



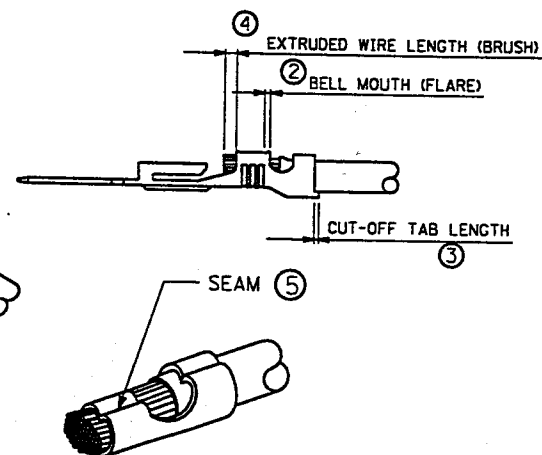
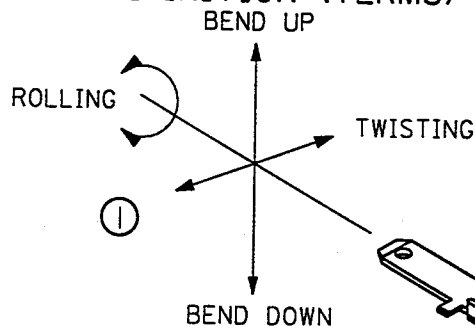
APPLICATION TOOLING TERMINATOR SPECIFICATION SHEET

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	(METRIC)
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

CONDUCTOR GRIP

INSULATION GRIP

CORRECT
POSITION

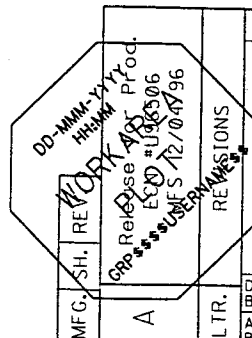
CORRECT
POSITION

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.



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 MFS CHK'D. BY MFS
APP'D. BY SCALE /: /



△ =



▽ =

REVISE ONLY ON CAD SYSTEM

TITLE

Specification Sheet
Terminator



MOLEX INCORPORATED

LISLE, ILL.

60532

U.S.A.

SHEET NO.

1 OF 4

DATE

96/03/06

PART NO.

638406300

DRWG. NO.

638406300

FILE NAME

6384063
S80

THIS DRAWING CONTAINS INFORMATION THAT IS PROPRIETARY TO
MOLEX INC. AND SHOULD NOT BE USED WITHOUT WRITTEN PERMISSION.

DIV.

AT

SIZE

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.

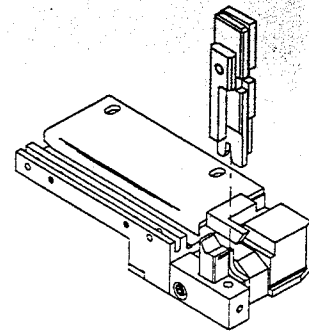
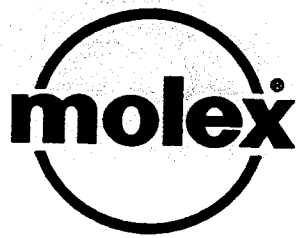
TERMINAL SERIES	WIRE AWG	CRIMP HEIGHT		CRIMP WIDTH (REF.)		PULL FORCE MINIMUM	
		ENGLISH	(METRIC)	ENGLISH	(METRIC)	LBS.	(N)
43178-2001	14	.078 - .082	(1.98 - 2.08)	.126	(3.20)	50	(222)
	16	.074 - .078	(1.88 - 1.98)			30	(133)
	18	.070 - .074	(1.78 - 1.88)			20	(88.9)
	18 DBL	.077 - .081	(1.96 - 2.06)			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.	Release for Prod. ECN #096506 12-05-96 KDP	REVISIONS	DIMENSIONS SHOWN (METRIC) INCH		TITLE		REVISE ONLY ON CAD SYSTEM													
			UNLESS OTHERWISE SPECIFIED TOLERANCES: ANGULAR ± 1/2°		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	---	± ---				
	INCH	METRIC																		
3 PLACE	± ---	---																		
2 PLACE	± ---	± ---																		
1 PLACE	---	± ---																		
			DRAFT WHERE APPLICABLE MUST REMAIN WITHIN DIMENSIONS																	
			DRWG. BY KDP	CHK'D. BY MFS	PART NO. 638406300		DRWG. NO. 638406300													
			APP'D. BY	SCALE	FILE NAME 6384063 S8		THIS DRAWING CONTAINS INFORMATION THAT IS PROPRIETARY TO MOLEX INC. AND SHOULD NOT BE USED WITHOUT WRITTEN PERMISSION.													
					SHEET NO. 2 OF 4		DATE 96/12/05													
					DIV. AT		SIZE 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

