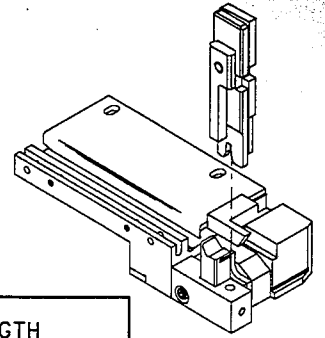




# APPLICATION TOOLING TERMINATOR DIE SPECIFICATION SHEET



## TERMINAL SPECIFICATION

TERMINAL SERIES	WIRE SIZE		INSULATION DIAMETER		STRIP LENGTH	
	AWG		ENGLISH	(METRIC)	ENGLISH	(METRIC)
- VER.	MIN	MAX				
43375-0001	18	14	.093 - .140	(2.36 - 3.56)	.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	634463937	B	634463937	INSULATION PUNCH	1
9	634453947	B	634453947	INSULATION ANVIL	1
***	6384050-70		6384050-70	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)
	-	( - )		( )		( )
	-	( - )		( )		( )

## NOTES:

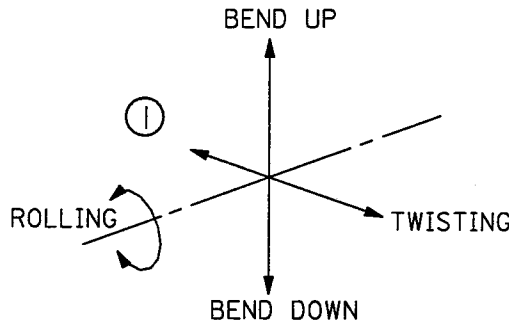
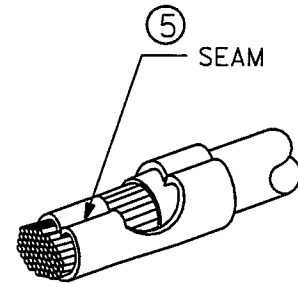
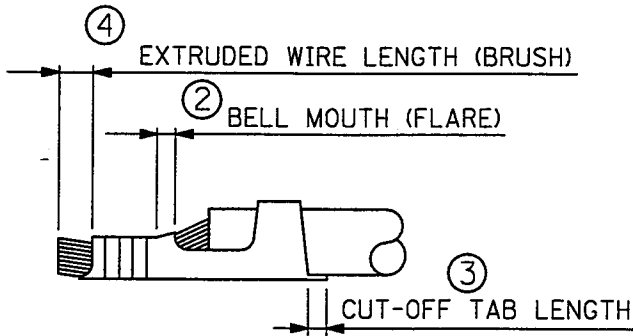
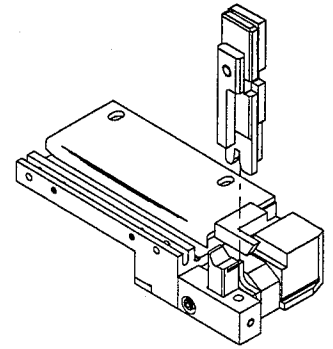
1. WE RECOMMEND AN EXTRA SET OF PERISHABLE TOOLING BE MAINTAINED IN YOUR FACTORY.
2. VERIFY TOOLING ALIGNMENT BY MANUALLY CYCLING THE PRESS AND DIE BEFORE CRIMPING UNDERPOWER. CHECK THAT ALL SCREWS ARE TIGHT.
3. SLUGS, TERMINALS, DIRT AND OIL SHOULD BE KEPT CLEAR OF WORK AREA.
4. CRIMP HEIGHT MAY VARY DEPENDING ON STYLE AND WIRE TYPE.
5. TO PREVENT INJURY - NEVER OPERATE THIS TOOL WITHOUT THE GUARDING SUPPLIED WITH THE PRESS IN PLACE.

