

FEATURES

nole

m

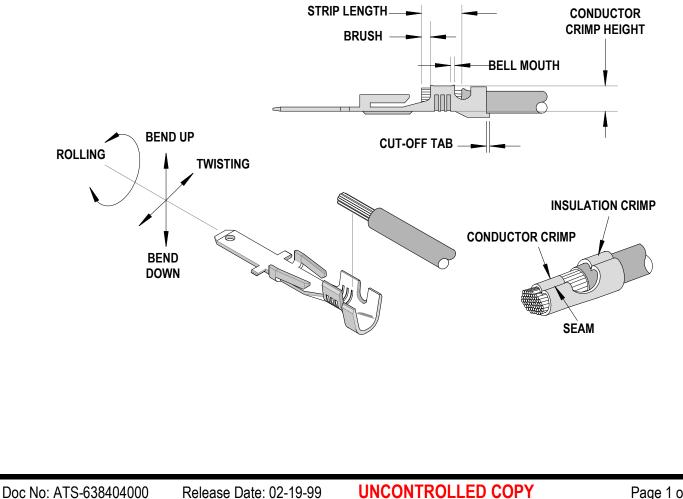
- It is ideally suited for mid-volume bench operations
- This terminator can be installed in the TM42 and Base Unit adapter for 3BF press
- Quick punch removal with the push of a button for fast and easy tooling change
- Flexible and inexpensive

SCOPE

Products: Sabre™ Crimp Terminal 18 AWG only.

[Terminal Series No. Terminal Order No.		Wire Size		Insulation Diameter		Strip Length		
	Terminal Series NO.	Terrinia	Oldel No.	AWG mm ²		mm	In.	mm	In.
	43178	43178-1001	43178-5001	18	0.80	2.36-3.56	.093130	3.96-5.54	.156218
		43178-1002	43178-5002						

DEFINITION OF TERMS



Release Date: 02-19-99 Revision Date: 10-27-06

CRIMP SPECIFICATIONS

	Terminal Series No.	Bell n	nouth	Cut-off 1	fab Max.	Conductor Brush		
	Terminal Series NO.	mm	In.	mm	ln.	mm	In.	
l	43178	0.25-1.00	.010039	0.50	.019	1.50	.059	

	Bond up	Bond down	Twist	Roll	Pu			Seam		
Terminal Series No.	Bend up Bend down		I WISL KUI		Conductor		Insulation		Seam shall not be open	
	De		Degree		mm	In	mm	In	and no wire allowed out	
43178	3	3	4	8	3.20	.126	4.30	.169	of the crimping area	

After crimping, the conductor profile should measure the following.

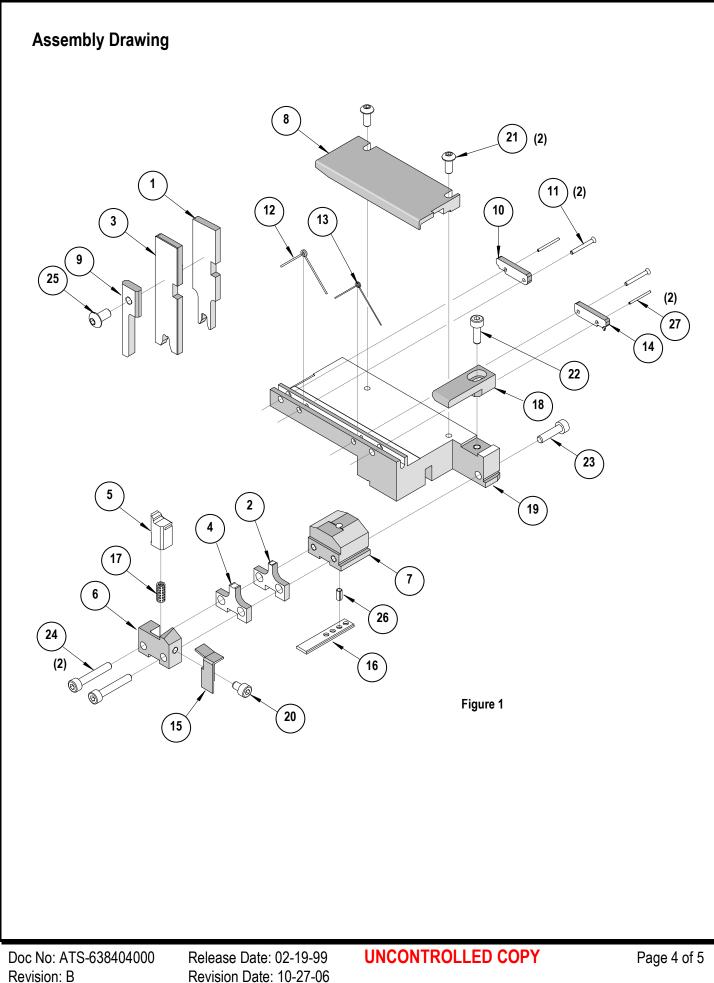
Terminal Series No.	Wire Size		Crimp	Pull Force Minimum		
	AWG	mm ²	mm	In.	Ν	Lb.
43178	18	0.80	1.78-1.88	.070074	88.9	20.00

