

## OPERATION AND SERVICE INSTRUCTIONS

- MOLEX -

ARBOR TERMINATOR FOR .156 SPACED I.D. CONNECTORS

AM7223-140 (11-20-0815)

### DESCRIPTION

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

### PRODUCT SPECIFICATIONS

Individual wires or cable can be terminated into the following housings: 7660 and 7664. Connector circuit size can vary from 2 to 16 circuits. Wire and insulation diameters should be matched to the insulation slot in the connector terminal following connector product guidelines.

### 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.

### INDIVIDUAL WIRE TERMINATION

2. Individual wires should be positioned above the connector contact where they are to be terminated. Push one wire down into the connector deep enough to have the plastic barbs on each side of the connector spring open above the wire insulation. These barbs will hold the wire in position above the connector contact. Place all wires, needed in the cable assembly, into the connector in the same manner.

3. When all wires are in place, push them into the connector in one stroke. Move the arbor handle downward until motion is stopped by the displacement adjusting screw. Release the handle and pull the connector assembly forward out of the holding block.

#### RIBBON CABLE TERMINATION

4. 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 are 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.
5. 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 wire or cable should be pushed into the connector until the 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 carefully with the ram down and engaged in connector housing to establish the proper location.

#### 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 arise, please contact the factory.

Molex, Inc. 2222 Wellington Ct.  
Application Tooling Department Lisle, IL 60532

(312) 969-4550