

AM-60079-2

11-21-9757

(42219 & 42254 SPOX)

ARBOR PRESS

OPERATION & SET-UP
MANUAL

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MOLEX INCORPORATED, 2222 WELLINGTON COURT, Lisle ILLINOIS (708) 969-4550

AM-60079-2

2.5MM ARBOR PRESS TERMINATOR

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AM-60079-2

2.5MM ARBOR PRESS TERMINATOR

DESCRIPTION

The Molex AM-60079-2 application tool was developed as a low cost, low volume, ribbon cable terminator.

An operator places a connector on the loading platform (AM-60079T112) and slides it right until contacting the positive stop under the track cover.

Next, the operator slides ribbon cable along the right cable guide until touching the wire stop above the connector. With ribbon cable in position, pull the press handle to full down position and return to full up position.

To remove the completed harness slide the housing to the left out of the nest.

SPECIFICATIONS

Physical Dimensions: Length 10 1/2"
Width 6"
Height 21"
Weight 41 lbs.

Maximum Ram force : 3,000 lbs.

Ram Stroke : 1.750

INSTALLATION

Fasten the press to a stable bench or work surface. Two holes sized for 5/16 lag screws are provided in the base of the press.

OPERATING INSTRUCTIONS

1. Ram Operation

To cycle the press, pull Ram Handle (AM-60026-23) from full up position to full down position and return.

2. Anti-Back-Up

To ensure a complete termination the basic press is equipped with an anti-back-up system. This guarantees full down stroke and full return. To temporarily disengage the anti-back-up, there is a release lever (AM-60026-18) located on the inner side of the frame (LH) (AM-60026-3). Pulling up and holding the release lever (AM-60026-18) will allow the ram handle (AM-60026-23) to move freely in either direction.

ADJUSTMENTS

1. Reversible Ram Handle

The press ram handle (AM-60026-23) can be reversed for left or right hand operation. To change the ram handle (AM-60026-23) from right side to left side, remove 1/4 - 20 S.H.C.S. from the lower portion of the ram arm (AM-60026-22). Remove the arm/handle assembly and rotate 180 degrees. Replace the 1/4 - 20 S.H.C.S. and tighten securely.

2. Ram Adjustment

Use the ram adjust screw (AM-60026-7) to adjust the depth of any tooling used on the ram (AM-60026-6). An indicator is engraved on the ram (AM-60026-6) just above the ram adjust screw (AM-60026-7). To increase depth, turn the ram adjust screw (AM-60026-7) to the left, (CW) toward the "+" sign. To decrease the depth, turn to the right, (CCW) toward the "-" sign.

GENERAL MAINTENANCE

The following components should be kept clean and lubricated sparingly with S.A.E. 10W motor oil or equivalent.

| | |
|----------------------------|-------------|
| Ram Cam (cam path) | AM-60026-11 |
| Cam Shaft | AM-60026-12 |
| Cam Shaft Bearings | AM-60026028 |
| Cam Follower | AM-60026-13 |
| Ram Cam Detent (ball) | AM-60026-32 |
| Ram (all four sides) | AM-60026-6 |
| Ram Roller Bearings | AM-60026-10 |
| Anti-Back-Up Pawl (pivot) | AM-60026016 |
| Anti-Back-Up Release Pivot | AM-60026-19 |

NOTE: For illustration of lubrication points, see Figure 1.

AM-60079T1

2.5MM DISCRETE WIRE TERMINATOR MODULE

DESCRIPTION

When assembled to a basic press, the AM-60079T2 terminator module will terminate and crimp the following Molex connectors:

#42219 Female Connector
#42254 Male Connector

The module was designed for low volume, prototype production requiring the operator to break off the terminal carrier strip as a secondary operation outside the press after termination.

