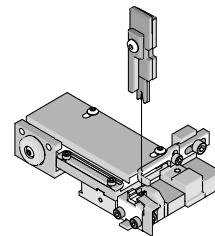


T2 Terminator Tooling

molex

Application Tooling Specification Sheet



Order no. 63912-3200

FEATURES

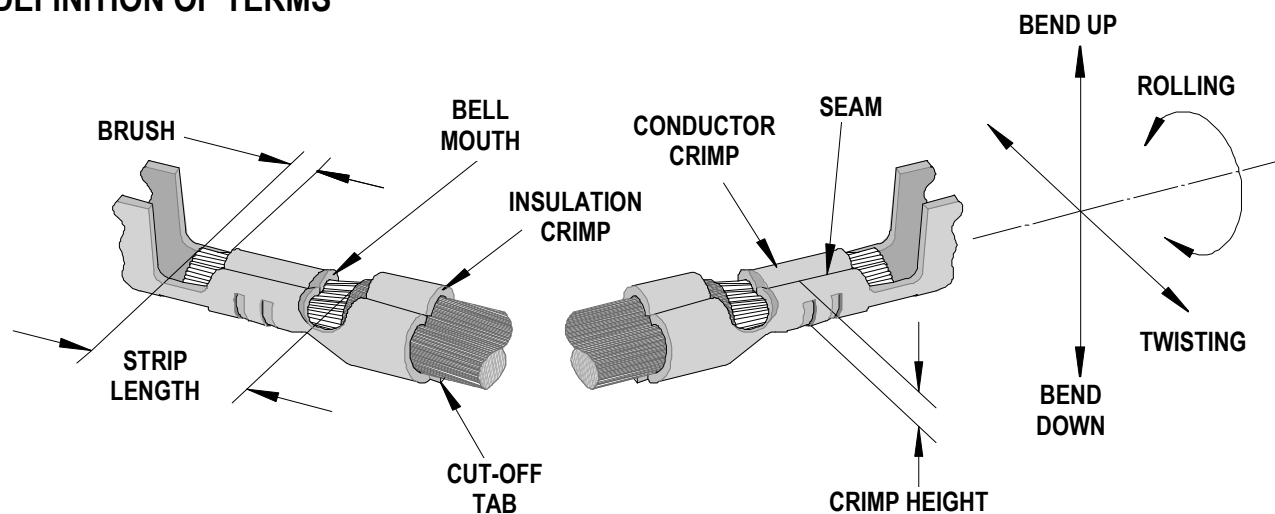
- It is ideally suited for mid-volume bench operations
- This terminator can be installed in the TM42 and the TM40 press or Base Unit adapter for 3BF press
- Quick punch removal with the push of a button for fast and easy tooling change
- Track adjustment capabilities in the T2 Terminators for improved 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: SL™ Female Crimp Terminal, 22-24 AWG.

Terminal Series No	Terminal Order No.			Wire Size		Insulation Diameter		Strip Length	
				AWG	mm²	mm	In.	mm	In.
70058	016-02-0086	016-02-0152	70058-4086	22-24	0.20-0.35	1.40-1.63	.055-.064	3.17-3.56	.125-.140
	016-02-0087	70058-0086	70058-5001						
	016-02-0088	70058-0087							
	016-02-0131	70058-0088							
71851	016-02-1110	016-02-1111	016-02-1124	22-24	0.20-0.35	1.40-1.63	.055-.064	3.17-3.56	.125-.140

DEFINITION OF TERMS



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

CRIMP SPECIFICATION

Terminal Series No.	Bell mouth		Cut-off Tab Maximum				Conductor Brush	
			Front		Rear			
	mm	In.	mm	In.	mm	In.	mm	In.
70058	0.20-0.50	.008-.020	0.13	.005	.08	.003	0.00-1.00	.000-.039
71851	0.20-0.50	.008-.020	0.13	.005	.08	.003	0.00-1.00	.000-.039

Terminal Series No.	Bend up Bend down		Twist Roll		Punch Width mm (Ref)				Seam Seam shall not be open and no wire allowed out of the crimping area
	Degree		Degree		Conductor		Insulation		
					mm	In	mm	In	
70058	3	3	3	8	1.40	.055	1.70	.067	
71851	3	3	3	8	1.40	.055	1.70	.067	

After crimping, the conductor profile should measure the following.

Terminal Series No.	Wire Size		Crimp Height		Pull Force Minimum	
	AWG	mm ²	mm	In.	N	Lb.
70058	22	0.35	0.84-0.89	.033-.035	35.6	8.0
	24	0.20	0.76-0.81	.030-.032	22.2	5.0
71851	22	0.35	0.84-0.89	.033-.035	35.6	8.0
	24	0.20	0.76-0.81	.030-.032	22.2	5.0

Pull Force should be measured with no influence from the insulation crimp.

The above specifications are guidelines to an optimum crimp.

