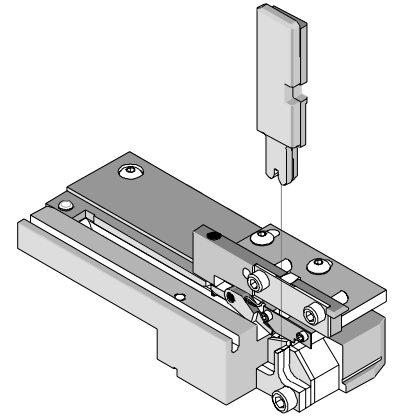




T Style Terminator Tooling Specification Sheet Order No. 11-40-2102 Eng. No. T8305AX



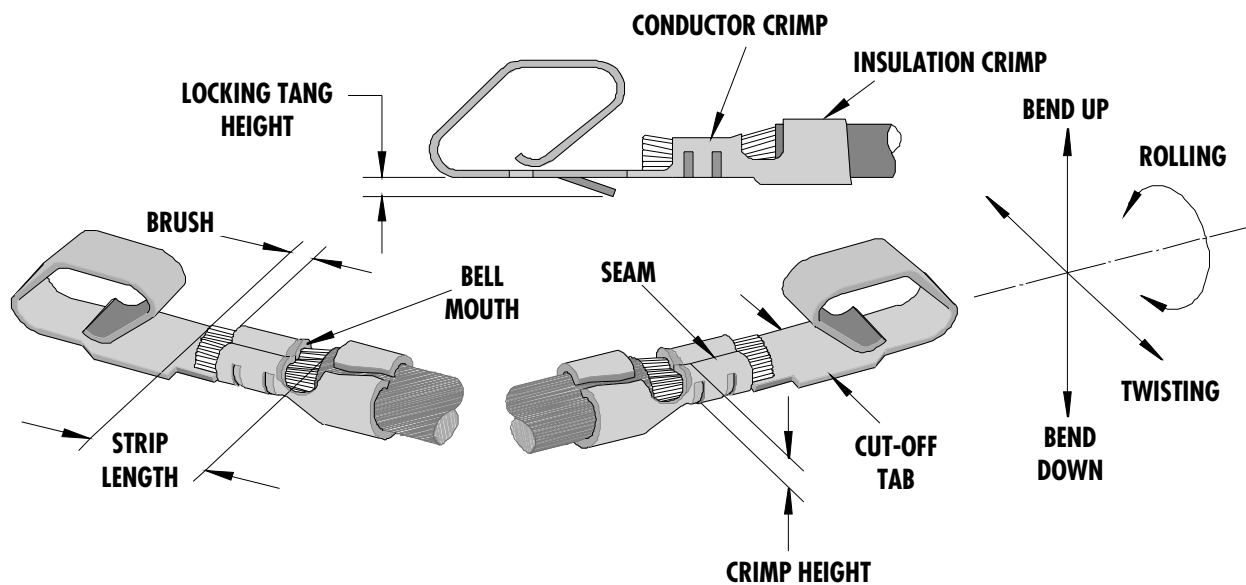
FEATURES

- It is ideally suited for mid-volume bench operations
- This terminator can be installed in the TM42, TM40, and Base Unit adapter for 3BF press
- Quick punch removal with the push of a button for fast and easy tooling change
- Flexible and inexpensive

SCOPE

Terminal Series No.	Terminal Order No.			Wire Size		Insulation Diameter		Strip Length	
				AWG	mm ²	mm	In.	mm	In.
4809	08-50-0030	08-50-0135	08-56-0158	22-30	0.35-0.05	1.12-1.57	.044-.062	2.54-3.18	.100-.125
	08-50-0031	08-55-0110	40-01-0829						
	08-50-0033	08-56-0120	97-00-0450						
8088	08-52-0103	08-65-0105	97-00-0225	22-30	0.35-0.05	1.12-1.57	.044-.062	2.54-3.18	.100-.125
	08-52-0105	40-07-0812	97-00-0227						
	08-52-0107								

CRIMPED TERMINAL



The above terminal drawing is a generic terminal representation. It is not an image of a terminal listed in the scope.

