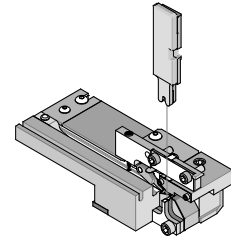


T Style Terminator Tooling

molex

Application Tooling Specification Sheet



Order No. 11-40-2265
Engineering No. T8304DX

FEATURES

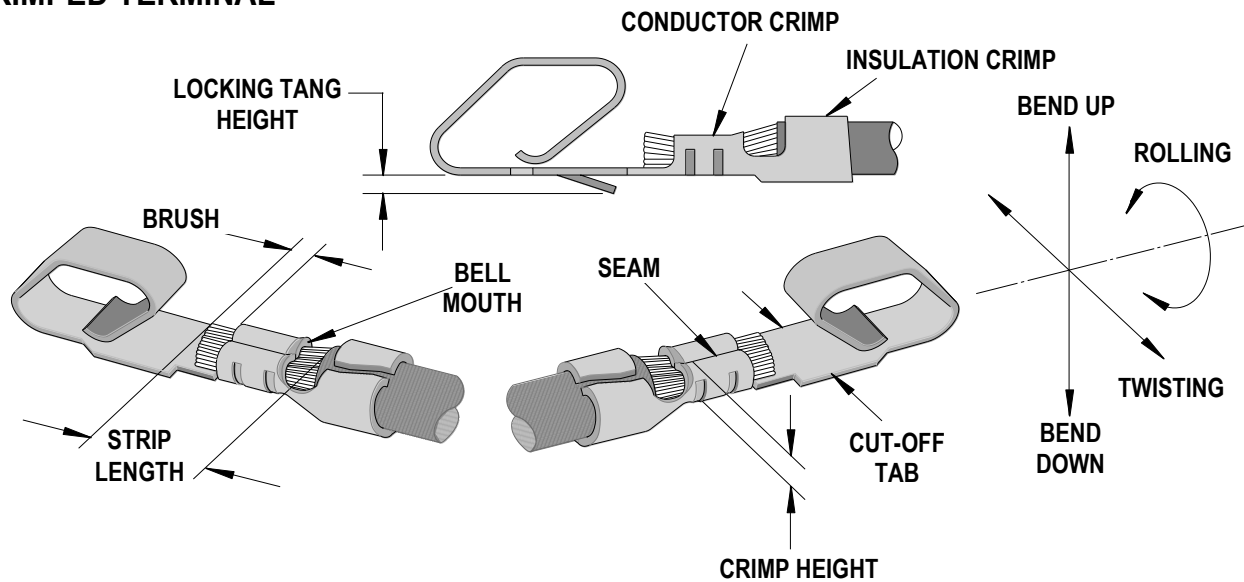
- It is ideally suited for mid-volume bench operations
- This terminator can be installed in the TM42, TM40, and Base Unit adapter for 3BF press
- Quick punch removal with the push of a button for fast and easy tooling change
- Flexible and inexpensive

SCOPE

Products: KK® Crimp Terminal and Cat Ear Crimp Terminals 22-30 AWG.

Terminal Series No.	Terminal Order No.			Wire Size		Insulation Diameter		Strip Length	
				AWG	mm ²	mm	In.	mm	In.
2759	08-50-0113	08-55-0130	39-00-0376	22-30	0.35-0.05	1.09-1.57	.043.062	2.54-3.18	.100-.125
	08-50-0159	08-56-0109	39-00-0378						
	08-50-0274	39-00-0032	39-00-0380						
	08-51-0101	39-00-0064	50-29-1757						
	08-51-0108	39-00-0372							
	08-55-0101	39-00-0374							
5139	08-70-0046			22-30	0.35-0.05	1.09-1.57	.043.062	2.54-3.18	.100-.125
5159	08-70-0048	08-70-0064		22-28	0.35-0.08	1.20-1.70	.047.067	2.80-3.40	.110-.133
6459	08-52-0101	08-65-0801	08-65-0815	22-30	0.35-0.05	1.09-1.57	.043.062	2.54-3.18	.100-.125
	08-52-0118	08-65-0811	08-65-0817						
	08-52-0121	08-65-0813	40-07-0815						
40445	08-50-0321	97-00-0444	97-00-0920	22-30	0.35-0.05	1.09-1.57	.043.062	2.54-3.18	.100-.125
41572	08-65-0804			22-30	0.35-0.05	1.09-1.57	.043.062	2.54-3.18	.100-.125

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.	Bell mouth		Cut-off Tab Maximum		Conductor Brush	
	mm	In.	mm	In.	mm	In.
2759	0.20-0.50	.008-.020	1.85-1.98	.073-.078	0.00-1.00	.000-.040
5139	0.20-0.50	.008-.020	1.85-1.98	.073-.078	0.00-1.00	.000-.040
5159	0.20-0.50	.008-.020	1.85-1.98	.073-.078	0.00-1.00	.000-.040
6459	0.20-0.50	.008-.020	1.85-1.98	.073-.078	0.00-1.00	.000-.040
40445	0.20-0.50	.008-.020	1.85-1.98	.073-.078	0.00-1.00	.000-.040
41572	0.20-0.50	.008-.020	1.85-1.98	.073-.078	0.00-1.00	.000-.040

