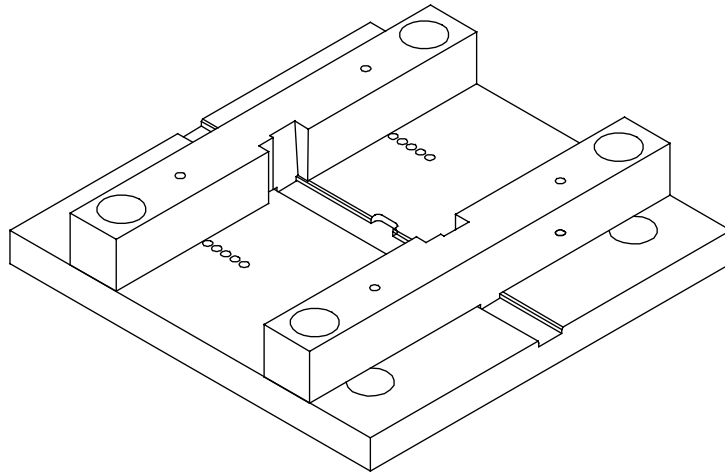




ARBOR PRESS FIXTURE PART No. 69020-2025

FOR MOLEX PRODUCT ENG. No 91317



DESCRIPTION

This fixture is used to terminate Molex connector 91317, 3 to 16 ckt. onto pre-cut ribbon cable.

FEATURES

1. This fixture can only be used in a standard Arbor Press part No. 69020-0660.
2. Adjustable from 3 to 16 ckt.
3. For loose piece terminals only.
4. Hand loading of connector and cable.

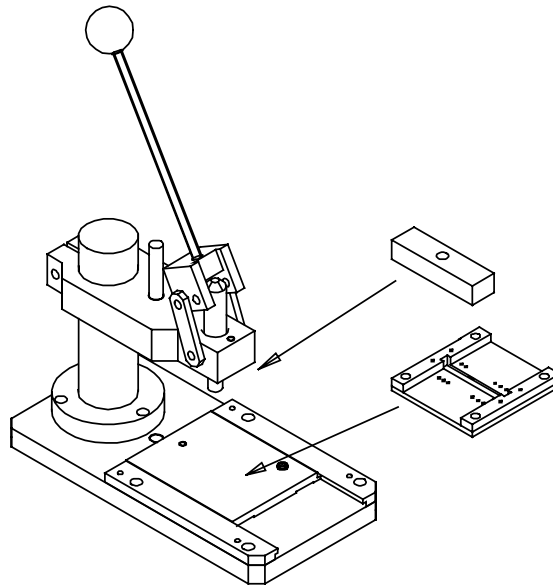
SPECIFICATION

SIZE: 100mm x 100mm x 50mm

WEIGHT: 1.25 kg

WORKING SERVICES: None.

SET-UP



- 1) Place lower termination fixture onto mounting platform of Arbor Press, locating it onto the two mounting pins.
- 2) Adjust positioning bars to keep connector central on the base plate.
- 3) Make a few samples following the next section (operation) and then check termination heights. If adjustment is required see adjustments section.

OPERATION

- 1) Insert connector into lower termination block.
- 2) Push pre-cut ribbon cable into connector.
- 3) Pull handle down fully to terminate connector.
- 4) Turn handle to start position.
- 5) Remove connector from fixture.

ADJUSTMENTS

- 1) If termination height is incorrect then follow the procedure below.
- 2) Loosen the stud nuts in the centre of the Arbor Press.
- 3) Loosen clamp bolt to column at the rear of the Arbor Press.
- 4) Adjust upper part of Arbor Press up or down using the two nuts on the central stud.
- 5) Re-tighten nuts and clamp bolt.
- 6) Recheck termination height.

MAINTENANCE

- 1) Keep fixture clean at all times.
- 2) Clean fixture with brush.
- 3) Oil moving parts weekly, when in use.
- 4) Store in a clean dry environment.

QUALITY

Check termination quality against the Molex wire termination specification for relevant product being terminated eg: PS-90650.

A quality procedure should be in place to monitor output from this fixture.

LIMITATIONS

This Arbor Press Fixture can only be used for product stated in the description of this leaflet.