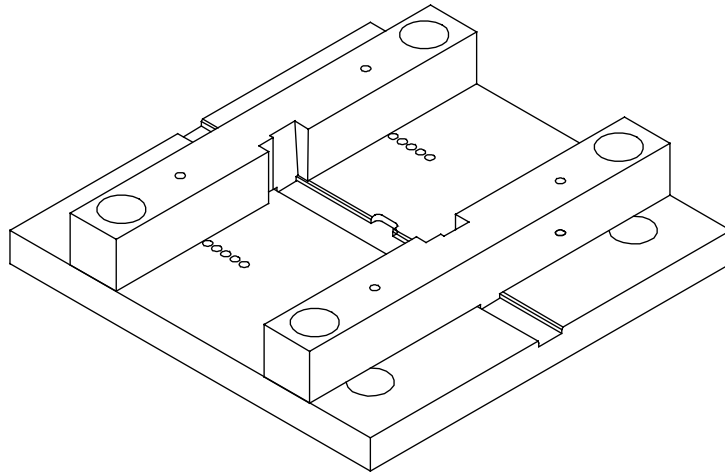# ARBOR PRESS FIXTURE
PART No. 69020-2025

FOR MOLEX PRODUCT ENG. No 91317

DESCRIPTION

This fixture is used to terminate Molex connector 91317, 3 to 16 ckt. onto pre-cut ribbon cable.

FEATURES

1.   This fixture can only be used in a standard Arbor Press part No. 69020-0660.

2.   Adjustable from 3 to 16 ckt.

3.   For loose piece terminals only.
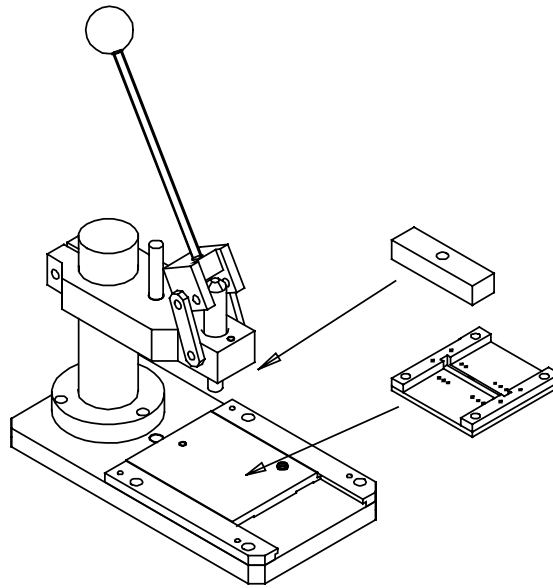
4.   Hand loading of connector and cable.

SPECIFICATION

SIZE: 100mm x 100mm x 50mm

WEIGHT: 1.25 kg

WORKING SERVICES: None.

SET-UP

1)   Place lower termination fixture onto mounting platform of Arbor Press, locating it onto the two mounting pins.

2)   Adjust positioning bars to keep connector central on the base plate.

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-cut ribbon cable into connector.

3)   Pull handle down fully to terminate connector.

4)   Turn handle to start position.

5)   Remove connector from 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 two 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.

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.