CRIMP SPECIFICATIONS

After crimping, the conductor profiles should measure the following (See Figure 1).

Terminal Series No.	Locking Tang Height		Bend up Bend down		Twist Roll		Punch Width (Ref)				Seam
	mm	In	Degree		Degree		Conductor		Insulation		Seam shall not be open and no wire allowed out of the crimping area
							mm	In	mm	In	
4809	0.64	.025	3	3	4	8	1.60	.063	1.68	.066	
8088	0.64	.025	3	3	4	8	1.60	.063	1.68	.066	

After crimping, the conductor profile should measure the following.

Terminal Series No.	Wire Size		Crimp Height		Pull Force Min.	
	AWG	mm ²	mm	In.	N	Lb.
4809	22	0.35	0.79-0.84	.031-.033	44.88	10.0
4809	24	0.20	0.74-0.79	.029-.031	35.59	8.0
4809	26	0.12	0.68-0.74	.027-.029	26.69	6.0
4809	28	0.08	0.66-0.71	.026-.028	17.79	4.0
4809	30	0.05	0.63-0.66	.026-.027	13.34	3.0
8088	22	0.35	0.79-0.84	.031-.033	44.88	10.0
8088	24	0.20	0.74-0.79	.029-.031	35.59	8.0
8088	26	0.12	0.68-0.74	.027-.029	26.69	6.0
8088	28	0.08	0.66-0.71	.026-.028	17.79	4.0
8088	30	0.05	0.63-0.66	.026-.027	13.34	3.0

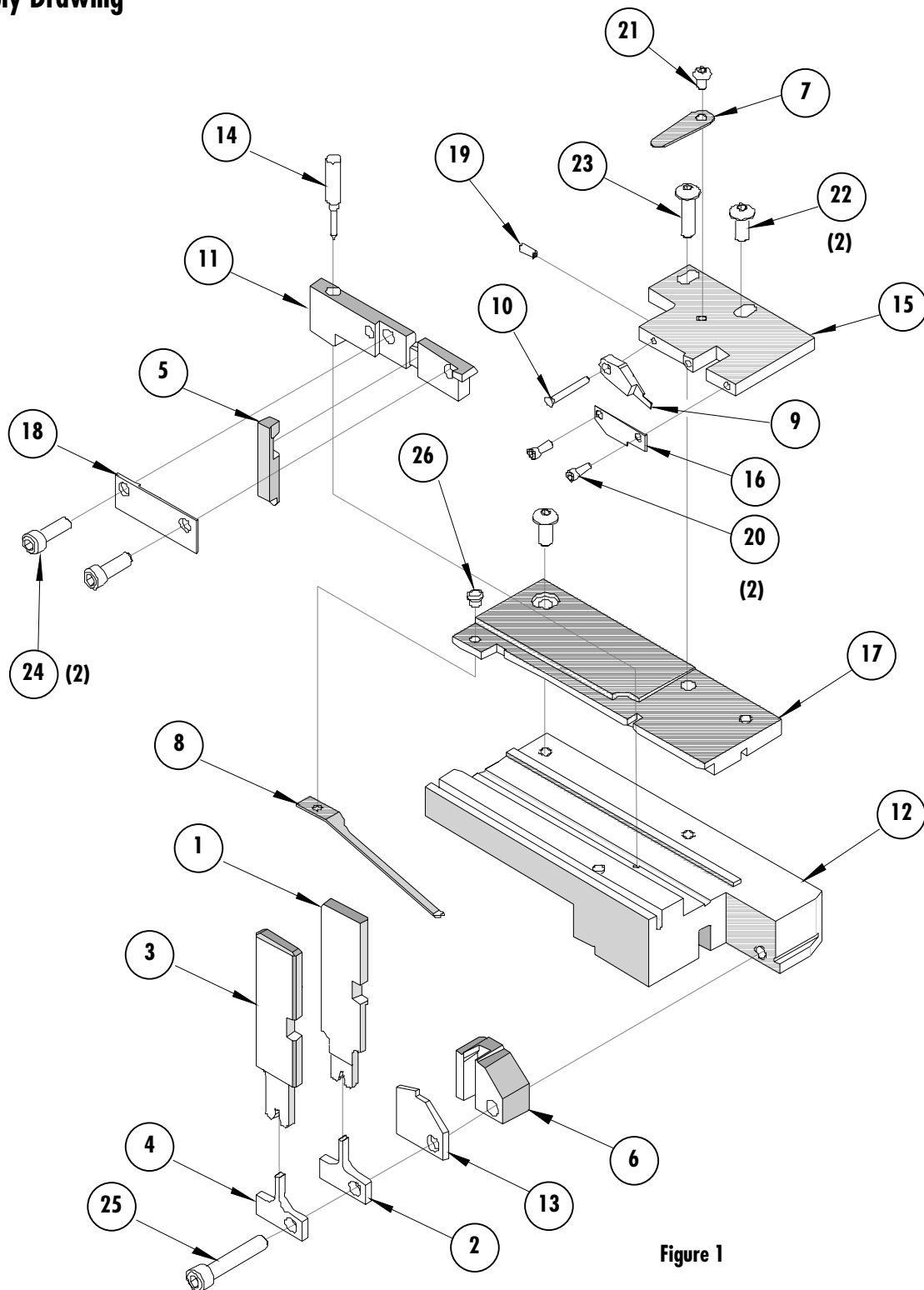
Pull Force should be measured with no influence from the insulation crimp.
The above specifications are guidelines to an optimum crimp.

