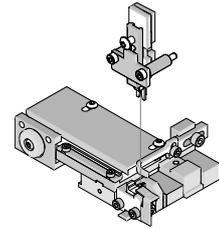


**T2 Terminator Tooling**



**Application Tooling Specification Sheet**



**Order No. 63912-2800**

**FEATURES**

- It is ideally suited for mid-volume bench operations
- This terminator can be installed in the TM42 and the TM40 press or Base Unit adapter for 3BF press
- Quick punch removal with the push of a button for fast and easy tooling change
- Track adjustment capabilities in the T2 Terminators for improved control of the bell mouth size and cutoff tab length
- T2 Terminator has standardized tooling with the Molex FineAdjust Applicator which will reduce your inventory requirements

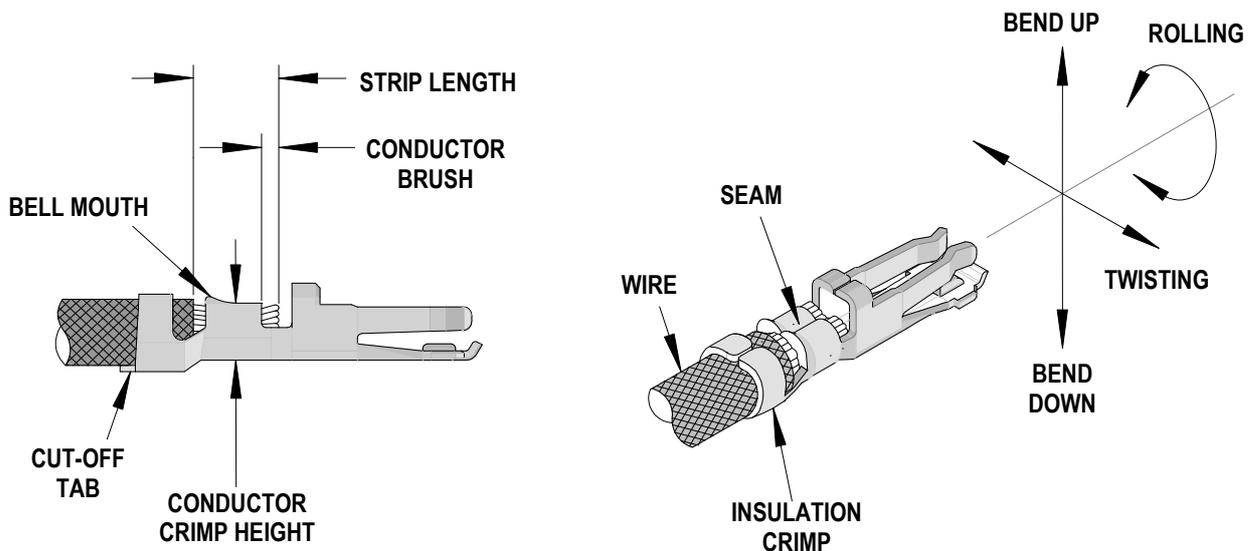
**SCOPE**

Products: 2.0 W/B Receptacle Terminals, 22-26 AWG.

Terminal Series No.	Terminal Order No.	Wire Size		★ Insulation Diameter		Strip Length	
		AWG	mm <sup>2</sup>	mm	In.	mm	In.
503657	503657-1000	22-26	-	0.90-1.50	.035-.059	1.90-2.10	.075-.083

★ Insulation crimp to meet IPC/WHMA-A-620 Class 2 compliance.

