



AM63181AT (11-20-1273)
90075 PHONE PLUG ARBOR PRESS

AM63181AT5 (11-20-1274)

The AM-63181AT series arbor tool was designed for medium level production needs where loose piece plugs are used. These tools consist of an arbor press, (#11-31-6356) a press fixture (11-21-9933) and interchangeable dies (4 and 6 pos. 11-28-0225, and 8 pos. 69020-0140)

To set up the press, install the ram head into the ram on the press and install the screws into the base at opposite corners. The die locates from the screw heads in the base. Set the die into the press with the appropriate plug nest facing out. (see fig.1) If the ram stroke on the press needs adjustment, this can be done by turning the thumb wheel that is located above the ram mounted die holder.

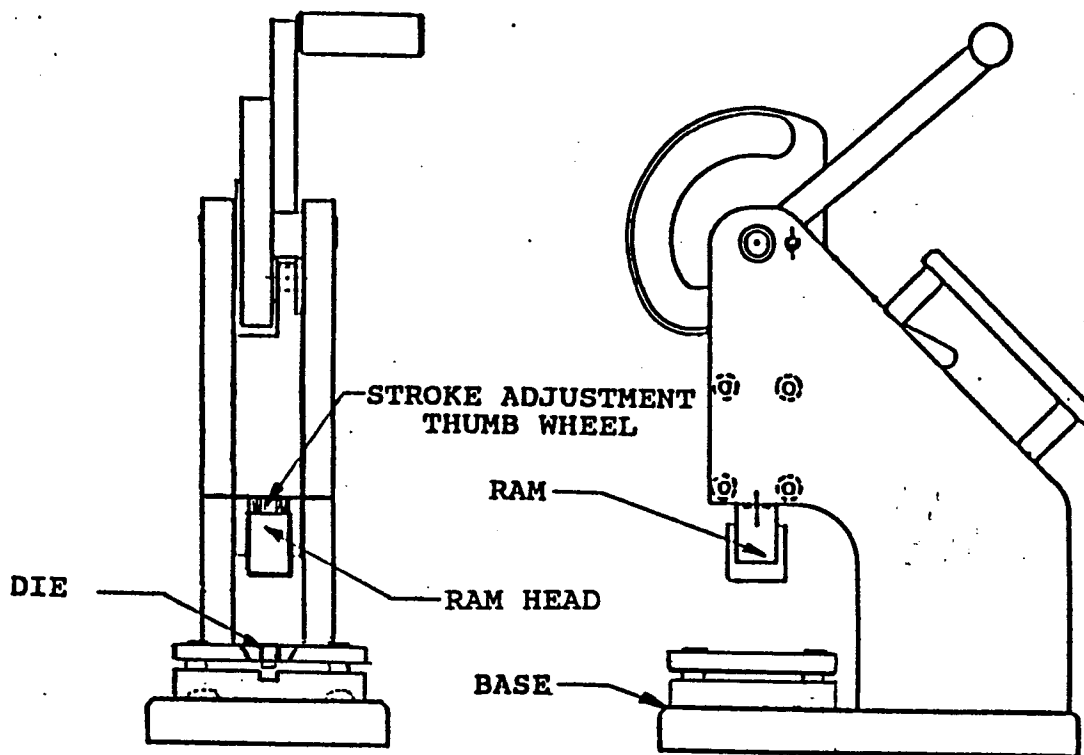


FIG. 1

To assemble a plug to a cable you must first strip the outer jacket of the cable to a length of 7.05mm max - 6.35mm min / .277" max - .25" min. Wires should be equal in length within 0.4mm / .016" without damage to the individual wire insulation. Insert the plug into the lower die with the locking latch down and the wire end facing out. (see fig.2)