Terminal Series No.	Locking Tang Height		Bend up Bend down		Twist Roll		Punch Width (Ref)				Seam
	mm	In	Degree	Degree	Conductor		Insulation				
					mm	In	mm	In			
2759	0.51-0.64	.020-.025	3	3	4	8	1.40	.055	1.90	.075	Seam shall not be open and no wire allowed out of the crimping area
5139	0.34-0.60	.013-.024	3	3	4	8	1.40	.055	1.90	.075	
5159	0.40-0.55	.016-.022	3	3	4	8	1.40	.055	1.90	.075	
6459	0.51-0.64	.020-.025	3	3	4	8	1.40	.055	1.90	.075	
40445	0.51-0.64	.020-.025	3	3	4	8	1.40	.055	1.90	.075	
41572	0.51-0.64	.020-.025	3	3	4	8	1.40	.055	1.90	.075	

After crimping, the conductor profile should measure the following.

Terminal Series No.	Wire Size		Crimp Height		Crimp Width (Ref.)		Pull Force Minimum	
	AWG	mm ²	mm	In.	mm	In.	N	Lb.
2759	22	0.35	0.79-0.84	.031-.033	1.37	.054	44.5	10.0
	24	0.20	0.73-0.79	.029-.031	1.37	.054	35.6	8.0
	26	0.12	0.71-0.76	.028-.030	1.37	.054	17.8	4.0
	28	0.08	0.68-0.73	.027-.029	1.37	.054	13.3	3.0
	30	0.05	0.66-0.71	.026-.028	1.37	.054	8.9	2.0
5139	22	0.35	0.79-0.84	.031-.033	1.37	.054	44.5	10.0
	24	0.20	0.73-0.79	.029-.031	1.37	.054	35.6	8.0
	26	0.12	0.71-0.76	.028-.030	1.37	.054	17.8	4.0
	28	0.08	0.68-0.73	.027-.029	1.37	.054	13.3	3.0
	30	0.05	0.66-0.71	.026-.028	1.37	.054	8.9	2.0
5159	22	0.35	0.79-0.84	.031-.033	1.37	.054	44.5	10.0
	24	0.20	0.73-0.79	.029-.031	1.37	.054	35.6	8.0
	26	0.12	0.71-0.76	.028-.030	1.37	.054	17.8	4.0
	28	0.08	0.68-0.73	.027-.029	1.37	.054	13.3	3.0
6459	22	0.35	0.79-0.84	.031-.033	1.37	.054	44.5	10.0
	24	0.20	0.73-0.79	.029-.031	1.37	.054	35.6	8.0
	26	0.12	0.71-0.76	.028-.030	1.37	.054	17.8	4.0
	28	0.08	0.68-0.73	.027-.029	1.37	.054	13.3	3.0
	30	0.05	0.66-0.71	.026-.028	1.37	.054	8.9	2.0
40445	22	0.35	0.79-0.84	.031-.033	1.37	.054	44.5	10.0
	24	0.20	0.73-0.79	.029-.031	1.37	.054	35.6	8.0
	26	0.12	0.71-0.76	.028-.030	1.37	.054	17.8	4.0
	28	0.08	0.68-0.73	.027-.029	1.37	.054	13.3	3.0
	30	0.05	0.66-0.71	.026-.028	1.37	.054	8.9	2.0
41572	22	0.35	0.79-0.84	.031-.033	1.37	.054	44.5	10.0
	24	0.20	0.73-0.79	.029-.031	1.37	.054	35.6	8.0
	26	0.12	0.71-0.76	.028-.030	1.37	.054	17.8	4.0
	28	0.08	0.68-0.73	.027-.029	1.37	.054	13.3	3.0
	30	0.05	0.66-0.71	.026-.028	1.37	.054	8.9	2.0

