

C. SPECIFICATION

NO. OF FIG.	ITEM	REQUIREMENT
1	BEND UP	0°
	BEND DOWN	8°
	TWISTING	6°
	ROLLING	10°
2	BELL MOUTH (FLARE)	0.05-0.2 (.002"-.008")
3	CUT-OFF TAB LENGTH	max 0.2 (.008")
4	EXTRUDED WIRE LENGTH (BRUSH)	0-1.0 (0-.039")
5	SEAM	SEAM SHALL NOT BE OPENED AND
		NO WIRE ALLOWED OUT OF THE
		CRIMPING AREA.

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)
50012-8000 50013-8000	24	.026 - .028	(0.65 - 0.72)	.047	(1.2)	5.0	()
	26	.024 - .026	(0.60 - 0.67)			3.0	()
	28	.023 - .025	(0.58 - 0.64)			2.0	()
		-	(-)				()
		-	(-)		()		()
		-	(-)		()		()
		-	(-)		()		()
		-	(-)		()		()
		-	(-)		()		()
		-	(-)		()		()
		-	(-)		()		()
		-	(-)		()		()
		-	(-)		()		()
		-	(-)		()		()

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

	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 LISLE, ILL. 60532 U.S.A.		SHEET NO. 2 of 4	DATE 12 / 13 / 95
		INCH	METRIC															
3 PLACE	± ---	---																
2 PLACE	± ---	± ---																
1 PLACE	---	± ---																
DRAFT WHERE APPLICABLE MUST REMAIN WITHIN DIMENSIONS		PART NO. 63841-5000		DRWG. NO. 638415000														
MFG. SH. RE. B	LTR.	DRWG. BY SMT	CHK'D. BY	FILE NAME 6384150	THIS DRAWING CONTAINS INFORMATION THAT IS PROPRIETARY TO MOLEX INC. AND SHOULD NOT BE USED WITHOUT WRITTEN PERMISSION.													
		APP'D. BY	SCALE /: /	S81	DIV. AT	SIZE A												

APPLICATOR ASSEMBLY - PARTS LIST

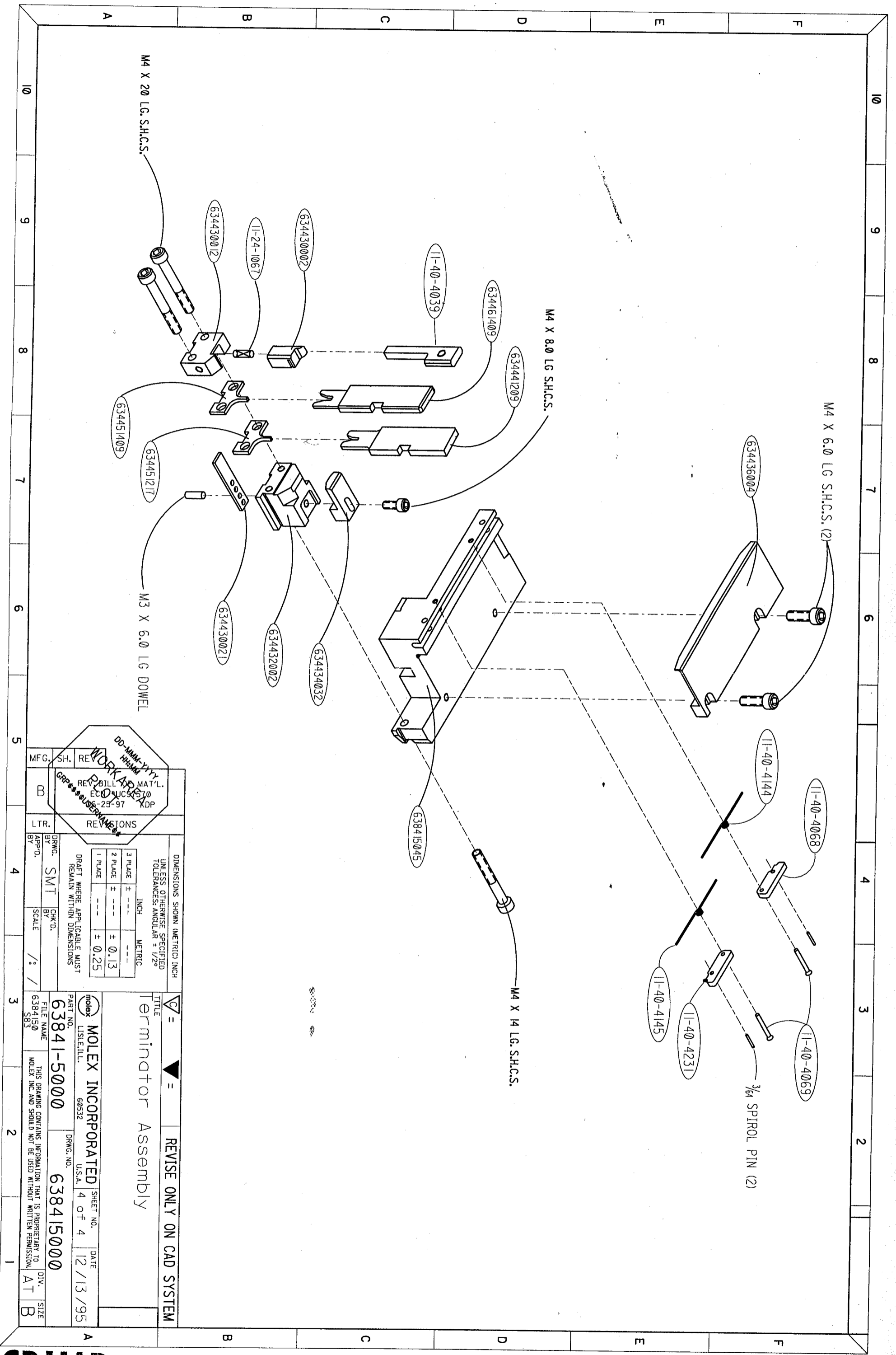
ITEM	ORDER NO.	SIZE	ENG. NO.	DESCRIPTION	REQ'D
6	634430012	b	634430012	Front Plunger Retainer	1
7	11-24-1067	a	4996-4	Cut-off Plunger Spring	1
8	11-40-4039	b	8302-5	Front Plunger Striker	1
9	634430021	b	634430021	Lower Tooling Key	1
10	634432002	b	634432002	Anvil Mount	1
11	634434032	B	634434032	Wire Stop	1
13	634436004	B	634436004	Rear Cover	1
40	11-40-4145	b	8302-111	Torsion Spring	1
41	11-40-4144	b	8302-110	Torsion Spring	1
42	11-40-4069	b	8302-103	Pivot Pin	2
43	11-40-4068	b	8302-102	Drag Finger	1
44	11-40-4231	b	8329-10	Stop Finger	1
45	638415045	c	638415045	Terminal Track	1