**DEFINITION OF TERMS**



### CRIMP SPECIFICATION

Terminal Series No.	Bell mouth		Cut-off Tab Maximum		Conductor Brush	
	mm	In.	mm	In.	mm	In.
503657	0.10-0.45	.004-.018	0.10	.004	0.10-0.65	.004-.026

Terminal Series No.	Bend up	Bend down	Twist Roll		Punch Width (Ref)				Seam Seam shall not be open and no wire allowed out of the crimping area
	Degree Max.		Degree Max.		Conductor		Insulation		
					mm	In	mm	In	
503657	4	2	3	6	1.20	.047	1.50	.059	

After crimping, the crimp profiles should measure the following:

Terminal Series No.	Wire Size		Conductor				Insulation				Pull Force Minimum	
			Crimp Height		Crimp Width (Ref)		Crimp Height Maximum		Crimp Width (Ref.)			
	AWG	mm <sup>2</sup>	mm	In.	mm	In.	mm	In.	mm	In.	N	Lb.
503657	22	-	0.78-0.83	.031-.033	1.20	.047	1.80	.071	1.50	.059	39.2	8.8
	24	-	0.70-0.75	.027-.029	1.20	.047	1.83	.072	1.50	.059	29.4	6.6
	26	-	0.65-0.70	.025-.027	1.20	.047	1.73	.068	1.50	.059	19.6	4.4

■ Tool Qualification Notes:

1. Pull Force should be measured with no influence from the insulation crimp.
2. The above specifications are guidelines to an optimum crimp.

**PARTS LIST**

<b>T2 Terminator 63912-2800</b>				
<b>Item</b>	<b>Order No</b>	<b>Engineering No.</b>	<b>Description</b>	<b>Quantity</b>
<b>Perishable Tooling</b>				
	63912-2870	63912-2870	Tool Kit (All "Y" Items)	REF
1	63457-0081	63457-0081	Conductor Punch	1 Y
2	63455-0045	63455-0045	Conductor Anvil	1 Y
3	63454-0061	63454-0061	Insulation Punch	1 Y
4	63456-0085	63456-0085	Insulation Anvil	1 Y
5	63443-0005	63443-0005	Cut-Off Plunger	1 Y
6	63443-0012	63443-0012	Front Plunger Retainer	1 Y
<b>Other Components</b>				
7	11-18-4083	60707-8	Feed Guide	1
8	11-24-1067	4996-4	Cut-off Plunger Spring	1
9	63443-0009	63443-0009	Scrap Chute	1
10	63443-0024	63443-0024	Key	1
11	63443-0085	63443-0085	Wire Stop L-Bracket	1
12	63443-0090	63443-0090	Wire Stop	1
13	63443-1719	63443-1719	18.90mm Height Spacer	1
14	63443-2216	63443-2216	16.00mm Coarse Spacer	1
15	63443-2318	63443-2318	3.90mm Fine Spacer	1
16	63443-2803	63443-2803	Front Plunger Striker	1
17	63443-2905	63443-2905	Wire Hold-Down Plunger	1
18	63443-6003	63443-6003	Rear Cover	1
19	63443-7201	63443-7201	Spring Cover	1
20	63600-0021	63600-0021	Striker Plunger Spring	1
21	63600-2972	63600-2972	Collar	2
<b>Frame</b>				
22	63800-8500	63800-8500	T2 Terminator	1
<b>Hardware</b>				
23	N/A	N/A	M3 by 6 Long SHCS	2**
24	N/A	N/A	M3 by 6 Long FHCS	1**
25	N/A	N/A	M4 by 6 Long SHCS	2**
26	N/A	N/A	M4 by 12 Long BHCS	2**
27	N/A	N/A	M4 by 14 Long SHCS	2**
28	N/A	N/A	M4 by 30 Long SHCS	2**
29	N/A	N/A	M4 by 50 Long SHCS	2**
30	N/A	N/A	M5 by 12 Long SHCS	1**
31	N/A	N/A	#10-32 by 3/8" Long BHCS	1**
** Available from an industrial supply company such as MSC (1-800-645-7270).				

