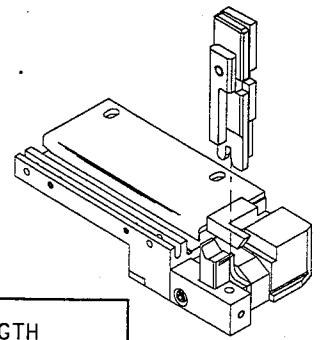




APPLICATION TOOLING TERMINATOR DIE SPECIFICATION SHEET



TERMINAL SPECIFICATION

TERMINAL SERIES	WIRE SIZE		INSULATION DIAMETER		STRIP LENGTH	
	MIN	MAX	ENGLISH	(METRIC)	ENGLISH	(METRIC)
43375-1001	.18	.14	.120 - .180	(3.05 - 4.57)	.156 - .218	(3.96 - 5.54)
			-	(-)	-	(-)
			-	(-)	-	(-)
			-	(-)	-	(-)
			-	(-)	-	(-)
			-	(-)	-	(-)
			-	(-)	-	(-)
			-	(-)	-	(-)

TOOLING INFORMATION

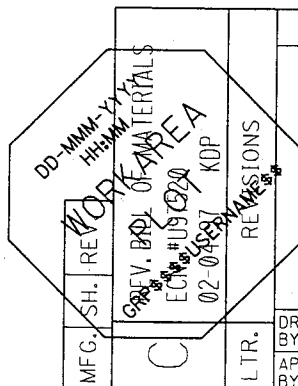
ITEM	ORDER NO.	SIZE	ENG. NO.	DESCRIPTION	REQ'D
4	634430002	B	634430002	FRONT CUT-OFF PLUNGER	1
6	634442513	B	634442513	CONDUCTOR PUNCH	1
7	634452562	B	634452562	CONDUCTOR ANVIL	1
8	634464817	B	634464817	INSULATION PUNCH	1
9	634454814	B	634454814	INSULATION ANVIL	1
					1
***	6384052-70		6384052-70	TOOL KIT (ALL THE ABOVE ITEMS)	1

CRIMP SPECIFICATION

WIRE AWG	CRIMP HEIGHT		CRIMP WIDTH (REF.)		PULL FORCE MINIMUM	
	ENGLISH	(METRIC)	ENGLISH	(METRIC)	LBS.	(N)
14	.065 - .069	(1.65 - 1.75)	.098	(2.50)	60	(266)
16	.058 - .062	(1.47 - 1.57)	.098	(2.50)	30	(133)
18	.053 - .056	(1.35 - 1.43)	.098	(2.50)	20	(88.9)
	-	(-)		()		()
DBL 18	.058 - .062	(1.47 - 1.57)	.098	(2.50)	20	(88.9)

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. CRIMP HEIGHT MAY VARY DEPENDING ON STYLE AND WIRE TYPE.
5. TO PREVENT INJURY - NEVER OPERATE THIS TOOL WITHOUT THE GUARDING SUPPLIED WITH THE PRESS IN PLACE.



DIMENSIONS SHOWN (METRIC) INCH

UNLESS OTHERWISE SPECIFIED
TOLERANCES: ANGULAR $\pm 1/2^\circ$

	INCH	METRIC
3 PLACE	$\pm$ ---	---
2 PLACE	$\pm$ ---	$\pm$ ---
1 PLACE	---	$\pm$ ---

DRAFT WHERE APPLICABLE MUST
REMAIN WITHIN DIMENSIONS

DRWG. BY SMT
CHK'D. BY VS
APP'D. BY
SCALE / : /

∇ =

∇ =

REVISE ONLY ON CAD SYSTEM

TITLE

TERMINATOR DIE ASSEMBLY

MOLEX

MOLEX INCORPORATED
LISLE, ILL. 60532 U.S.A.

SHEET NO.

DATE

1 of 4 03/07/95

PART NO.

DRWG. NO.

6384052-00

6384052-00

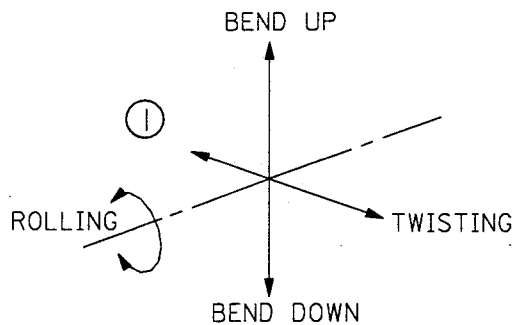
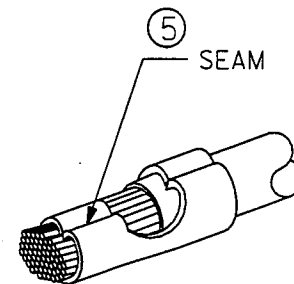
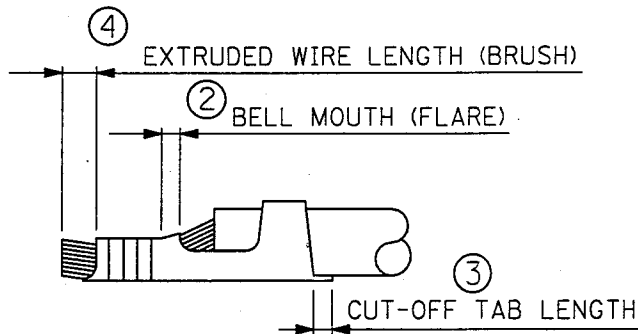
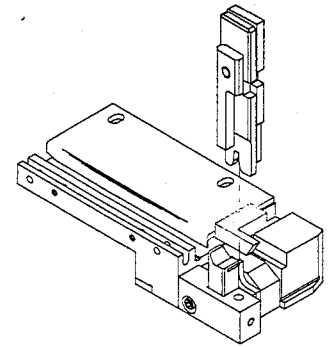
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DIV. SIZE
AT A