**CRIMP**

<div style="border: 1px solid black; padding: 5px; transform: rotate(-45deg); display: inline-block;">             DD-MMM-YY HH:MM REV. BDL OF MATERIALS PER FCN 049160A 09-13-97 KDP REVISIONS MFG. SH. REV. WORK L.T.R.           </div>	DIMENSIONS SHOWN (METRIC) INCH		▽ =	▼ =	REVISE ONLY ON CAD SYSTEM																			
	UNLESS OTHERWISE SPECIFIED TOLERANCES: ANGULAR ± 1/2°		TITLE		TERMINATOR DIE ASSEMBLY																			
	<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	---	± ---	<table border="1"> <tr> <td></td> <td><b>MOLEX INCORPORATED</b></td> <td>SHEET NO.</td> <td>DATE</td> </tr> <tr> <td>LISLE, ILL.</td> <td>60532</td> <td>U.S.A.</td> <td>1 of 4 03/03/95</td> </tr> </table>			<b>MOLEX INCORPORATED</b>	SHEET NO.	DATE	LISLE, ILL.	60532	U.S.A.	1 of 4 03/03/95
		INCH	METRIC																					
3 PLACE	± ---	---																						
2 PLACE	± ---	± ---																						
1 PLACE	---	± ---																						
	<b>MOLEX INCORPORATED</b>	SHEET NO.	DATE																					
LISLE, ILL.	60532	U.S.A.	1 of 4 03/03/95																					
DRAFT WHERE APPLICABLE MUST REMAIN WITHIN DIMENSIONS		PART NO.		DRWG. NO.																				
<table border="1"> <tr> <td>DRWG. BY</td> <td>SMT</td> <td>CHK'D. BY</td> <td>VS</td> </tr> <tr> <td>APP'D. BY</td> <td></td> <td>SCALE</td> <td>/ : /</td> </tr> </table>		DRWG. BY	SMT	CHK'D. BY	VS	APP'D. BY		SCALE	/ : /	<table border="1"> <tr> <td>6384050-00</td> <td>6384050-00</td> </tr> <tr> <td>FILE NAME</td> <td>THIS DRAWING CONTAINS INFORMATION THAT IS PROPRIETARY TO MOLEX INC. AND SHOULD NOT BE USED WITHOUT WRITTEN PERMISSION.</td> </tr> <tr> <td>6384050</td> <td>AT A</td> </tr> <tr> <td>S80</td> <td></td> </tr> </table>		6384050-00	6384050-00	FILE NAME	THIS DRAWING CONTAINS INFORMATION THAT IS PROPRIETARY TO MOLEX INC. AND SHOULD NOT BE USED WITHOUT WRITTEN PERMISSION.	6384050	AT A	S80						
DRWG. BY	SMT	CHK'D. BY	VS																					
APP'D. BY		SCALE	/ : /																					
6384050-00	6384050-00																							
FILE NAME	THIS DRAWING CONTAINS INFORMATION THAT IS PROPRIETARY TO MOLEX INC. AND SHOULD NOT BE USED WITHOUT WRITTEN PERMISSION.																							
6384050	AT A																							
S80																								



# 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.

**CRIMP**

DD-MMM-YY  
 HH:MM  
 REV. BRN. OF MATERIALS  
 PENDING @ 09/16/04  
 09-15387 KDP  
 REV. 08/04  
 WORK IN PROGRESS  
 MFG. SH. C LTR.

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

▽ =    ▼ =    REVISE ONLY ON CAD SYSTEM

TITLE: TERMINATOR DIE ASSEMBLY

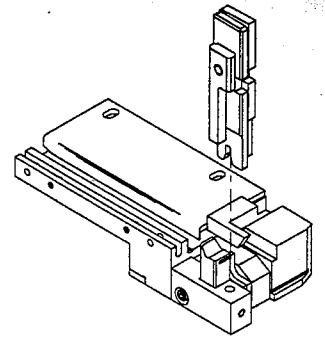
MOLEX INCORPORATED    SHEET NO. 2 of 4    DATE 03/03/95  
 LISLE, ILL. 60532    U.S.A.

PART NO. 6384050-00    DRWG. NO. 6384050-00

FILE NAME 6384050 S81    THIS DRAWING CONTAINS INFORMATION THAT IS PROPRIETARY TO MOLEX INC. AND SHOULD NOT BE USED WITHOUT WRITTEN PERMISSION.    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
8	634463937	B	634463937	INSULATION PUNCH	1
9	634453947	B	634453947	INSULATION ANVIL	1
***	6384050-70		6384050-70	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					

**CRIMP**

DD-MMM-YY  
 HH:MM  
 WORK CENTER  
 REV. BRD. OF MATERIALS  
 PER ECN 0109160A  
 09-15-98  
 KDP  
 REVISIONS  
 MFG. SH. REV. C  
 LTR.

