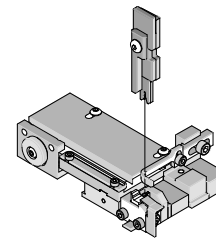


T2 Terminator Tooling

molex

Application Tooling Specification Sheet


Order No. 63911-6000

FEATURES

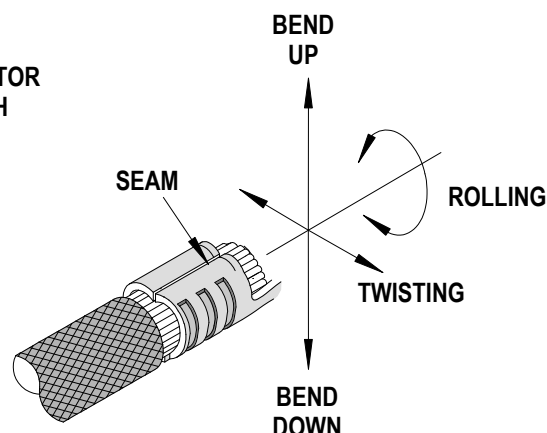
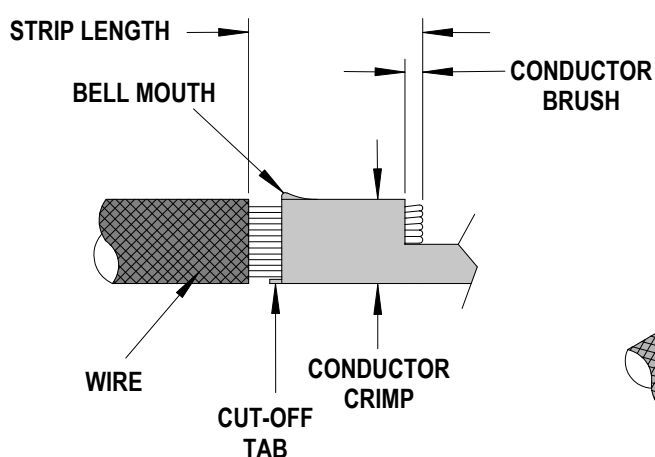
- It is ideally suited for mid-volume bench operations
- This terminator can be installed in the TM42 and the TM40 press or Base Unit adapter for 3BF press
- Quick punch removal with the push of a button for fast and easy tooling change
- Track adjustment capabilities in the T2 Terminators for improved 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: CRC™ (Compact Robot Connector) Power Crimp Pin and Socket Terminals, 18-22 AWG.

Terminal Series No.	Terminal Order No.		Wire Size		Insulation Diameter		Strip Length	
			AWG	mm ²	mm	In.	mm	In.
56193	56193-4028	56193-4085	14-18	2.00-0.80	2.60-3.80	.102-.150	3.70-4.10	.146-.161
	56193-4099							
56194	56194-9028	56194-9085	14-18	2.00-0.80	2.60-3.80	.102-.150	3.70-4.10	.146-.161
	56194-9099							

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	
	mm	In.	mm	In.	mm	In.
56193	0.10-0.50	.004-.020	0.25	.010	0.20-1.00	.008-.039
56194	0.10-0.50	.004-.020	0.25	.010	0.20-1.00	.008-.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
					Conductor		
	Degree (Max)		Degree (Max)		mm	In	
56193	3	3	3	6	2.60	.102	
56194	3	3	3	6	2.60	.102	

After crimping, the crimp profiles should measure the following:

Terminal Series No.	Wire Size	Actual mm²	Conductor Crimp				Pull Force Minimum	
			Crimp Height		Crimp Width (Ref.)		N	Lb.
			mm	In.	mm	In.		
56193	14 AWG	2.00	1.41-1.51	.056-.059	2.65	.104	147.0	33.05
	16 AWG	1.30	1.39-1.49	.055-.058	2.65	.104	127.4	28.64
	18 AWG	0.80	1.20-1.30	.047-.051	2.65	.104	88.2	19.83
56194	14 AWG	2.00	1.41-1.51	.056-.059	2.65	.104	147.0	33.05
	16 AWG	1.30	1.39-1.49	.055-.058	2.65	.104	127.4	28.64
	18 AWG	0.80	1.20-1.30	.047-.051	2.65	.104	88.2	19.83