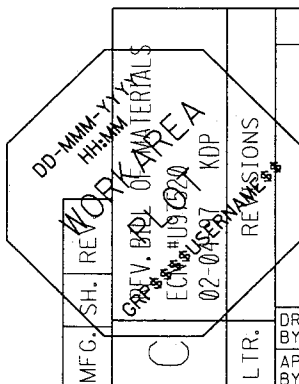


APPLICATION TOOLING TERMINATOR DIE SPECIFICATION SHEET



CRIMP SPECIFICATION

NO. OF FIG.	ITEM	REQUIREMENT
1	BEND UP	5° MAX
	BEND DOWN	2° MAX
	TWISTING	5° MAX
	ROLLING	5° MAX
2	BELL MOUTH (FLARE)	0.2 - 0.5mm
3	CUT-OFF TAB LENGTH	0.2mm MAX
4	EXTRUDED WIRE LENGTH (BRUSH)	0.0 - 0.5 mm
5	SEAM	SEAM SHALL NOT BE OPENED AND
		NO WIRE ALLOWED OUT OF THE
		CRIMPING AREA.



DIMENSIONS SHOWN (METRIC) INCH

UNLESS OTHERWISE SPECIFIED
TOLERANCES: ANGULAR $\pm 1/2^\circ$

	INCH	METRIC
3 PLACE	$\pm$ ---	---
2 PLACE	$\pm$ ---	$\pm$ ---
1 PLACE	---	$\pm$ ---

DRAFT WHERE APPLICABLE MUST
REMAIN WITHIN DIMENSIONS

DRWG. BY SMT
CHK'D. BY VS
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SCALE / : /

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TITLE

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REVISE ONLY ON CAD SYSTEM

TERMINATOR DIE ASSEMBLY



MOLEX INCORPORATED
LISLE, ILL. 60532 U.S.A.

SHEET NO.

DATE

2 of 4

03/07/95

PART NO.

DRWG. NO.

6384052-00

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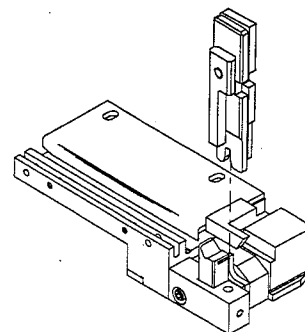
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DIV. AT
SIZE A



APPLICATION TOOLING TERMINATOR DIE SPECIFICATION SHEET



TOOLING INFORMATION

ITEM	ORDER NO.	SIZE	ENG. NO.	DESCRIPTION	REQ'D
4	634430002	B	634430002	FRONT CUT-OFF PLUNGER	1
6	634442513	B	634442513	CONDUCTOR PUNCH	1
7	634452562	B	634452562	CONDUCTOR ANVIL	1
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9	634454814	B	634454814	INSULATION ANVIL	1
***	6384052-70		6384052-70	TOOL KIT (ALL THE ABOVE ITEMS)	1

TERMINATOR ASSEMBLY - PARTS LIST

ITEM	ORDER NO.	SIZE	ENG. NO.	DESCRIPTION	REQ'D
5	634430012	B	634430012	CUT-OFF PLUNGER RETAINER	1
10	11-40-4039	B	8302-5	PLUNGER STRIKER	1
11	634430021	B	634430021	MOUNTING KEY	1
12	638405012	B	638405012	ANVIL MOUNT	1
13	11-40-4068	B	8302-102	DRAG FINGER (L.H.)	1
14	638405014	B	638405014	DRAG FINGER (R.H.)	1
15					
16					
17	638405017	B	638405017	COVER	1
18	11-24-1067	A	4996-4	CUT-OFF PLUNGER SPRING	1
19	638405019	B	638405019	WIRE STOP	1
20	638405020	C	638405020	TERMINAL TRACK	1
21					
22	11-40-4144	B	8302-110	TORSION SPRING, DRAG FINGER	2
23					
24	11-40-4069	B	8302-103	PIVOT PIN	2
25					
26					
27					
28					
29					

DIMENSIONS SHOWN (METRIC) INCH

UNLESS OTHERWISE SPECIFIED
TOLERANCES: ANGULAR $\pm 1/2^\circ$

	INCH	METRIC
3 PLACE	---	---
2 PLACE	---	$\pm$ ---
1 PLACE	---	$\pm$ ---

DRAFT WHERE APPLICABLE MUST
REMAIN WITHIN DIMENSIONS

DRWG. BY SMT CHK'D. BY VS
APP'D. BY SCALE / : /

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REVISE ONLY ON CAD SYSTEM

TITLE

TERMINATOR DIE ASSEMBLY



MOLEX INCORPORATED
LISLE, ILL. 60532 U.S.A.

SHEET NO.

DATE

3 of 4 03/07/95

PART NO.

DRWG. NO.

6384052-00

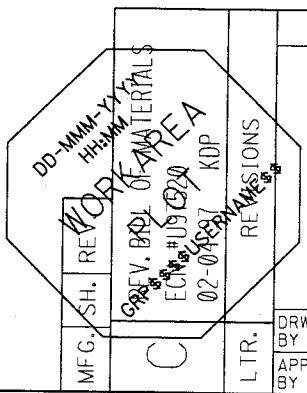
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