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

Terminator 11-40-2265 (T8304DX)				
Item	Order No	Engineering No.	Description	Quantity
Perishable Tooling				
	11-40-3267	K8304D	Tool Kit (All "Y" Items)	REF
1	11-40-5376	8304D106	Conductor Punch	1 Y
2	11-40-5377	8304D107	Conductor Anvil	1 Y
3	11-40-4015	8304-1	Insulation Punch	1 Y
4	11-24-1116	6117-8	Insulation Anvil	1 Y
5	11-40-4418	8304-11	Cut-Off Punch	1 Y
6	11-24-1113	6117-5	Cut-off Insert	1 Y
Other Components				
7	11-17-0109	1837-9	Terminal Drag Spring	1
8	11-40-4069	8302-103	Pivot Pin	1
9	11-40-4085	8301-10	Terminal Stop and Scrap Shield	1
10	11-40-4087	8301-12	Terminal Drag Spring	1
11	11-40-4089	8304-5	Terminator Base and Track	1
12	11-40-4091	8304-7	Rear Cover	1
13	11-40-4390	8304-10	Wire Stop Block	1
14	11-40-4391	8304-10A	Wire Stop Blade	1
15	11-40-4417	8304-3A	Cut-Off Punch and Guide Pin Block	1
16	11-40-4421	8571	Punch Retainer	1
17	11-40-4458	8301-23	Stop Finger	1
18	11-40-4461	8304-13	Stop Finger Block	1
Hardware				
19	N/A	N/A	#2-56 by 1/4" Long SSS	1**
20	N/A	N/A	#2-56 by 1/4" Long SHCS	2**
21	N/A	N/A	#5-40 by 3/16" Long BHCS	1**
22	N/A	N/A	#8-32 by 3/8" Long BHCS	1**
23	N/A	N/A	#8-32 by 5/8" Long BHCS	1**
24	N/A	N/A	#8-32 by 1/2" Long SHCS	3**
25	N/A	N/A	#10-32 by 1.0" Long SHCS	1**
26	N/A	N/A	1/8 Diameter by 1/8" Long Tubular Rivet	1**
** Available from an industrial supply company such as MSC (1-800-645-7270).				

Assembly Drawing

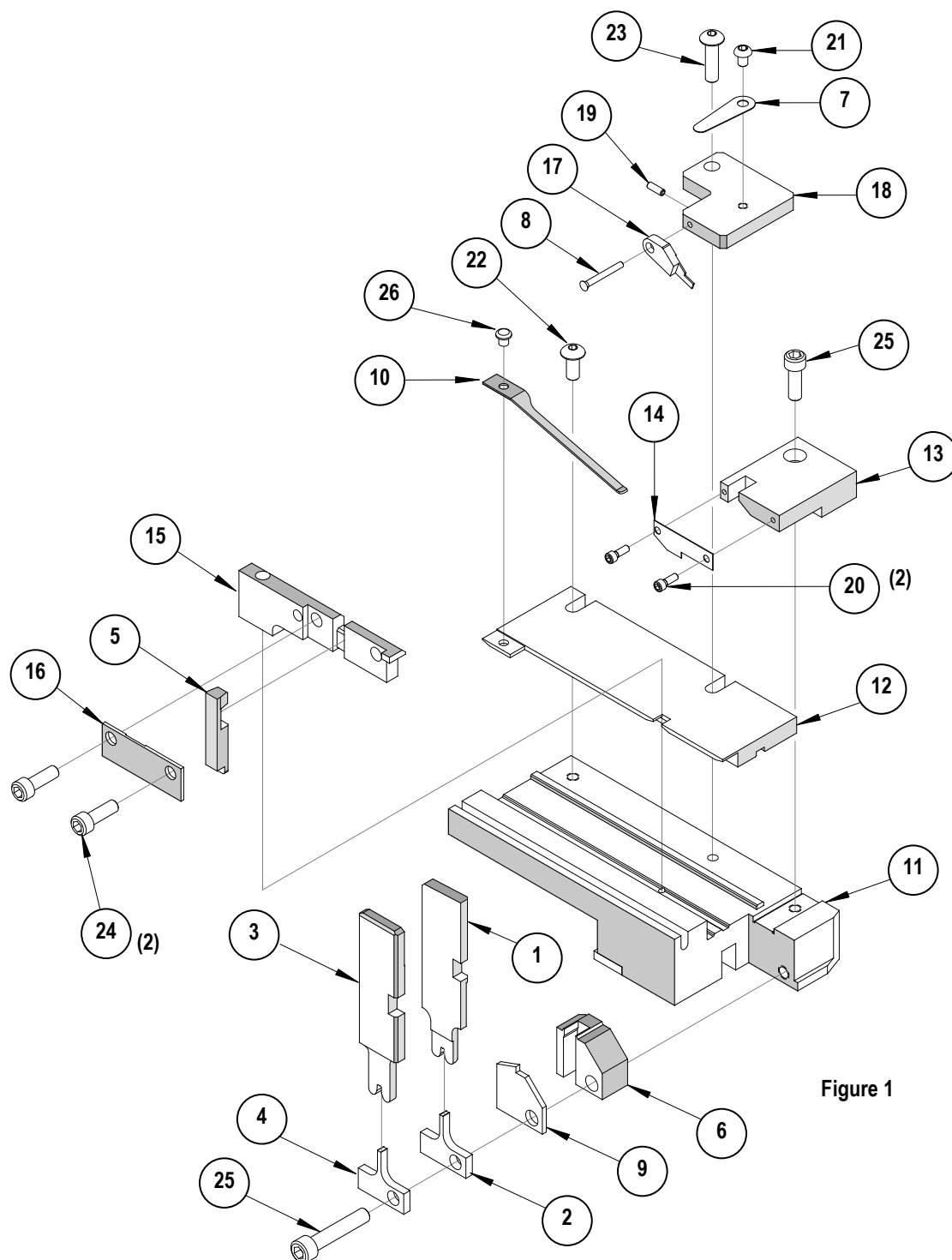


Figure 1

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.

Visit our Web site at <http://www.molex.com>