



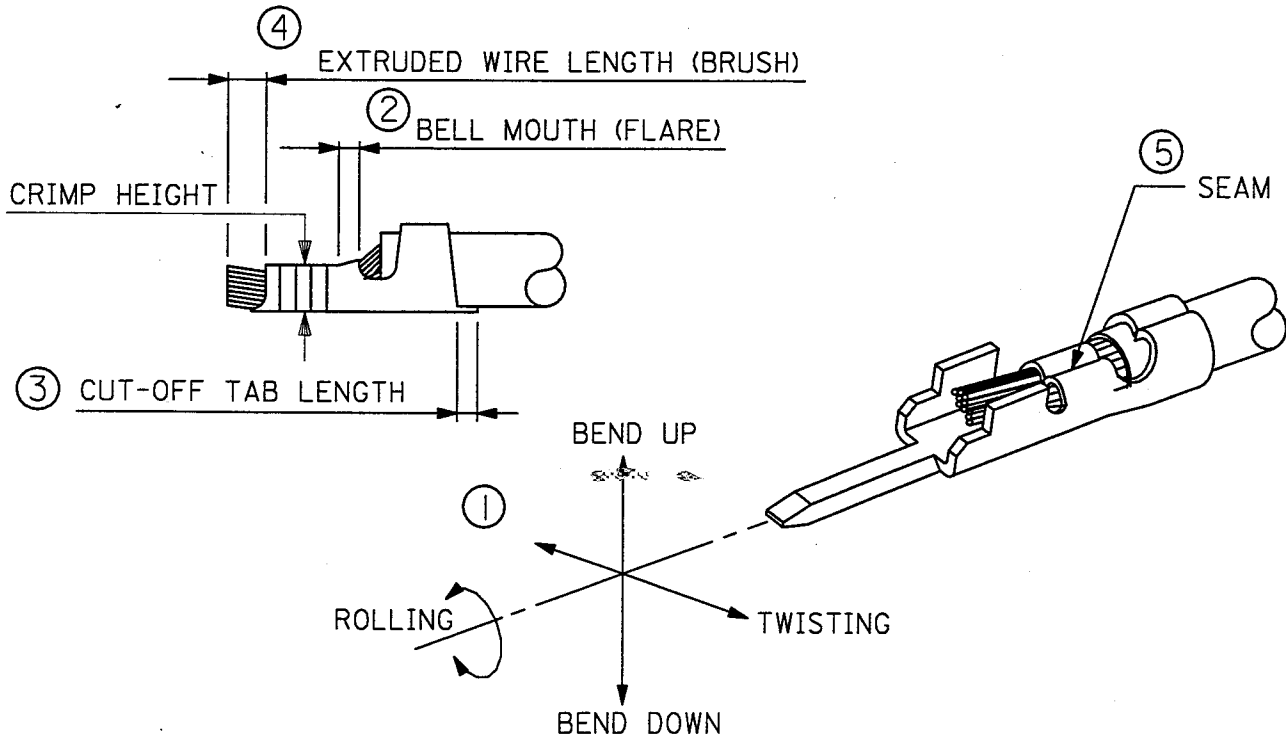
# APPLICATION TOOLING TERMINATOR SPECIFICATION SHEET

## 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)	
50012-8000	24 - 28	.036 - .045	(0.92 - 1.15)	.067 - .091	(1.7 - 2.3)	
50013-8000	24 - 28	.036 - .045	(0.92 - 1.15)	.067 - .091	(1.7 - 2.3)	
	-	-	( - )	-	( - )	
	-	-	( - )	-	( - )	
	-	-	( - )	-	( - )	
	-	-	( - )	-	( - )	
	-	-	( - )	-	( - )	
	-	-	( - )	-	( - )	