PARTS LIST

T-Style Terminator 63912-3200				
Item	Order No	Engineering No.	Description	Quantity
Perishable Tooling				
	63912-3270	63912-3270	Tool Kit (All "Y" Items)	REF
1	63444-1417	63444-1417	Conductor Punch	1 Y
2	63445-1446	63445-1446	Conductor Anvil	1 Y
3	63454-0123	63454-0123	Insulation Punch	1 Y
4	63445-1730	63445-1730	Insulation Anvil	1 Y
5	63443-0003	63443-0003	Cut-Off Plunger	2 Y
6	63443-0012	63443-0012	Front Plunger Retainer	1 Y
7	63443-1402	63443-1402	Cut-off Die Blade	1 Y
8	63443-1002	63443-1002	Rear Plunger Retainer	1 Y
Other Components				
9	11-17-0022	1739-21	Hold Down Spring	1
10	11-18-4094	60709A111	Front Cover	1
11	11-24-1067	4996-4	Cut-Off Plunger Spring	2
12	11-24-1149	4996-37	Shank	1
13	11-40-4039	8302-5	Front Plunger Striker	1
14	11-40-4274	8331-8	Hold Down Blade	1
15	63443-0025	63443-0025	Dual Carrier Key	1
16	63443-0085	63443-0085	Wire Stop L-Bracket	1
17	63443-0090	63443-0090	Wire Stop	1
18	63443-2600	63443-2600	Front Spacer	1
19	63443-2205	63443-2205	Coarse Spacer (5.00mm)	1
20	63443-2306	63443-2306	Fine Spacer (3.30mm)	1
21	63443-6003	63443-6003	Rear Cover	1
22	63800-8502	63800-8502	Rear Plunger Striker	1
Frame				
23	63800-8500	63800-8500	T2 Terminator	1
24	63860-2015	63860-2015	Drag Frame	1
Hardware				
25	N/A	N/A	M3 by 6 Long SHCS	2**
26	N/A	N/A	M3 by 6 Long FHCS	1**
27	N/A	N/A	M4 by 6 Long SHCS	1**
28	N/A	N/A	M4 by 12 Long BHCS	2**
29	N/A	N/A	M4 by 14 Long SHCS	2**
30	N/A	N/A	M4 by 50 Long SHCS	2**
31	N/A	N/A	M5 by 10 Long SHCS	1**
32	N/A	N/A	M5 by 12 Long SHCS	1**
33	N/A	N/A	#5-40 by 3/8" Long SHCS	1**
34	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