TOOLING INFORMATION

ITEM	ORDER NO.	SIZE	ENG. NO.	DESCRIPTION	REQ'D
1	634441209	b	634441209	Conductor Punch	1
2	634451217	b	634451217	Conductor Anvil	1
3	634461409	b	634461409	Insulation Punch	1
4	634451409	b	634451409	Insulation Anvil	1
5	634430002	B	634430002	Cut-off Plunger	1
70	638415070		638415070	ToolKit For Above	1

4-57-95

<p>DD-MMM-YYYY HH:MM</p> <p>WORK AREA</p> <p>REWORK BILL MATL. ESN: PUC3R570 GRP: 000006-25-97 LADP</p> <p>REVISIONS</p> <p>LTR.</p> <p>MFG. SH. REWORK</p> <p>B</p>	DIMENSIONS SHOWN (METRIC) INCH UNLESS OTHERWISE SPECIFIED TOLERANCES: ANGULAR = 1/2°		▽ = ▼ =	REVISE ONLY ON CAD SYSTEM													
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		INCH	METRIC														
	3 PLACE	± ---	---														
2 PLACE	± ---	± ---															
1 PLACE	---	± ---															
DRAFT WHERE APPLICABLE MUST REMAIN WITHIN DIMENSIONS		MOLEX INCORPORATED LISLE, ILL. 60532 U.S.A.		SHEET NO. 3 of 4	DATE 12 / 13 / 95												
DRWG. BY SMT APP'D. BY		CHK'D. BY SCALE /: /		PART NO. 63841-5000 DRWG. NO. 638415000													
FILE NAME 6384150 S82				THIS DRAWING CONTAINS INFORMATION THAT IS PROPRIETARY TO MOLEX INC. AND SHOULD NOT BE USED WITHOUT WRITTEN PERMISSION.													
				DIV. AT	SIZE A												



REVISION ONLY ON CAD SYSTEM

Terminator Assembly

DIMENSIONS SHOWN (METRIC) INCH

UNLESS OTHERWISE SPECIFIED
TOLERANCES: ANGULAR ± 1/2°

3 PLACE	±	---	INCH	METRIC
2 PLACE	±	---	± 0.13	
1 PLACE	---	---	± 0.25	

DRAFT WHERE APPLICABLE MUST
REMAIN WITHIN DIMENSIONS

DD-MMM-YY
MFG. SH. RE. HHHMM
WORK AREA
REV. BILL. MAT'L.
ECC. W.C.S. 510
6-29-97
GPP...
REV. NAME

LTR. REV. NAME

DRWG. BY: SMT
APP'D. BY: GKK/D.
SCALE: /: /

MOLEX INCORPORATED U.S.A.

PART NO. 638415000

LISTE/ILL. 60532

DRWG. NO. 638415000

SHEET NO. 4 OF 4

DATE 12/13/95

FILE NAME 6384150

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DIV. AT B

SIZE B