INSTALLATION

1. Punch Holder to Ram

With the ram handle (AM-60026-23) in full up position slip tooling holder (AM-60063-2) on to the ram (AM-60026-6) and gently push up until it stops. While maintaining a light upward force on the tooling holder (AM-60063-2), push the latch (AM-60037-5) to the rear and release. This allows the tooling holder (AM-60063-2) to shift up and the latch (AM-60037-5) to lock into the groove on the ram adjust screw (AM-60026-7).

2. Mounting Plate to Basic Press

Slide the mounting plate (AM-60079-T111) on the press base (AM-60026-1) so the slots on both sides of the nest base (AM-60038-2) capture the nest mounting screws.

-----DO NOT TIGHTEN SCREWS-----

Slowly pull down the ram handle (AM-60026-23) to bring alignment pins (AM-60079T109 & AM-60079T110) down to engage in the guide holes. When the ram handle (AM-60026-23) is full down the nest base (AM-60038-2) is properly aligned. Tighten the nest mounting screws securely.

PERISHABLE PARTS LIST

This perishable parts list contains information for the identification and ordering of parts for the AM-60079T2 terminator module which might require replacement due to wear or other damage. Always specify both the Engineering No. and the E.D.P. No. when ordering replacement parts.

| <u>Description</u> | <u>Qty.</u> | <u>Eng. No.</u> | <u>E.D.P. No.</u> |
|--------------------------|-------------|-----------------|-------------------|
| Pilot Pin | 15 | AM-60079T101 | 11-31-8718 |
| 1st Termination Blade | 1 | AM-60079T103 | 11-31-8720 |
| Center Termination Blade | 1 | AM-60079T104 | 11-31-8721 |
| 3rd Termination Blade | 1 | AM-63179T105 | 11-32-6125 |
| Crimp Blade | 1 | AM-63179T106 | 11-32-6126 |

MOLEX ATD. PARTS LIST- A

10-87

ENGR.EPB

DATE 2-17-90

SHEET 1 OF 1

| TITLE: 2.5mm ARBOR PRESS TOOLING (FOR CABLF) | | | | | | | | | | | |
|--|-------------|------------|--------------|-----|---------|--------------------------|------|------------|-----------|-------|----------|
| LV# | SHIT OR DET | EDP # | ENG # | REV | DWG SIZ | DESCRIPTION | QTY. | GROUP CODE | ITEM TYPE | NOTES | HR ROUTE |
| 1 | - | 11-31-8718 | AM-60079T101 | | B | PILOT PIN | 15 | | | | |
| 2 | - | 11-31-8719 | AM-60079T102 | B | B | UPPER NEST | 1 | | | | |
| 3 | - | 11-31-8720 | AM-60079T103 | A | B | 1st. TERMINATION BLADE | 1 | | | | |
| 4 | - | 11-31-8721 | AM-60079T104 | A | B | CENTER TERMINATION BLADE | 1 | | | | |
| 5 | - | 11-31-8722 | AM-60079T105 | A | B | 3rd. TERMINATION BLADE | 1 | | | | |
| 6 | - | 11-31-8723 | AM-60079T106 | A | B | CRIMP BLADE | 1 | | | | |
| 7 | - | 11-31-8724 | AM-60079T107 | | B | TOOLING ADAPTOR PLATE | 1 | | | | |
| 8 | - | 11-31-8725 | AM-60079T108 | | B | PIN RETAINER | 1 | | | | |
| 9 | - | 11-31-8726 | AM-60079T109 | | B | ALIGNMENT PIN | 1 | | | | |
| 10 | - | 11-31-8727 | AM-60079T110 | | B | ALIGNMENT PIN | 1 | | | | |
| 11 | - | 11-31-8728 | AM-60079T111 | A | B | MOUNTING PLATE | 1 | | | | |
| 12 | - | 11-31-8729 | AM-60079T112 | | C | TRACK | 1 | | | | |
| 13 | - | 11-31-8730 | AM-60079T113 | A | B | TRACK COVER | 1 | | | | |
| 14 | - | 11-31-8731 | AM-60079T114 | | B | HOUSING STOP | 1 | | | | |
| 15 | 1 | 11-32-2610 | AM-60079T201 | | B | ADAPTOR BLOCK | 1 | | | | |
| 16 | - | 11-31-8733 | AM-60079T116 | A | B | WIRE PLATFORM | 1 | | | | |
| 17 | 2 | 11-32-2630 | AM-60079T202 | | B | CABLE GUIDE | 1 | | | | |
| 18 | | | | | | | | | | | |
| 19 | - | 11-31-7558 | AM-60063-2 | | B | TOOLING HOLDER | 1 | | | | |
| 20 | - | 11-31-7151 | AM-60037-5 | | B | LATCH | 1 | | | | |
| 21 | - | 11-31-7152 | AM-60037-6 | | A | SPRING,LATCH | 1 | | | | |
| 22 | | | | | | | | | | | |
| 23 | | | | | | | | | | | |
| 24 | | | | | | | | | | | |