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

▽ =    ▼ =  
TITLE

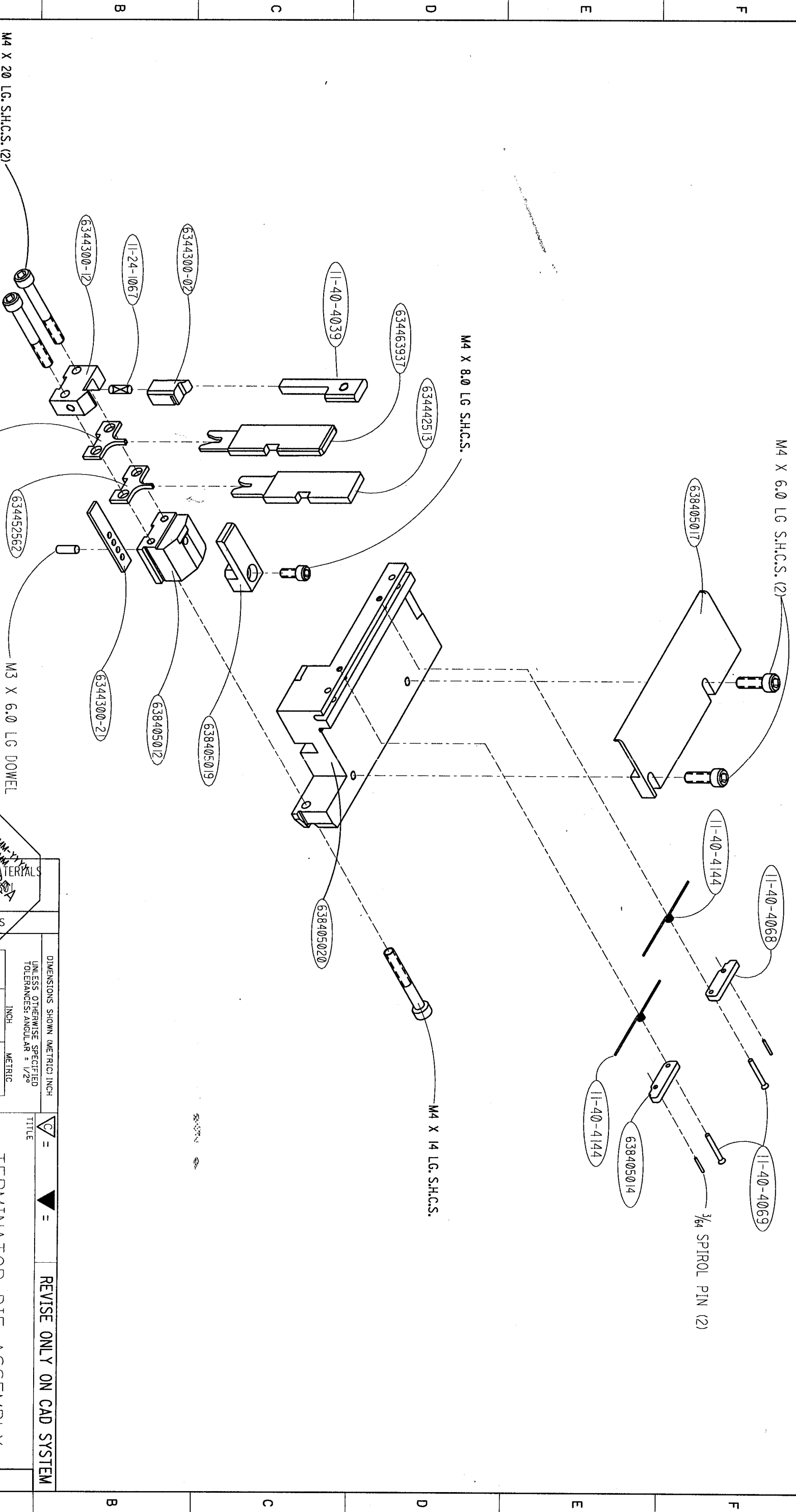
REVISE ONLY ON CAD SYSTEM

TERMINATOR DIE ASSEMBLY

MOLEX INCORPORATED    SHEET NO.    DATE  
LISLE, ILL.    60532    U.S.A.    3 of 4    03/03/95

PART NO.    DRWG. NO.  
6384050-00    6384050-00

FILE NAME    THIS DRAWING CONTAINS INFORMATION THAT IS PROPRIETARY TO MOLEX INC. AND SHOULD NOT BE USED WITHOUT WRITTEN PERMISSION.    DIV.    SIZE  
6384050    S82    AT    A



DD-MMM-YY  
REV. BLD. OF MATERIALS  
PET ECN 0UC9760  
09-15-93  
KDP

REV.	BY	DATE	DESCRIPTION
1			
2			
3			

DRAFT WHERE APPLICABLE MUST REMAIN WITHIN DIMENSIONS

PLACE	INCH	METRIC
3 PLACE	±	---
2 PLACE	±	---
1 PLACE	---	±

DIMENSIONS SHOWN (METRIC) INCH  
UNLESS OTHERWISE SPECIFIED  
TOLERANCES: ANGULAR ± 1/2°

WORK AREA  
REVISIONS

MFG.	SH.	REV.	
LTR.	BY	SCALE	VS
DRWG. SMT	CHK'D.		VS
APP'D.	BY	SCALE	/ :

FILE NAME  
6384050-00

PART NO.  
6384050

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

DRWG. NO.  
6384050-00

SHEET NO.  
4 OF 4

DATE  
03/03/95

DIV.  
AT

SIZE  
B

TITLE  
**TERMINATOR DIE ASSEMBLY**

REVISE ONLY ON CAD SYSTEM