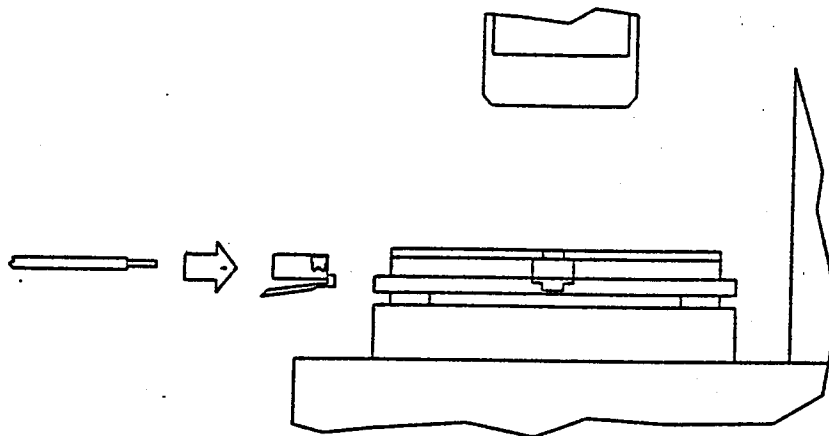
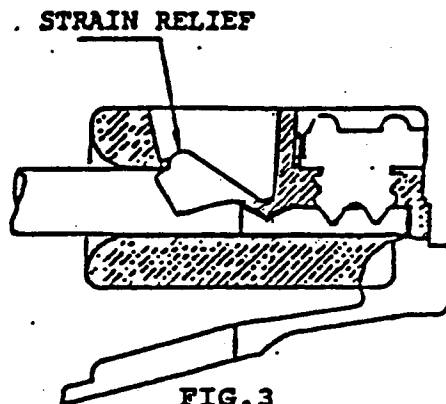


FIG. 2

Push the plug until it locks in position. Then insert the prepared cable into the plug and push it full forward. While holding the cable with one hand, pull the lever on the arbor press full forward until the ratchet releases. Then return the lever. Now the assembly can be removed by depressing the locking latch on the plug and pulling it out of the die. A completed assembly should look like fig.3.



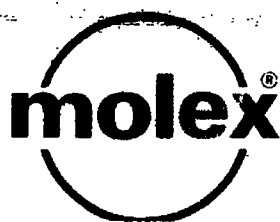
SHEET 1 OF 1

TITLE: PHONE PLUG TOOLING ADAPT. KIT FOR 60026 PRESS	EDP#: 11-21-9933	ENG#: AM63181
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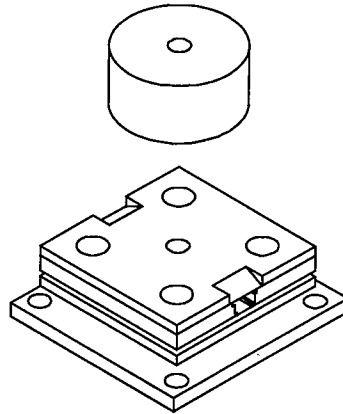


ITEM No	DRAWING No.	SIZE	QTY	DESCRIPTION	REMARKS
1	69020-0141	A2	1	BASEPLATE.	
2	69020-0142	A2	1	PUNCH PLATE.	
3	69020-0143	A2	1	LOCATION PLATE.	
4	69020-0144	A2	1	TOP PLATE.	
5	69020-0145		2	CLAMP PLATE.	
6	69020-0146	A3	2	STRAIN RELIEF PUNCH.	
7	69020-0127	A3	1	INSERTION PUNCH, 8/8.	
8	69020-0122	A3	1	INSERTION PUNCH, 8/6.	
9	69020-0148	A3	1	PUSHER.	
12	69020-0147	ND.	4	BALL BUSHING $\phi 8 \frac{1}{8} \times \phi 15 \frac{9}{16} \times 20$. LG.	SPERAX TYPE 815 OR EQUIV. (LBA 8x15x20)
15	69011-8013		4	COMPRESSION SPRING.	LEE. LC-045E-8
18	69011-0026		4	SOC HD CAPSCREW. M4 x 6. LG	
21	69011-1033		4	SOC C/SUNK SCREW. M5 x 14. LG.	
24	69011-2006		4	BUTTON HEAD SOC SCREW. M4 x 10. LG	
26	69011-3002		1	SOC SHLDR SCREW. $\phi 6 \times M5 \times 16$. LG	
28	69011-4011		2	SOC SET SCR'W (DOG POINT) M4 x 6. LG	
30	69011-7038		4	DOWEL. $\phi 8 \times 35$. LG	
32	69011-2601		2	SPRING PLUNGER. M4 x 15 LG	
33	69011-2602		1	SPRING PLUNGER M5 x 18 LG	
34	69020-0136		4	SOC SET SCR'. M4 x 5. LG.	
COMPILED T.A.		TITLE. FIXTURE FOR W.E. 8/8 & 8/6 SHORT HOUSING CONNECTOR.			DRAWING NUMBER. 69020-0140
DATE 9/10/86					ISSUE A B C D E F
					SHEET 1. OF 1.