ENG#: 11-32-1956

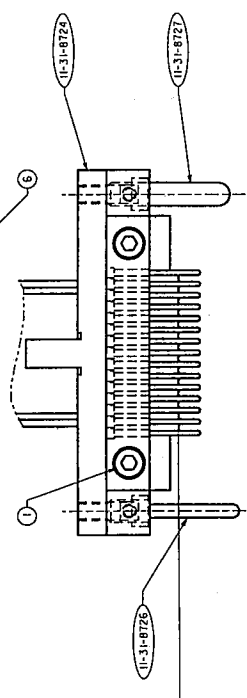
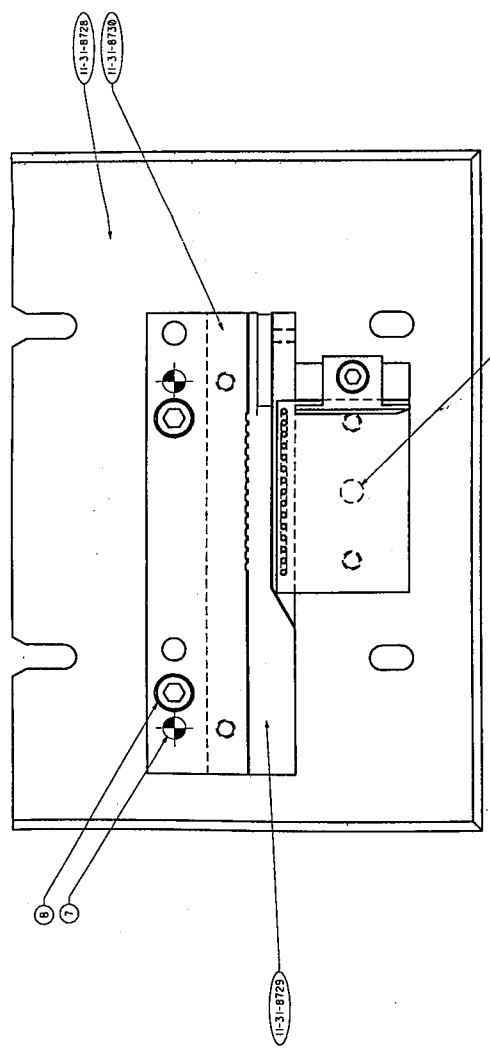
AM-60079T2

