

## OPERATION AND SERVICE INSTRUCTIONS

- MOLEX -

ARBOR TERMINATOR FOR .156 SPACED I.D. CONNECTORS

AM-7223-126 (11-20-0314)

### DESCRIPTION

The arbor terminator is a small bench mounted press containing fixtures to assemble ribbon cable to pre-loaded I.D. connectors. It is low cost terminator intended for medium volume of assembly. Rates are determined by operator efficiency since the operator controls all steps in the operation; loading a connector, positioning pre-cut cable, lowering the press ram, and removing a completed assembly.

### PRODUCT SPECIFICATIONS

Pre-notched cable with conductors on .156 spacing can be terminated into the following housings; 7674, 7675 and 7223. Connector circuit size can vary from 2 to 16 circuits.

### TO OPERATE

1. Slide a connector into the pocket in the lower fixture block. Orientate the connector so the exposed terminals and wire slots face up and the housing rib is on the left side of the connector. Push the connector to the rear wall of the pocket where a spring loaded ball plunger will engage an opening in the connector side to position the housing.
2. Locate the ribbon cable with its edge along the guide bar at the rear. The pre-notched area of the cable is visually lined up over the connector. For "daisy chain" terminations, the notch openings is centered across the connector width. For cable end termination, the pre-cut cable is moved from left to right until the wire ends lay across the connector.

3. Holding the cable in position, depress the arbor handle until the downward motion is stopped by the displacement adjusting screw. Release handle and pull cable assembly forward out of the fixture holding block.

#### TO ADJUST THE ARBOR TERMINATOR

1. The cable should be pushed into the connector until the cable insulation just touches or is .010 inches (0.25) above the bottom of the housing wire slot. To adjust this displacement depth, turn the stop screw located in the block fastened to the top of the arbor ram.
2. Support rods on the rear cable guide can be relocated to provide maximum contact for the cable without interfering with connectors already assembled to the cable.
3. The displacement teeth should enter a connector without touching the contact. If realignment is needed, move the lower fixture block by loosening the two screws holding the block to the arbor. Retighten lower block with the ram down and engaged in connector housing.

#### MAINTENANCE

Lubricate the arbor press monthly by introducing a small quantity of grease through the grease fitting in the handle support.

Spare parts are not normally supplied. Should a problem or question arise, please contact the factory.

Molex, Inc.  
Application Tooling Department  
2222 Wellington Court  
Lisle, IL 60532  
312/969-4550

FEB 28 1989

P A R T S L I S T

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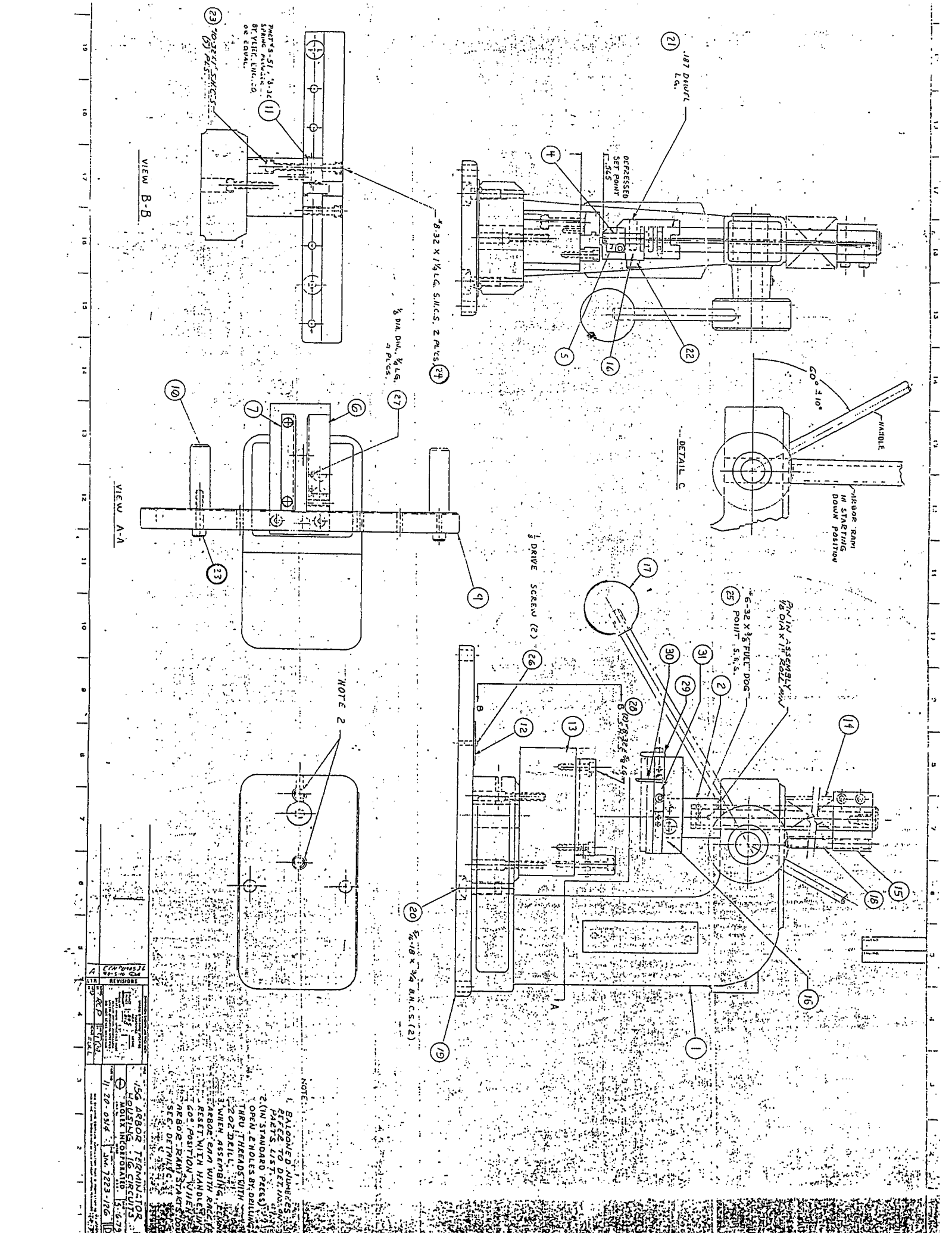
Title:		Main Assy.	
ARBOR TERMINATOR - .156 FOR 7223 HSG. - 16 CIRCUITS		Eng. No. AM7223-126	E.D.P. No. 11-20-0314