### Assembly Drawing

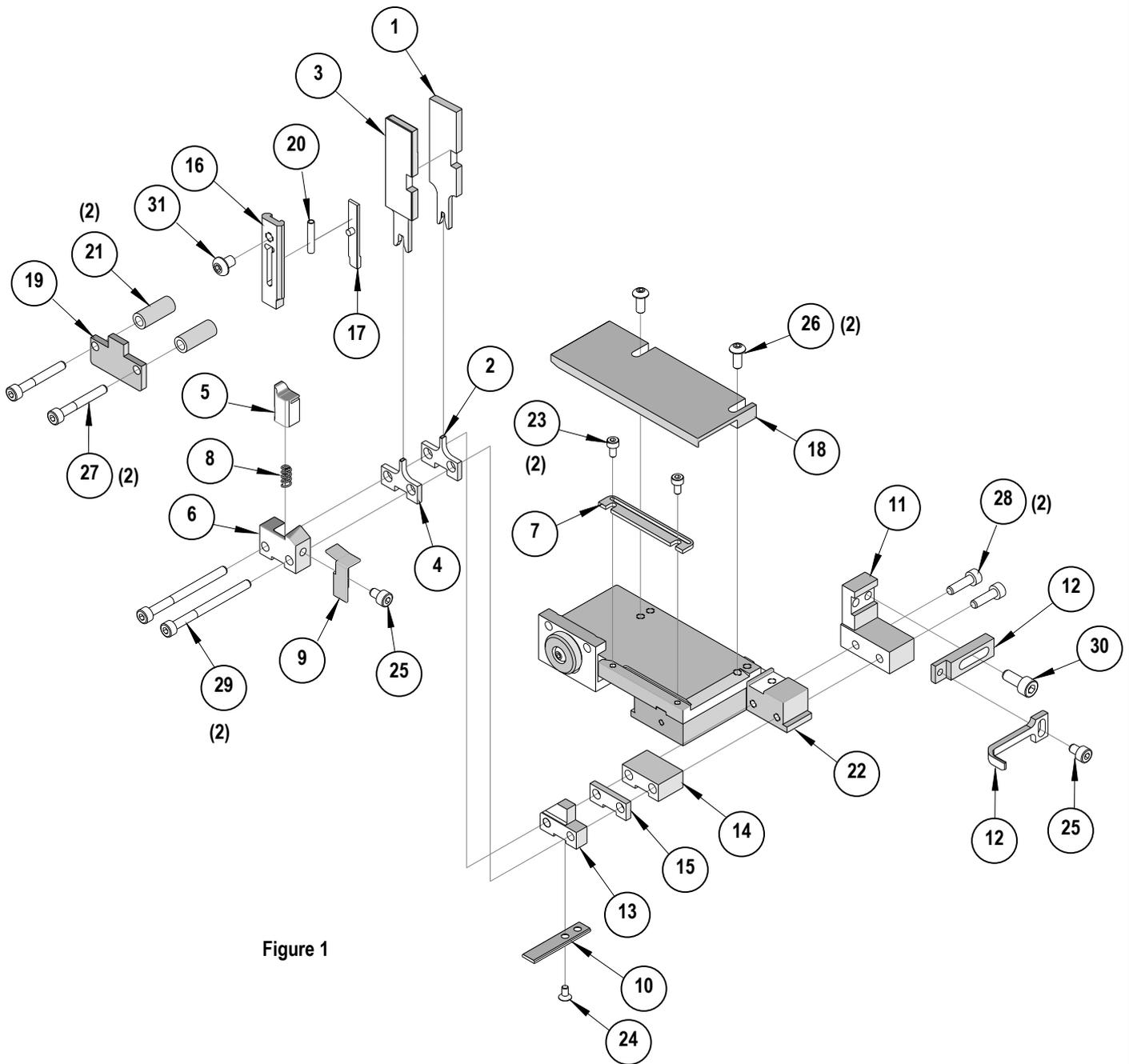


Figure 1

## NOTES

Depending on the press vintage a feed finger assembly is supplied with the T2 Terminator.

1. To remove the existing feed finger assembly loosens the M4 x 10 mm set screw in the feed lever.
2. Select T2 Feed finger assembly from Terminator box.
3. Insert a screwdriver into the slot behind the feed lever and force the feed arm spring to the right.
4. Slide the T2 feed finger shaft for TM42 (11-40-5307) or (11-40-0123) for TM40 /Base Unit into the feed lever and to the left of the feed arm spring.
5. Release the feed arm spring.
6. Position feed finger for selected product. (Refer to Figure 5.1 in the T2 Manual).