REV. A

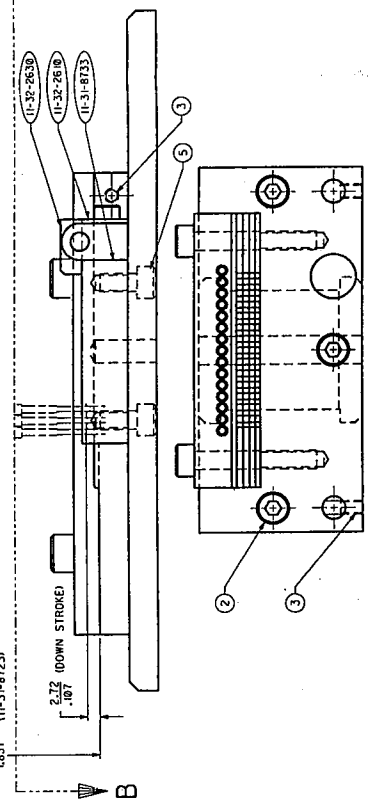
BILL OF FASTENERS

| QTY. | DESCRIPTION |
|------|---------------------------|
| 2 | M3 X .70 S.S.C.S. 25x1.6 |
| 2 | M3 X .70 S.S.C.S. 10x1.6 |
| 3 | M3 X .70 S.S.C.S. 20x1.6 |
| 4 | M3 X .70 S.S.C.S. 30x1.6 |
| 4 | M3 X .70 S.S.C.S. 40x1.6 |
| 5 | M3 X .70 S.S.C.S. 50x1.6 |
| 6 | M3 X .70 S.S.C.S. 60x1.6 |
| 7 | M3 X .70 S.S.C.S. 70x1.6 |
| 8 | M3 X .70 S.S.C.S. 80x1.6 |
| 8 | M3 X .70 S.S.C.S. 100x1.6 |

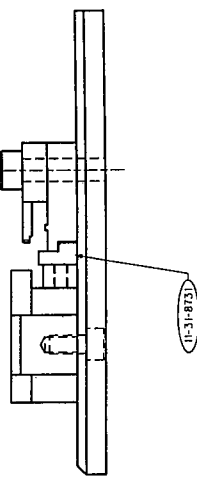
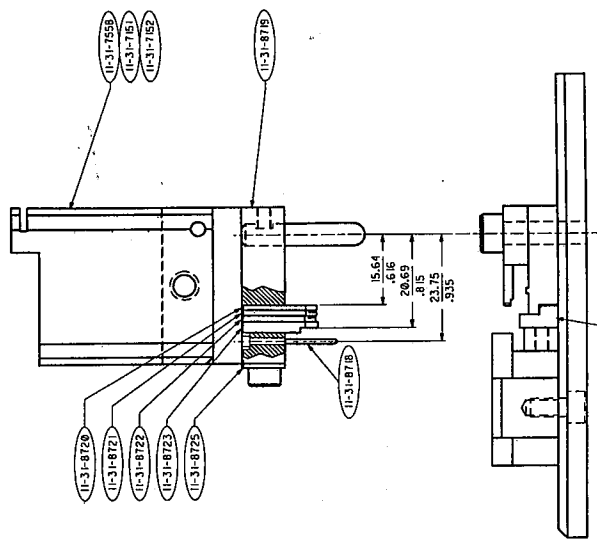
VIEW B-B



2.72 (DOWN STROKE)
 .107
 47.17
 TO GROUP RANGE
 11-31-8723



VIEW A-A



| REV | DATE | DESCRIPTION |
|-----|------|---------------------------|
| 1 | | REVISE ONLY ON CAD SYSTEM |
| 2 | | ARBOR PRESS TOOLING |
| 3 | | 2.5mm |
| 4 | | 15 Ckt. MAX. CABLE |
| 5 | | BEST PERFORMANCE |
| 6 | | 3/20/93 |
| 7 | | 11-32-9556 |
| 8 | | AM-6087912 |
| 9 | | 11-31-8728 |
| 10 | | 11-31-8728 |
| 11 | | 11-31-8728 |
| 12 | | 11-31-8728 |
| 13 | | 11-31-8728 |
| 14 | | 11-31-8728 |
| 15 | | 11-31-8728 |
| 16 | | 11-31-8728 |
| 17 | | 11-31-8728 |
| 18 | | 11-31-8728 |
| 19 | | 11-31-8728 |
| 20 | | 11-31-8728 |

11-31-8728

AM-60079

2.5MM ARBOR PRESS TERMINATOR

OPERATION MANUAL

DISCRETE WIRE VERSION

OBSOLETE!