PARTS LIST

Item	Order No	Engineering No.	Description	Quantity
	11-40-2102	T8305AX	Terminator (Fig. 1)	REF
1	11-40-4018	8305-2	Conductor Punch	1 Y
2	11-24-1239	6118-14	Conductor Anvil	1 Y
3	11-40-4017	8305-1	Insulation Punch	1 Y
4	11-24-1238	6118-13	Insulation Anvil	1 Y
5	11-40-4423	8305-16	Cut-Off Punch	1 Y
6	11-24-1241	6118-16	Cut-off Insert	1 Y
7	11-17-0109	1837-9	Terminal Drag Spring	1
8	11-40-4087	8301-12	Terminal Drag Spring	1
9	11-40-4458	8301-23	Stop Finger	1
10	11-40-4069	8302-103	Pivot Pin	1
11	11-40-4422	8305-3A	Cut-Off Punch and Guide Pin Block	1
12	11-40-4092	8305-4	Terminator Track and Base	1
13	11-40-4094	8305-6	Terminal Stop and Scrap Shield	1
14	11-40-4095	8305-7	Terminal Locating Pin	1
15	11-40-4470	8305-17	Stop Finger Block	1
16	11-40-4471	8305-18	Wire Stop Blade	1
17	11-40-4472	8305-19	Rear Cover	1
18	11-40-4421	8571	Cut-off Punch Retainer Plate	1
19	N/A	N/A	#2-56 by .25 Lg. SSSS	1**
20	N/A	N/A	#2-56 by .25 Lg. SHCS	2**
21	N/A	N/A	#5-40 by 3/16 Lg. BHCS	1**
22	N/A	N/A	#8-32 by 3/8 Lg. BHCS	2**
23	N/A	N/A	#8-32 by 5/8 Lg. BHCS	1**
24	N/A	N/A	#8-32 by 1/2 Lg. SHCS	2**
25	N/A	N/A	#10-32 by 1.0 Lg. SHCS	1**
26	N/A	N/A	1/8 Dia. by 1/8 Lg. Tubular Rivet	1**
	11-40-3102	K8305AX	Tool Kit (All Y Items)	REF

** The following purchased parts are available from an Industrial supply company such as MSC (1-800-645-7270).

Assembly Drawing



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 only be 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 in place. Reference the TM42 press instruction manual.

CAUTION: Molex crimp specifications are valid only when used with Molex terminals, applicators and tooling.

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