► 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

T2 Terminator 63911-6000				
Item	Order No	Engineering No.	Description	Quantity
Perishable Tooling				
	63911-6070	63911-6070	Tool Kit (All "Y" Items)	REF
1	63457-0074	63457-0074	Conductor Punch	1 Y
2	63455-0101	63455-0101	Conductor Anvil	1 Y
3	63443-0005	63443-0005	Front Cut-Off Plunger	1 Y
4	63443-0012	63443-0012	Front Plunger Retainer	1 Y
Other Components				
5	11-17-0022	1739-21	Hold Down Spring	1
6	11-18-4083	60707-8	Feed Guide	1
7	63443-0009	63443-0009	Front Scrap Chute	1
8	63443-0024	63443-0024	Key	1
9	63443-0085	63443-0085	Wire Stop L-Bracket	1
10	63443-0090	63443-0090	Wire Stop	1
11	63443-0093	63443-0093	Shank	1
12	63443-1719	63443-1719	18.90mm Height Spacer	1
13	63443-2214	63443-2214	14.00mm Spacer	1
14	63443-2315	63443-2315	3.75mm Spacer	1
15	63443-3101	63443-3101	Front Plunger Striker	1
16	63443-6007	63443-6007	Rear Cover	1
17	63454-0101	63454-0101	Punch Spacer	1
18	63890-0095	63890-0095	Terminal Hold Down	1
19	63700-0539	63700-0539	Cut-off Plunger Spring	1
Frame				
20	63800-8500	63800-8500	T2 Terminator	1
Hardware				
21	N/A	N/A	M3 by 6 Long FHCS	1**
22	N/A	N/A	M3 by 6 Long SHCS	2**
23	N/A	N/A	M3 by 8 Long SHCS	1**
24	N/A	N/A	M4 by 6 Long SHCS	2**
25	N/A	N/A	M4 by 12 Long BHCS	2**
26	N/A	N/A	M4 by 14 Long SHCS	2**
27	N/A	N/A	M4 by 45 Long SHCS	2**
28	N/A	N/A	M5 by 12 Long SHCS	1**
29	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

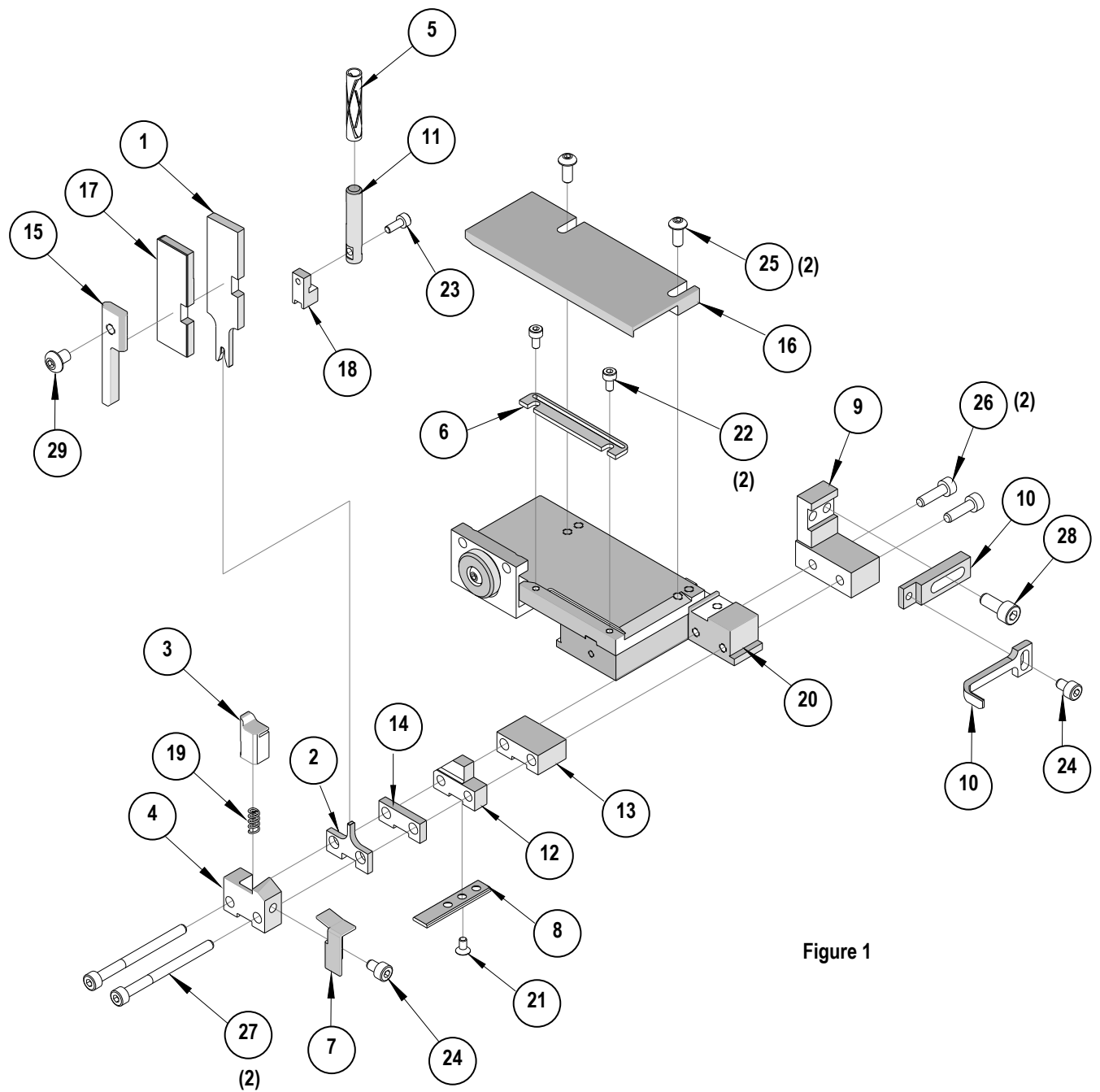


Figure 1

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).

