



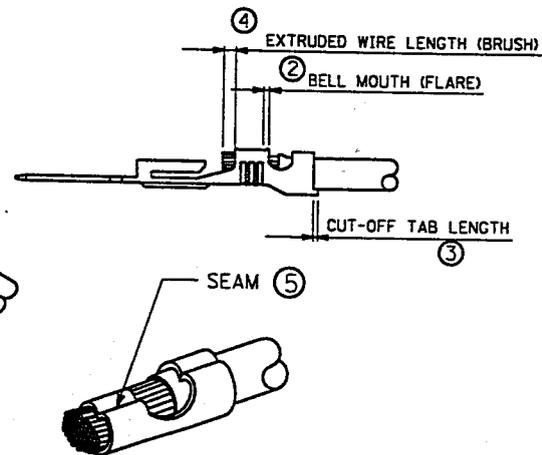
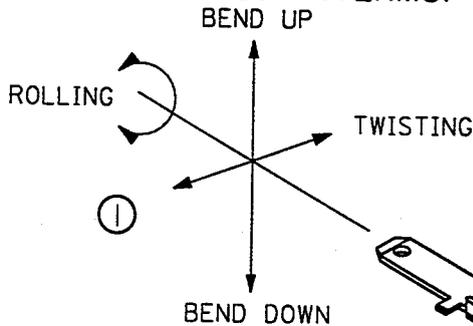
# APPLICATION TOOLING TERMINATOR SPECIFICATION SHEET

## 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
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.

DD-MM-YY  
HH-MM-YY  
Release App. Prod.  
E.C.D. #12/0506  
GRIP \*\*\*\*\*  
MFG. SH. REV. WORK AREA  
REVISIONS  
L.T.R.

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 MOLEX INCORPORATED SHEET NO. DATE  
LISLE, ILL. 60532 U.S.A. 1 OF 4 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. SIZE AT 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.

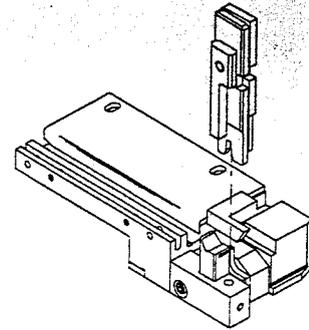
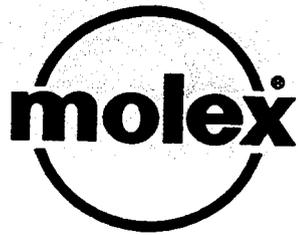
TERMINAL SERIES	WIRE AWG	CRIMP HEIGHT		CRIMP WIDTH (REF.)		PULL FORCE MINIMUM	
		ENGLISH	(METRIC)	ENGLISH	(METRIC)	LBS.	(N)
43178-2001	14	.078 - .082	(1.98 - 2.08)	.126	(3.20)	50	(222 )
	16	.074 - .078	(1.88 - 1.98)			30	(133 )
	18	.070 - .074	(1.78 - 1.88)			20	(88.9)
	18 DBL	.077 - .081	(1.96 - 2.06)			20	(88.9)
		-	( - )				( )
		-	( - )		( )		( )
		-	( - )		( )		( )
		-	( - )		( )		( )
		-	( - )		( )		( )
		-	( - )		( )		( )
		-	( - )		( )		( )
		-	( - )		( )		( )
		-	( - )		( )		( )
		-	( - )		( )		( )

# 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.	A	L IR.	DRWG. BY KDP	CHK'D. BY MFS	SCALE :	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	△ =      ▽ =      REVERSE ONLY ON CAD SYSTEM	TITLE		
							SPECIFICATION SHEET		TERMINATOR	
						MOLEX INCORPORATED LISLE, ILL. 60532 U.S.A.	SHEET NO.	DATE		
						PART NO. 638406300	DRWG. NO. 638406300	2 OF 4	96/12/05	
						FILE NAME 6384063 S8	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
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

Collect THIS (no spec)

## FRAME ASSEMBLY PARTS LIST

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

**CRIMP**

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



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