Det. No.	Eng. No.	Dwg. Size	Qty.	Description	*	E.D.P. No.
	AM7223-126	D		Assembly - Arbor Terminator		
1	AM4700-25	D	1	Lever Press Modification	CM	11-21-0698
2	AM7223-52	A	1	Press Chuck		11-21-1627
4	-127	C	1	L.H. Insertion Blade 16 Ckt.		11-21-2407
5	-128	C	1	R.H. Insertion Blade 16 Ckt.		11-21-2408
6	-129	A	1	Left Plate		11-21-2409
7	-130	A	1	Right Plate		11-21-2410
9	-58	A	1	Cable Guide Bar		11-21-1632
10	-59	A	2	Cable Support		11-21-1633
11	-43		1	Spring Plunger, Vlier S-51		11-21-1634
12	4968		1	Molex Serial Tag	C	11-17-0676
13	AM7223-131	A	1	Base Block		11-21-2411
14	-44		2	Comp. Spring Assoc. #C0975-092 -3000S	C	11-21-1636
15	-41		1	Arbor Down Stop - Janesville	C	11-21-1245
16	-42	A	1	Clamp Bar - Chuck		11-21-1637
17	AM4700-40		1	Ball Knob Reids #B-32	C	11-21-4970
18	AM7223-45	A	1	Stop Screw		11-21-1638
19	AM4700-26	B	1	Base Plate		11-10-1050
20			2	5/16-18 x 3/4 BHCS	C	
21			1	3/16 Dia. x 7/8 Lg. Dowel	C	
22			1	1/4-20 x 7/8 Lg. Soc. HSS	C	
23			8	#10-32 x 1" Soc. HSS	C	
24			2	#8-32 x 1 1/4" Soc. HCS	C	
25			1	#6-32 x 3/8 Full Dog Point SS	C	
26			2	1/8 Drive Screw	C	
27			4	1/8 Dia. x 3/4 Lg. Dowel	C	
28			2	#8-32 x 5/8 Lg. SHCS	C	
29	AM7223-133	A	1	End Wall Retainer		11-21-5517
30	-134	A	1	Floating Retainer		11-21-5518
31	-135	A	1	Floating Retainer Mtg. Block		11-21-5519

\*MANUFACTURING CODES  
 C=COMMERCIAL PART  
 M=SUPPLIED BY MOLEX  
 S=MADE IN SHOP

CM=COMMERCIAL PART MODIFIED  
 P=PERISHABLE TOOLING  
 SS=SEE SUPPLEMENT SHEET

CO=CUSTOMER ORDER  
 R=REPLACEMENT PART  
 SE=SEE ENGINEERING



REV	DESCRIPTION	DATE	BY	CHKD
1	ASSEMBLY	11-20-64	...	...
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NOTE 1: BALLOONED NUMBERS REFER TO DETAIL PARTS LIST.

NOTE 2: (IN STANDARD PAGES) OPEN & HOLES BY DRILLING THROUGH THROUS WITH 1/8" DIA. DRILL.

NOTE 3: WHEN ASSEMBLING ARBOG, LEAN WITH ARBOG REET WITH HANDLE IN 60° POSITION, WHEN ARBOG REAM STARTS, SEE DETAIL C.

ARBOG TERMINATOR HOUSING 1/8" CIRCUITS

11-20-64 7223-176