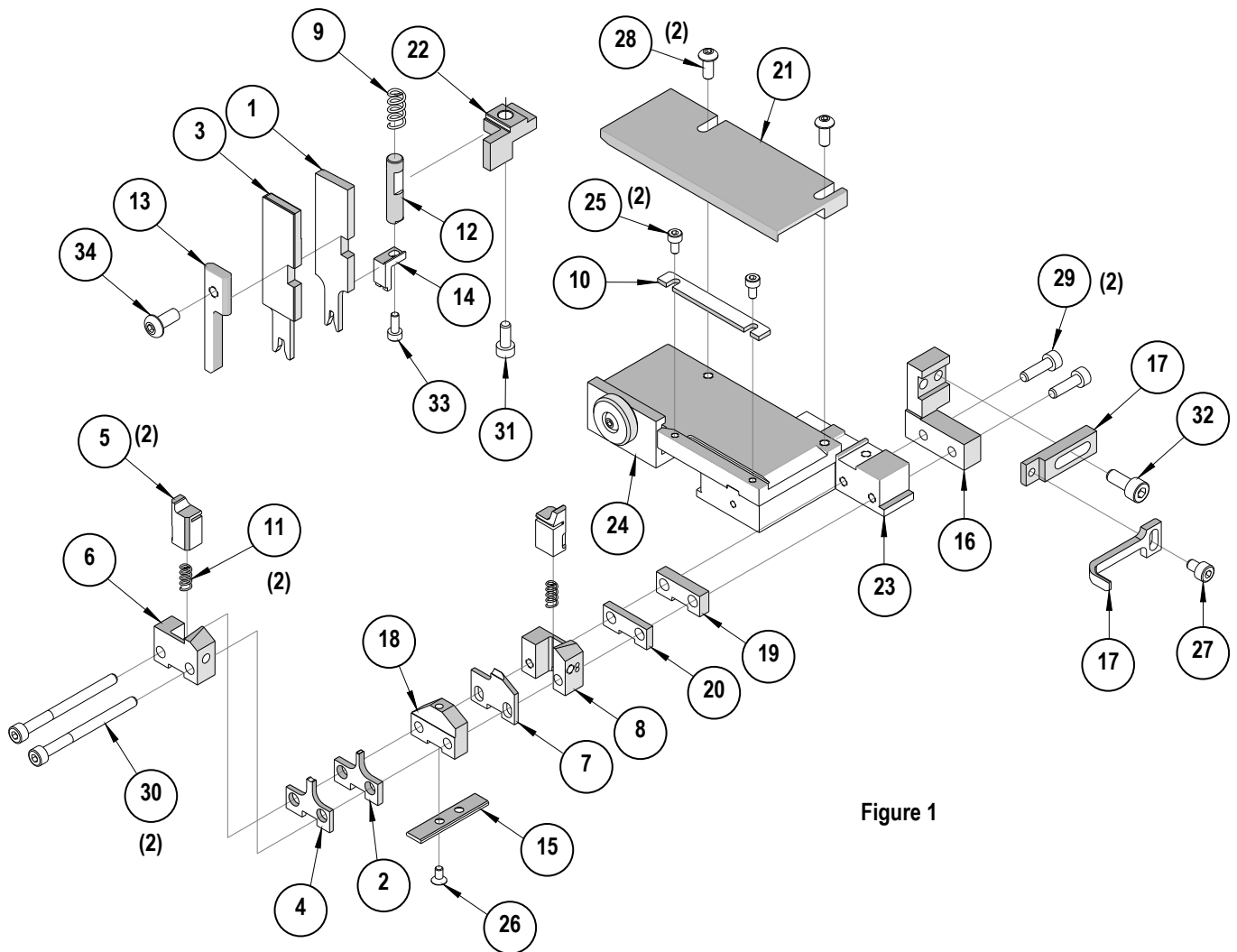


Figure 1

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).

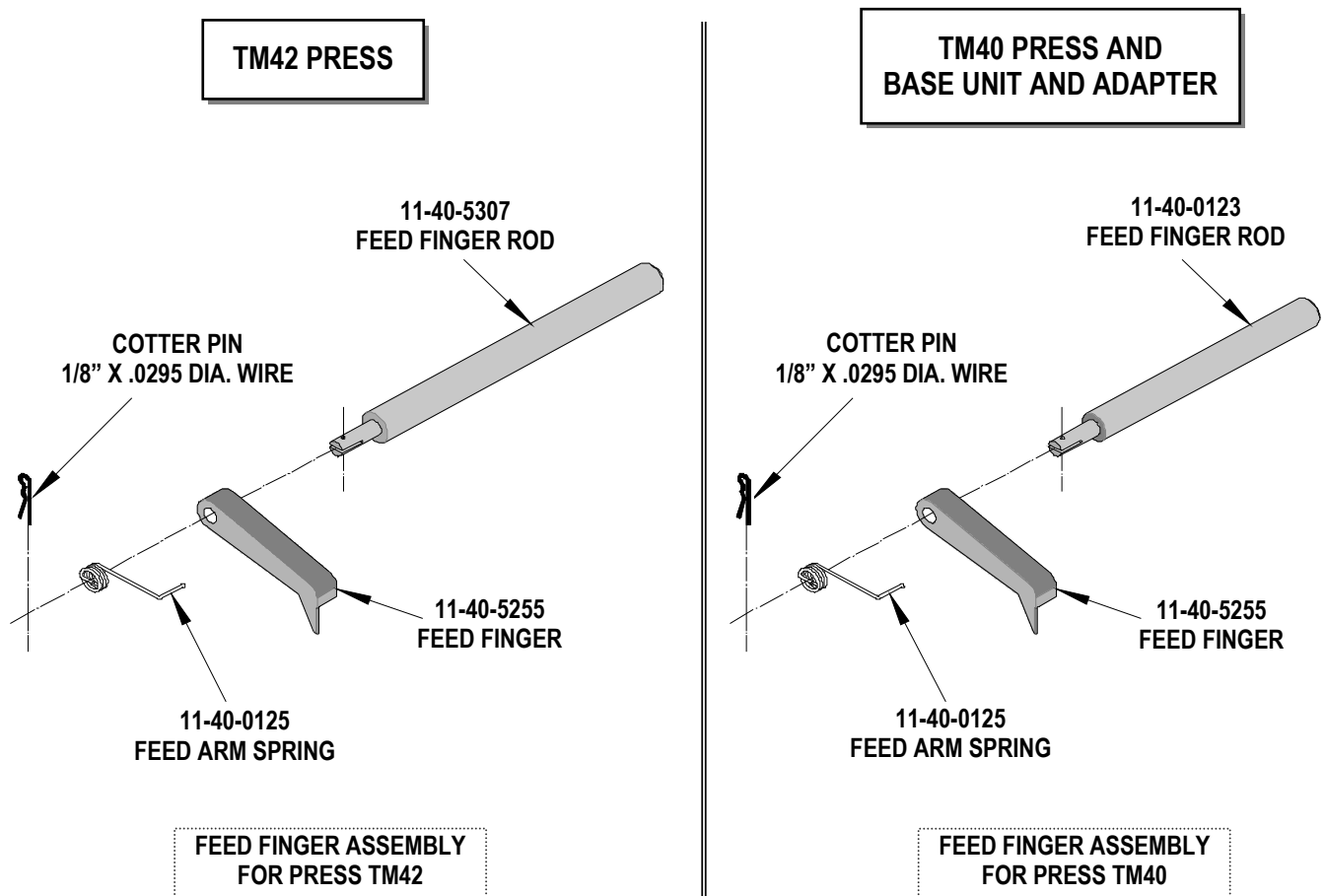


Figure 2

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 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>