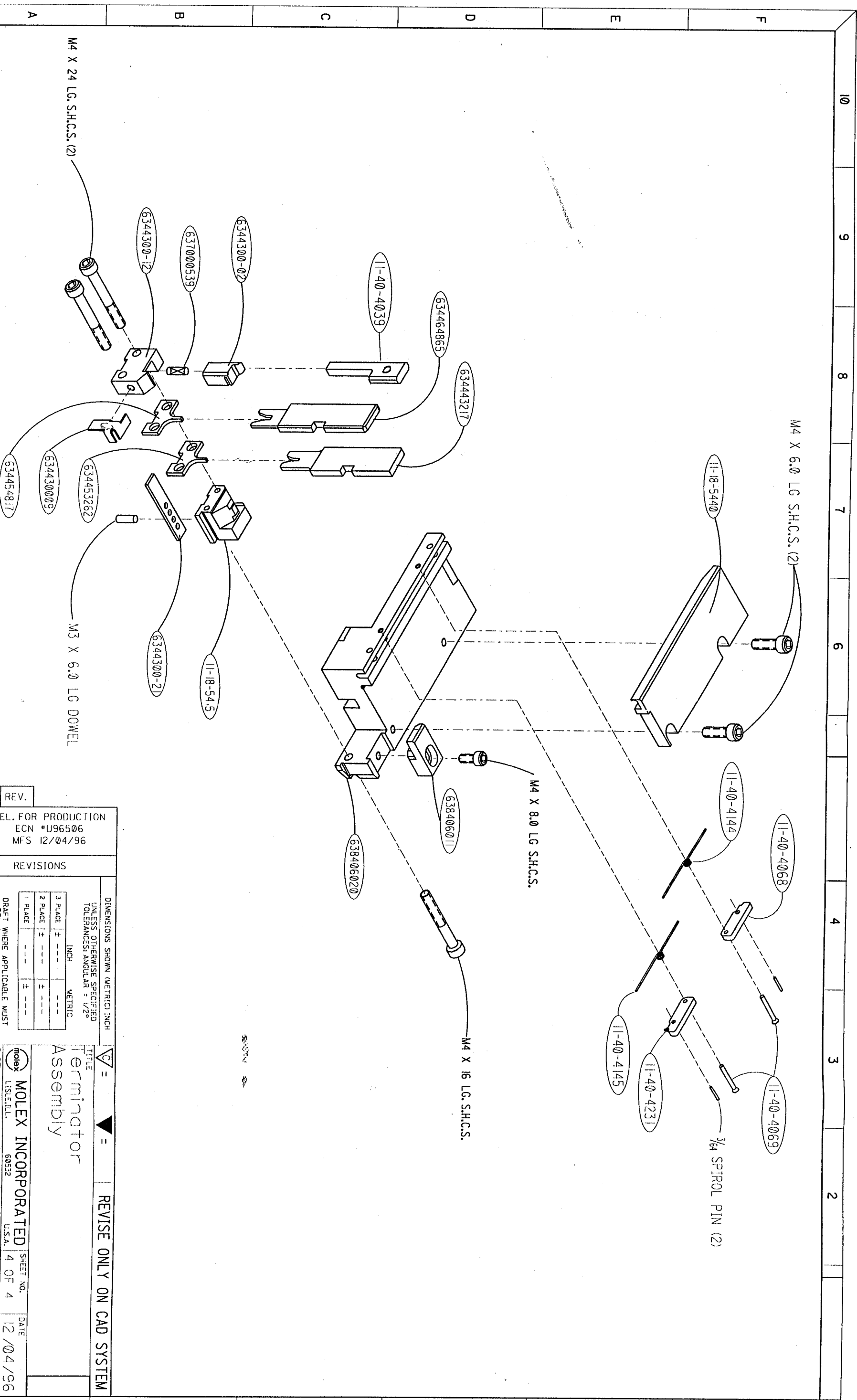
ITEM	ORDER NO.	SIZE	ENG. NO.	DESCRIPTION	REQ'D
2	634430012	B	634430012	Front Plunger Retainer	1
3	634430002	B	634430002	Front Cutoff Plunger	1
6	634443217	b	634443217	Conductor Punch	1
7	634453262	b	634453262	Conductor Anvil	1
8	6344648-65	b	6344648-65	Insulation Punch (non-tip)	1
9	634454817	b	634454817	Insulation Anvil	1
10	638406370	/	638406370	Toolkit (above items)	0

FRAME ASSEMBLY PARTS LIST

ITEM	ORDER NO.	SIZE	ENG. NO.	DESCRIPTION	REQ'D
20	638406020	C	638406020	Terminal Track	1

CRIMP

RELEASE FOR PRODUCTION MFS 12-04-96 ECN #U96506		DIMENSIONS SHOWN (METRIC) INCH UNLESS OTHERWISE SPECIFIED TOLERANCES: ANGULAR = 1/2°		TITLE BILL OF MATERIALS TERMINATOR		REVISE ONLY ON CAD SYSTEM	
MFG. SH. REV.		INCH METRIC		MOLEX INCORPORATED		SHEET NO. DATE	
A		3 PLACE ± --- --- 2 PLACE ± --- ± --- 1 PLACE --- ± ---		LISE,ILL. 60532 U.S.A.		3 OF 4 2/04/96	
LIR.		DRAFT WHERE APPLICABLE MUST REMAIN WITHIN DIMENSIONS		PART NO. 638406300		DRWG. NO. 638406300	
BY MFS		CHK'D. BY MFS		FILE NAME 6384063 S82		THIS DRAWING CONTAINS INFORMATION THAT IS PROPRIETARY TO MOLEX INC. AND SHOULD NOT BE USED WITHOUT WRITTEN PERMISSION.	
APP'D. BY		SCALE /: /		DIV. AT		SIZE A	



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

CRIMP



**Стандарт
Электрон
Связь**

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С нами вы становитесь еще успешнее!

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