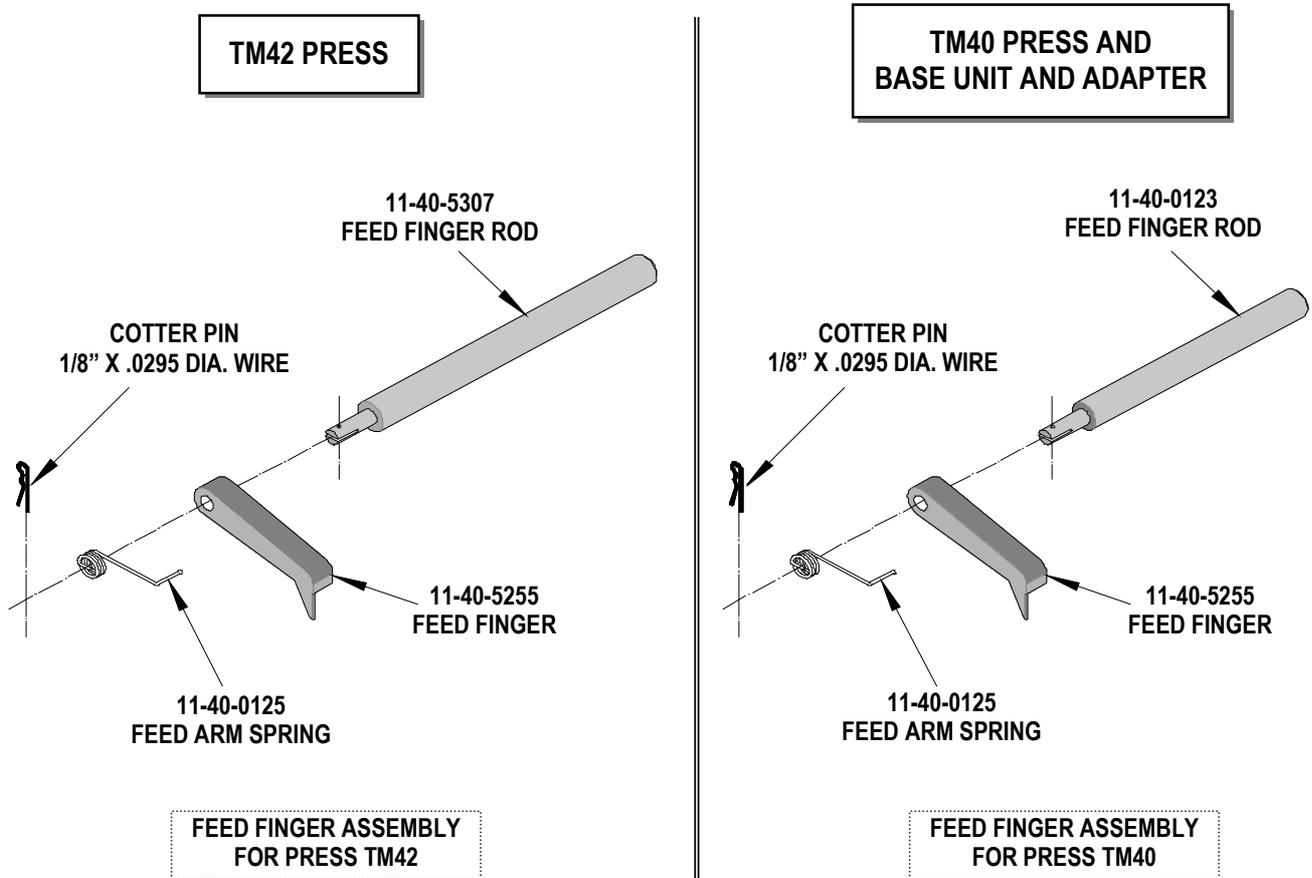


Figure 2

## 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 or 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.

<http://www.molex.com>