## B. DEFINITION (TERMS)



**CRIMP**

<div style="border: 1px solid black; padding: 5px; transform: rotate(-45deg); display: inline-block;">             DD-MMM-YYYY HH:MM WORK REVISIONS REPLACES MAT'L #J068570 #06-25-97 AKDP GRP           </div>	DIMENSIONS SHOWN (METRIC) INCH UNLESS OTHERWISE SPECIFIED TOLERANCES: ANGULAR ± 1/2°	□ = ▼ =	<b>REVISE ONLY ON CAD SYSTEM</b>													
	<table border="1" style="margin: auto;"> <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>± 0.13</td> </tr> <tr> <td>1 PLACE</td> <td>---</td> <td>± 0.25</td> </tr> </tbody> </table>		INCH	METRIC	3 PLACE	± ---	---	2 PLACE	± ---	± 0.13	1 PLACE	---	± 0.25	TITLE Specification Sheet Terminator		
		INCH	METRIC													
	3 PLACE	± ---	---													
2 PLACE	± ---	± 0.13														
1 PLACE	---	± 0.25														
DRAFT WHERE APPLICABLE MUST REMAIN WITHIN DIMENSIONS	<table border="1" style="width: 100%;"> <tr> <td style="width: 30%; text-align: center;"> <b>MOLEX INCORPORATED</b> LISLE, ILL. 60532 U.S.A.         </td> <td style="width: 20%;">           SHEET NO. 1 of 4         </td> <td style="width: 50%;">           DATE 12 / 13 / 95         </td> </tr> <tr> <td>           PART NO. <b>63841-5000</b> </td> <td colspan="2">           DRWG. NO. <b>638415000</b> </td> </tr> </table>			<b>MOLEX INCORPORATED</b> LISLE, ILL. 60532 U.S.A.	SHEET NO. 1 of 4	DATE 12 / 13 / 95	PART NO. <b>63841-5000</b>	DRWG. NO. <b>638415000</b>								
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PART NO. <b>63841-5000</b>	DRWG. NO. <b>638415000</b>															
DRWG. BY SMT APP'D. BY	CHK'D. BY SCALE :	FILE NAME 6384150 S80 THIS DRAWING CONTAINS INFORMATION THAT IS PROPRIETARY TO MOLEX INC. AND SHOULD NOT BE USED WITHOUT WRITTEN PERMISSION.														

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

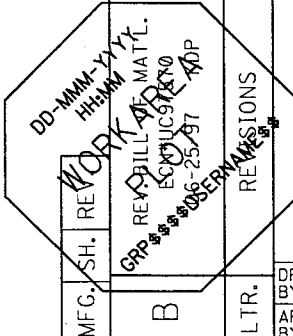

AFTER CRIMPING , THE CRIMPED CONDUCTOR AREA SHOULD BE AS FOLLOWS.

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**

	DIMENSIONS SHOWN (METRIC) INCH		▽ =	▼ =	REVISE ONLY ON CAD SYSTEM													
	UNLESS OTHERWISE SPECIFIED TOLERANCES: ANGULAR ± 1/2°		TITLE		Specification Sheet Terminator													
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		INCH	METRIC															
3 PLACE	± ---	---																
2 PLACE	± ---	± ---																
1 PLACE	---	± ---																
DRAFT WHERE APPLICABLE MUST REMAIN WITHIN DIMENSIONS		PART NO. <b>63841-5000</b>		DRWG. NO. <b>638415000</b>														
MFG. SH. RE. B	LTR.	DRWG. BY SMT	CHK'D. BY	FILE NAME 6384150	THIS DRAWING CONTAINS INFORMATION THAT IS PROPRIETARY TO MOLEX INC. AND SHOULD NOT BE USED WITHOUT WRITTEN PERMISSION.													
		APP'D. BY	SCALE /: /	81	DIV. AT	SIZE A												

