



THIS STANDARD SPECIFIES THE DIMENSIONS AFTER CRIMPING OF THE TERMINALS UNDERMENTIONED.

[illegible]

The diagram illustrates the crimping process and wire types. On the left, a cross-sectional view of a crimp shows a wire being compressed between two metal strips. Key dimensions are labeled: (1) CRIMP HEIGHT, (2) BELL MOUTH (FLARE), (3) CUT-OFF TAB LENGTH, and (4) EXTRUDED WIRE LENGTH (BRUSH). On the right, a perspective view of a crimped wire is shown, with a label (5) SEAM indicating the joint. Below the crimped wire, a diagram shows a wire being bent up, bent down, rolled, and twisted, with arrows indicating the direction of movement.

CRIP

DD-MMM-YYYY HH:MM WORK AREA RE-BUILD OF MAT'L E.O. # 12812-570 GRP-000006-22-97 USER NAME: JAKDP		DIMENSIONS SHOWN (METRIC) INCH		▽ = ▼ = REVISE ONLY ON CAD SYSTEM													
		UNLESS OTHERWISE SPECIFIED TOLERANCES: ANGULAR ± 1/2°		Specification Sheet Terminator													
		<table border="1" style="width: 100%; border-collapse: collapse;"> <thead> <tr> <th></th> <th style="text-align: center;">INCH</th> <th style="text-align: center;">METRIC</th> </tr> </thead> <tbody> <tr> <td>3 PLACE</td> <td style="text-align: center;">± ---</td> <td style="text-align: center;">---</td> </tr> <tr> <td>2 PLACE</td> <td style="text-align: center;">± ---</td> <td style="text-align: center;">± 0.13</td> </tr> <tr> <td>1 PLACE</td> <td style="text-align: center;">---</td> <td style="text-align: center;">± 0.25</td> </tr> </tbody> </table>					INCH	METRIC	3 PLACE	± ---	---	2 PLACE	± ---	± 0.13	1 PLACE	---	± 0.25
			INCH			METRIC											
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DRAFT WHERE APPLICABLE MUST REMAIN WITHIN DIMENSIONS																	
DRWG. BY SMT		CHK'D. BY		MOLEX INCORPORATED LISLE, ILL. 60532 U.S.A. SHEET NO. 1 of 4 DATE 12 / 13 / 95													
APP'D. BY		SCALE															
MFG. SH. B		L.T.R.		PART NO. 63841-5000													
FILE NAME 6384150		DRWG. NO. 638415000		THIS DRAWING CONTAINS INFORMATION THAT IS PROPRIETARY TO MOLEX INC. AND SHOULD NOT BE USED WITHOUT WRITTEN PERMISSION.													
S80		DIV. AT		SIZE A													

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

 MOLEX INCORPORATED LISLE, ILL. 60532 U.S.A.		SHEET NO.		DATE	
		2 of 4		12 / 13 / 95	
		PART NO.		DRWG. NO.	
		63841-5000		638415000	
DD-MMM-YYYY. HH:MM WORK AREA REV. BILL E. MATH. ECKHART GRP 6-25/97 OBSERVE		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 SMT APP'D. BY		CHK'D. BY SCALE /: /			
FILE NAME 6384150 S81		THIS DRAWING CONTAINS INFORMATION THAT IS PROPRIETARY TO MOLEX INC. AND SHOULD NOT BE USED WITHOUT WRITTEN PERMISSION.			
DIV. AT SIZE A					