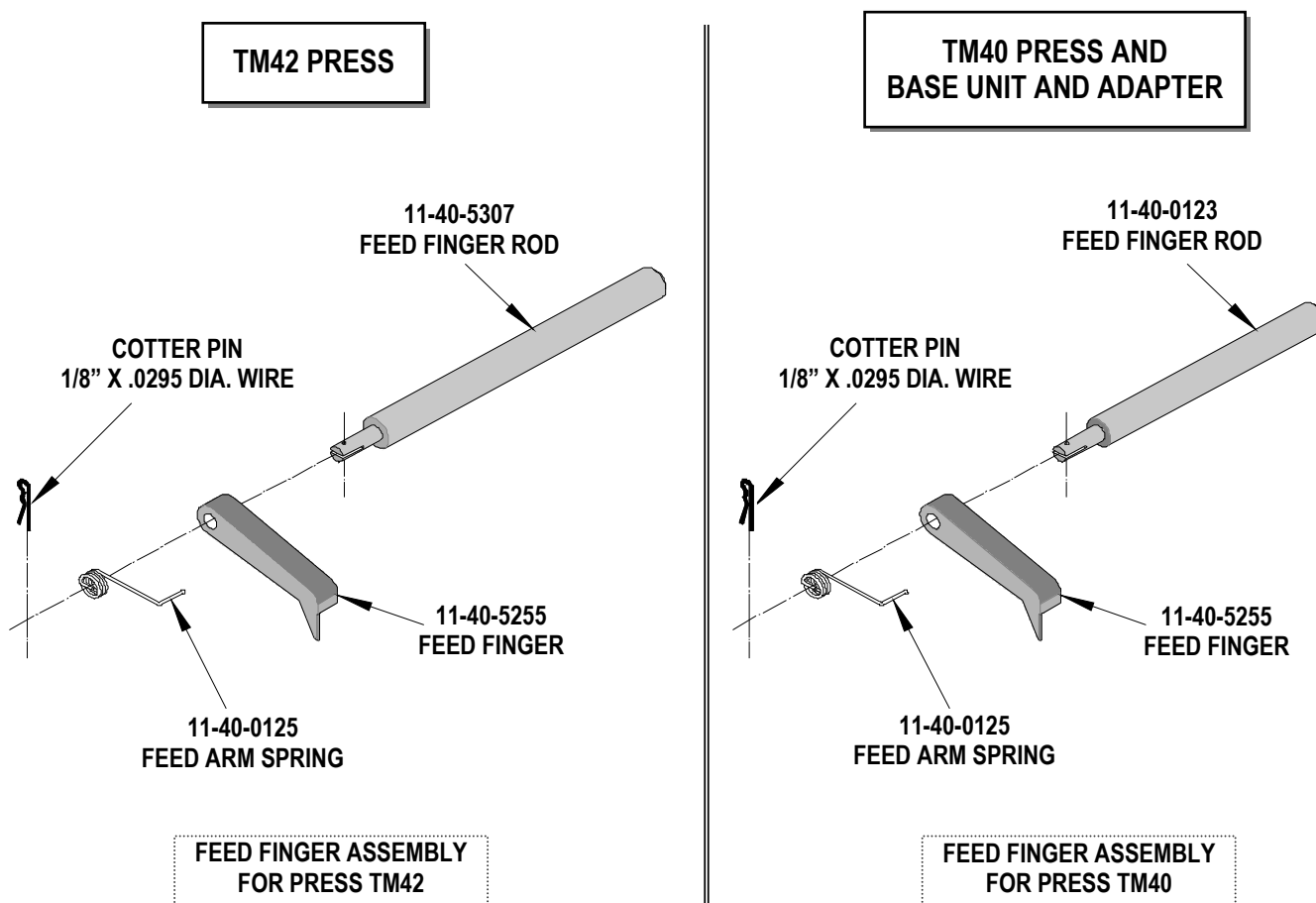


Figure 2

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>

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Офис по работе с юридическими лицами:

105318, г.Москва, ул.Щербаковская д.3, офис 1107, 1118, ДЦ «Щербаковский»

Телефон: +7 495 668-12-70 (многоканальный)

Факс: +7 495 668-12-70 (доб.304)

E-mail: info@moschip.ru

Skype отдела продаж:

moschip.ru

moschip.ru_4

moschip.ru_6

moschip.ru_9