ARBOR PRESS FIXTURE PART No. 69020-0140

FOR MOLEX PRODUCT ENG No. 90075 8/6 & 8/8 WAY



DESCRIPTION

This fixture is used to terminate 90075 8/6 and 8/8 Way connectors onto pre-cut and stripped cable.

FEATURES

1. This fixture can only be used in a standard Arbor Press part No. 69020-0660.
2. 3 - Termination positions.
3. For loose piece terminals only.
4. Hand loading of assembled connector and cable.

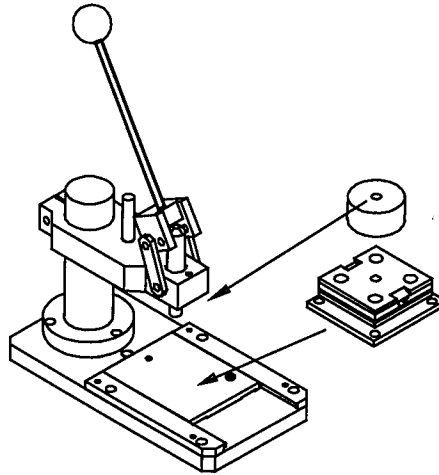
SPECIFICATION

SIZE: 100mm x 100mm x 50mm

WEIGHT: 3Kg

WORKING SERVICES: None

SET-UP



- 1) Fix upper block onto Arbor Press spindle and tighten locking screw.
- 2) Place lower termination fixture onto mounting platform of Arbor Press.
- 3) Make a few samples following the next section (operation) and then check termination heights. If adjustment is required see adjustments section.

OPERATION

- 1) Insert connector into lower termination block.
- 2) Push pre-stripped cable into connector.
- 3) Pull handle down fully to terminate connector.
- 4) Turn handle to start position.
- 5) Release connector latch and SLIDE harness backwards out of fixture.

ADJUSTMENTS

- 1) If termination height is incorrect then follow the procedure below.
- 2) Loosen the stud nuts in the centre of the Arbor Press.
- 3) Loosen clamp bolt to column at the rear of the Arbor Press.
- 4) Adjust upper part of Arbor Press up or down using the nuts on the central stud.
- 5) Re-tighten nuts and clamp bolt.
- 6) Recheck termination height.

MAINTENANCE

- 1) Keep fixture clean at all times.
- 2) Clean fixture with brush.
- 3) Oil moving parts weekly, when in use.
- 4) Store in a clean dry environment.

SPARE PARTS

Insertion Punch 8/6 Way 69020-0122

Insertion Punch 8/8 Way 69020-0127

Strain Relief Punch 69020-0146

QUALITY

Check termination quality against the Molex wire termination specification for relevant product being terminated eg: PS-90650.

A quality procedure should be in place to monitor output from this fixture.

LIMITATIONS

This Arbor Press Fixture can only be used for product stated in the description of this leaflet.

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