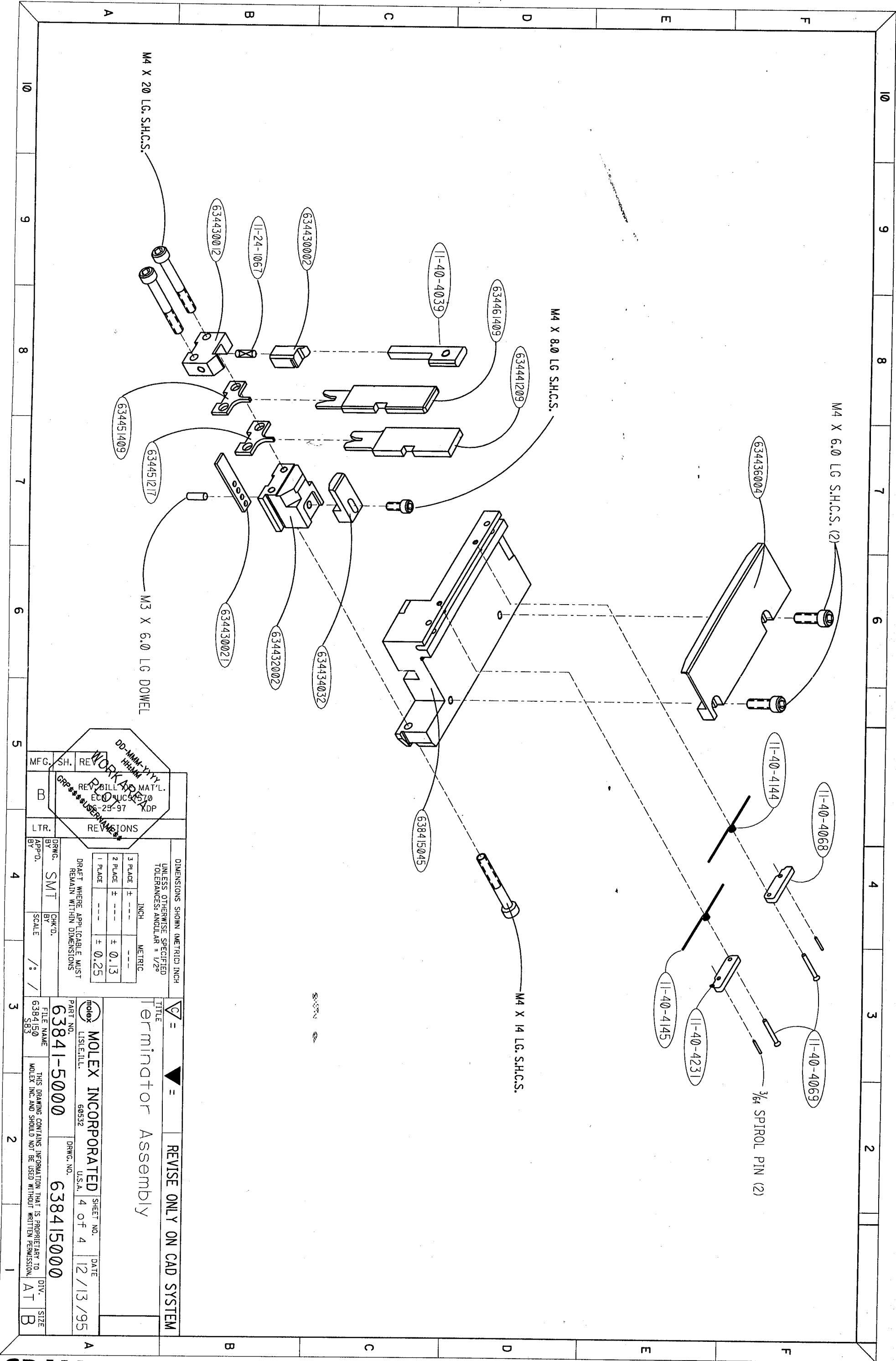
APPLICATOR ASSEMBLY - PARTS LIST

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

DD-MMM-YYYY HHMM REWORK AREA REASON: URGENT DATE: 06-25-97 BY: [Signature] GROUP: [Signature]		DIMENSIONS SHOWN (METRIC) INCH		C = ▼ = REVISE ONLY ON CAD SYSTEM													
		UNLESS OTHERWISE SPECIFIED TOLERANCES: ANGULAR ± 1/2°		TITLE Bill of Material Terminator													
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