Pull Force should be measured with no influence from the insulation crimp.

The above specifications are guidelines to an optimum crimp.

PARTS LIST

T-Style Terminator 63840-4000										
ltem	Order No	Engineering No.	Description	Quantity						
Perishable Tooling										
			Tool Kit (All "Y" Items)	REF						
1	63444-3217	63444-3217	Conductor Punch	1 Y						
2	63445-3262	63445-3262	Conductor Anvil	1 Y						
3	63446-4321	63446-4321	Insulation Punch	1 Y						
4	63445-4327	63445-4327	Insulation Anvil	1 Y						
5	63443-0002	63443-0002	Cut-Off Plunger	1 Y						
6	63443-0012	63443-0012	Front Plunger Retainer	1 Y						
			Components							
7	11-18-5415	60842A111	Anvil Mount	1						
8	11-18-5440	60842A117	Rear Cover	1						
9	11-40-4039	8302-5	Front Plunger Striker	1						
10	11-40-4068	8302-102	Drag Finger	1						
11	11-40-4069	4069 8302-103 Pivot Pin		2						
12	11-40-4144	8302-110	Torsion Spring	1						
13	11-40-4145	8302-111	Torsion Spring (Stop Finger)	1						
14	11-40-4231	8329-10	Stop Finger	1						
15	63443-0009	63443-0009	Scrap Chute	1						
16	63443-0021	63443-0021	63443-0021 Mounting Key							
17	63700-0539	63700-0539 Heavy Duty Cut-Off Plunger Spring		1						
18	63840-6011	011 63840-6011 Wire Stop		1						
19	63840-6020 63840-6020		Terminal Track	1						
			ardware							
20	N/A	N/A	M4 by 6 Long SHCS	1**						
21	N/A	N/A	M4 by 10 Long BHCS	2**						
22	N/A	N/A	M4 by 12 Long SHCS	1**						
23	N/A	N/A	M4 by 16 Long SHCS	1**						
24	N/A	N/A	M4 by 24 Long SHCS	2**						
25	N/A	N/A #10-32 by 3/8" Long BHCS		1**						
26	N/A	N/A	3mm by 6 Long Roll Pin	1**						
27	N/A	N/A	3/64" Diameter Spirol Pin	2**						
	** Available from an industrial supply company such as MSC (1-800-645-7270).									



NOTES

- 1. Molex recommends an extra perishable tooling kit be maintained at your facility.
- 2. Verify tooling alignment by manually cycling the press before crimping under power. Check that all screws are tight.
- 3. Slugs, Terminals, Dirt and Oil should be kept clear of work area.
- 4. This Terminator should be only used in a Molex TM42, TM40, or 3BF Press with a Base Unit adaptor.
- 5. Wear safety glasses at all times.
- 6. For recommended maintenance refer to the TM40, TM42 Manual.

CAUTION: To prevent injury never operate this Terminator without the guards supplied with the press in place. Reference the TM42 press manufacturer's instruction manual.

CAUTION: Molex crimp specifications are valid only when used with Molex terminals, applicators and tooling.

Americas Headquarters Lisle, Illinois 60532 U.S.A. 1-800-78MOLEX amerinfo@molex.com Far East North Headquarters Yamato, Kanagawa, Japan 81-462-65-2324 feninfo@molex.com Far East South Headquarters Jurong, Singapore 65-6-268-6868 fesinfo@molex.com European Headquarters Munich, Germany 49-89-413092-0 eurinfo@molex.com Corporate Headquarters 2222 Wellington Ct. Lisle, IL 60532 U.S.A. 630-969-4550 Fax: 630-969-1352

Visit our Web site at http://www.molex.com

Doc No: ATS-638404000 Revision: B Release Date: 02-19-99 Revision Date: 10-27-06 **UNCONTROLLED COPY**