AM-60079

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AM-60079

2.5MM ARBOR PRESS TERMINATOR

DESCRIPTION

The Molex AM-60079 application tool was developed as a low cost, low volume, discrete wire terminator.

An operator places a connector on the loading platform (AM-60079T112) and slides it right until contacting the positive stop under the track cover.

Next, the operator slides discrete wires into the desired slots until touching the wire stop above the connector. With all wires in position, pull the press handle to full down position and return to full up position.

To remove the completed harness, first lift the wire guide (AM-60079T115) out of position to release the wires, then slide the housing out of the nest.

Return the wire guide to closed position.

SPECIFICATIONS

Physical Dimensions: Length 10 1/2"
Width 6"
Height 21"
Weight 41 lbs.

Maximum Ram force : 3,000 lbs.

Ram Stroke : 1.750

INSTALLATION

Fasten the press to a stable bench or work surface. Two holes sized for 5/16 lag screws are provided in the base of the press.

OPERATING INSTRUCTIONS

1. Ram Operation

To cycle the press, pull Ram Handle (AM-60026-23) from full up position to full down position and return.

2. Anti-Back-Up

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GENERAL MAINTENANCE

The following components should be kept clean and lubricated sparingly with S.A.E. 10W motor oil or equivalent.

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| Cam Shaft | AM-60026-12 |
| Cam Shaft Bearings | AM-60026028 |
| Cam Follower | AM-60026-13 |
| Ram Cam Detent (ball) | AM-60026-32 |
| Ram (all four sides) | AM-60026-6 |
| Ram Roller Bearings | AM-60026-10 |
| Anti-Back-Up Pawl (pivot) | AM-60026016 |
| Anti-Back-Up Release Pivot | AM-60026-19 |

NOTE: For illustration of lubrication points, see Figure 1.

AM-60079T1

2.5MM DISCRETE WIRE TERMINATOR MODULE

DESCRIPTION

When assembled to a basic press, the AM-60079T1 terminator module will terminate and crimp the following Molex connectors:

#42219 Female Connector
#42254 Male Connector

The module was designed for low volume, prototype production requiring the operator to break off the terminal carrier strip as a secondary operation outside the press after termination.

INSTALLATION

1. Punch Holder to Ram

With the ram handle (AM-60026-23) in full up position slip tooling holder (AM-60063-2) on to the ram (AM-60026-6) and gently push up until it stops. While maintaining a light upward force on the tooling holder (AM-60063-2), push the latch (AM-60037-5) to the rear and release. This allows the tooling holder (AM-60063-2) to shift up and the latch (AM-60037-5) to lock into the groove on the ram adjust screw (AM-60026-7).

2. Mounting Plate to Basic Press

Slide the mounting plate (AM-60079-T111) on the press base (AM-60026-1) so the slots on both sides of the nest base (AM-60038-2) capture the nest mounting screws.

-----DO NOT TIGHTEN SCREWS-----

Slowly pull down the ram handle (AM-60026-23) to bring alignment pins (AM-60079T109 & AM-60079T110) down to engage in the guide holes. When the ram handle (AM-60026-23) is full down the nest base (AM-60038-2) is properly aligned. Tighten the nest mounting screws securely.

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|--------------------------|-------------|-----------------|-------------------|
| Pilot Pin | 15 | AM-60079T101 | 11-31-8718 |
| 1st Termination Blade | 1 | AM-60079T103 | 11-31-8720 |
| Center Termination Blade | 1 | AM-60079T104 | 11-31-8721 |
| 3rd Termination Blade | 1 | AM-60079T105 | 11-31-8722 |
| Crimp Blade | 1 | AM-60079T106 | 11-31-8723 |