# APPLICATOR ASSEMBLY - PARTS LIST

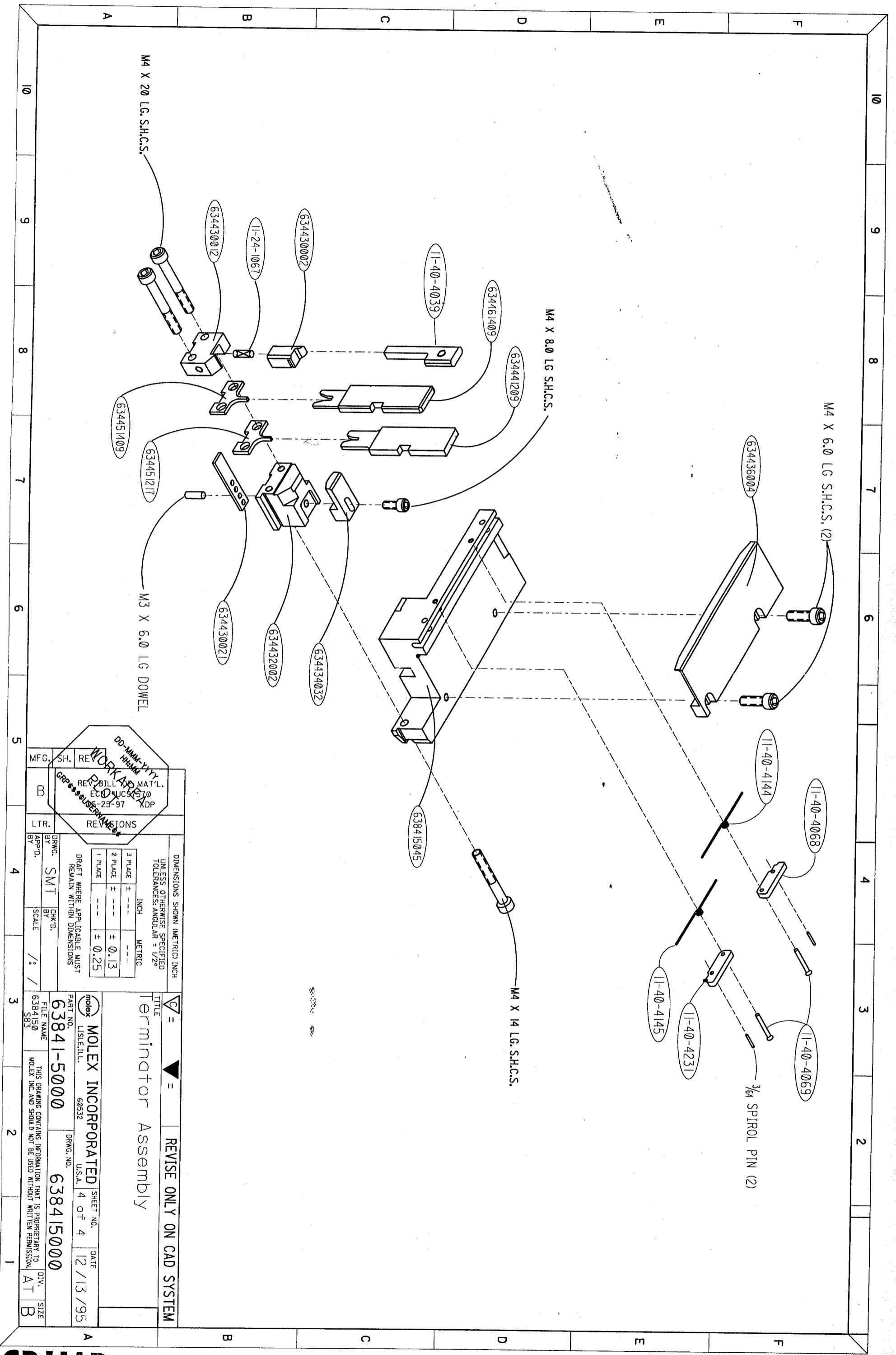
ITEM	ORDER NO.	SIZE	ENG. NO.	DESCRIPTION	REQ'D
6	634430012	b	634430012	Front Plunger Retainer	1
7	11-24-1067	a	4996-4	Cut-off Plunger Spring	1
8	11-40-4039	b	8302-5	Front Plunger Striker	1
9	634430021	b	634430021	Lower Tooling Key	1
10	634432002	b	634432002	Anvil Mount	1
11	634434032	B	634434032	Wire 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

4-57-00

<p>DD-MMM-YYYY HH:MM</p> <p><b>WORK AREA</b></p> <p>REWORK BILL MAT'L ESN: PUC3R570 GRP: 06-25-97 LADP</p> <p>REVISIONS</p> <p>MFG. SH. REVISIONS</p> <p>B</p> <p>LTR.</p>	DIMENSIONS SHOWN (METRIC) INCH UNLESS OTHERWISE SPECIFIED TOLERANCES: ANGULAR ± 1/2°		TITLE Bill of Material Terminator		REVISE ONLY ON CAD SYSTEM													
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DRWG. BY SMT APP'D. BY		CHK'D. BY SCALE /: /		FILE NAME 6384150 S82		THIS DRAWING CONTAINS INFORMATION THAT IS PROPRIETARY TO MOLEX INC. AND SHOULD NOT BE USED WITHOUT WRITTEN PERMISSION.												
				DIV. AT	SIZE A													



DD-MMM-YY  
 WORK AREA  
 REV. BILL MAT'L.  
 ECN # CS 510  
 6-29-97  
 USER NAME

MFG. SH. RE. LTR. REV. IONS

DRWG. BY: SMT  
 APP'D. BY: GKD.  
 SCALE: /% /

DIMENSIONS SHOWN (METRIC) INCH  
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3 PLACE	±	---	INCH	METRIC
2 PLACE	±	---	± 0.13	
1 PLACE	±	---	± 0.25	

DRAFT WHERE APPLICABLE MUST  
 REMAIN WITHIN DIMENSIONS

MOLEX INCORPORATED  
 U.S.A.  
 60532

REVISIONS

REVISION ONLY ON CAD SYSTEM

Terminator Assembly

PART NO. 63841-5000  
 LISTEN, ILL. 60532

DRWG. NO. 638415000

SHEET NO. 4 OF 4  
 DATE 12/13/95

FILE NAME 6384150  
 S83

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DIV. AT B  
 SIZE B