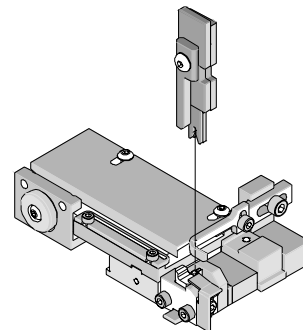




T2 Terminator Tooling Specification Sheet Part No. 63910-6400



FEATURES

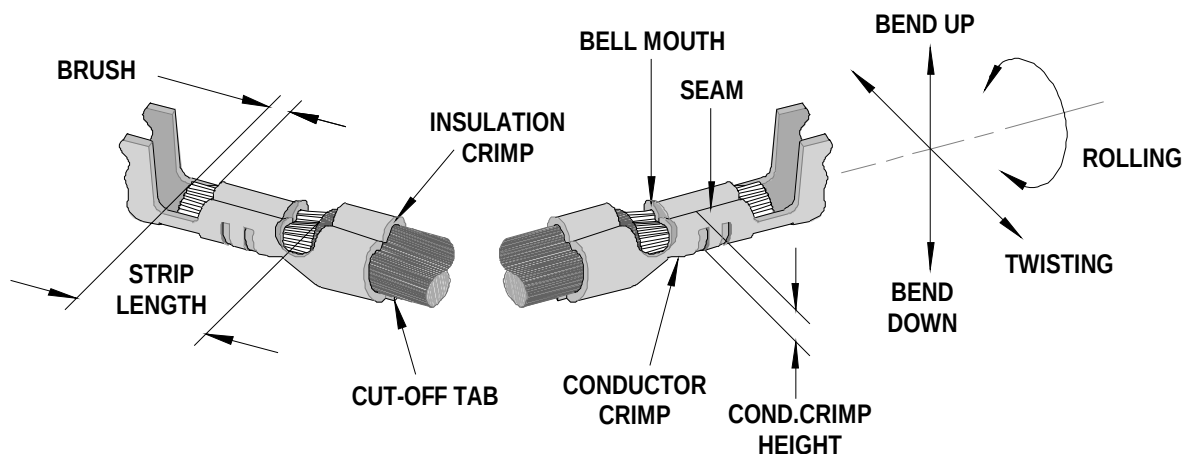
- It is ideally suited for mid-volume bench operations
- This terminator can be installed in the TM42 and the TM40 press or Base Unit adapter for 3BF press
- Quick punch removal with the push of a button for fast and easy tooling change
- Track adjustment capabilities in the T2 Terminators for improved 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: 2.00mm (.079") Pitch, Wire-to-Board, Crimp Terminal, 24-30 AWG.

Terminal Series No.	Terminal Order No.	Wire Size		* Insulation Diameter		Strip Length	
		AWG	mm ²	mm	In.	mm	In.
48105	48105-0001	24-30	0.20-0.05	1.10-1.50	.043-.059	1.90-2.50	.075-.099
* Note: 1) Insulation OD: 1.10-1.20mm will provide optimum A-620-Class 2 crimps 2) Insulation OD: 1.25-1.35mm will provide optimum A-620-Class 1 crimps 3) Insulation OD: 1.40-1.50mm will not provide optimum A-620 crimps							

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.
48105	0.10-0.30	.004-.012	0.50	.020	0.30-0.60	.012-.024

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				Conductor		Insulation		
			mm	In	mm	In			
48105	6	6	5	7	1.10	.043	1.50	.059	

After crimping, the conductor profile should measure the following.

Terminal Series No.	Wire Size		Conductor Crimp				Insulation Crimp Maximum				Pull Force Minimum	
			Height		Width (Ref)		Height		Width (Ref)			
	AWG	mm ²	mm	In.	mm	In.	mm	In.	mm	In.	N	Lb.
48105	24	0.20	0.62-0.67	.024-.026	1.15	.045	1.70	.067	1.55	.061	29.4	6.62
	26	0.13	0.57-0.62	.023-.025	1.15	.045	1.60	.063	1.55	.061	19.6	4.41
	28	0.08	0.55-0.60	.022-.024	1.15	.045	1.50	.059	1.55	.061	14.7	3.31
	30	0.05	0.52-0.57	.021-.023	1.15	.045	1.50	.059	1.55	.061	7.8	1.76

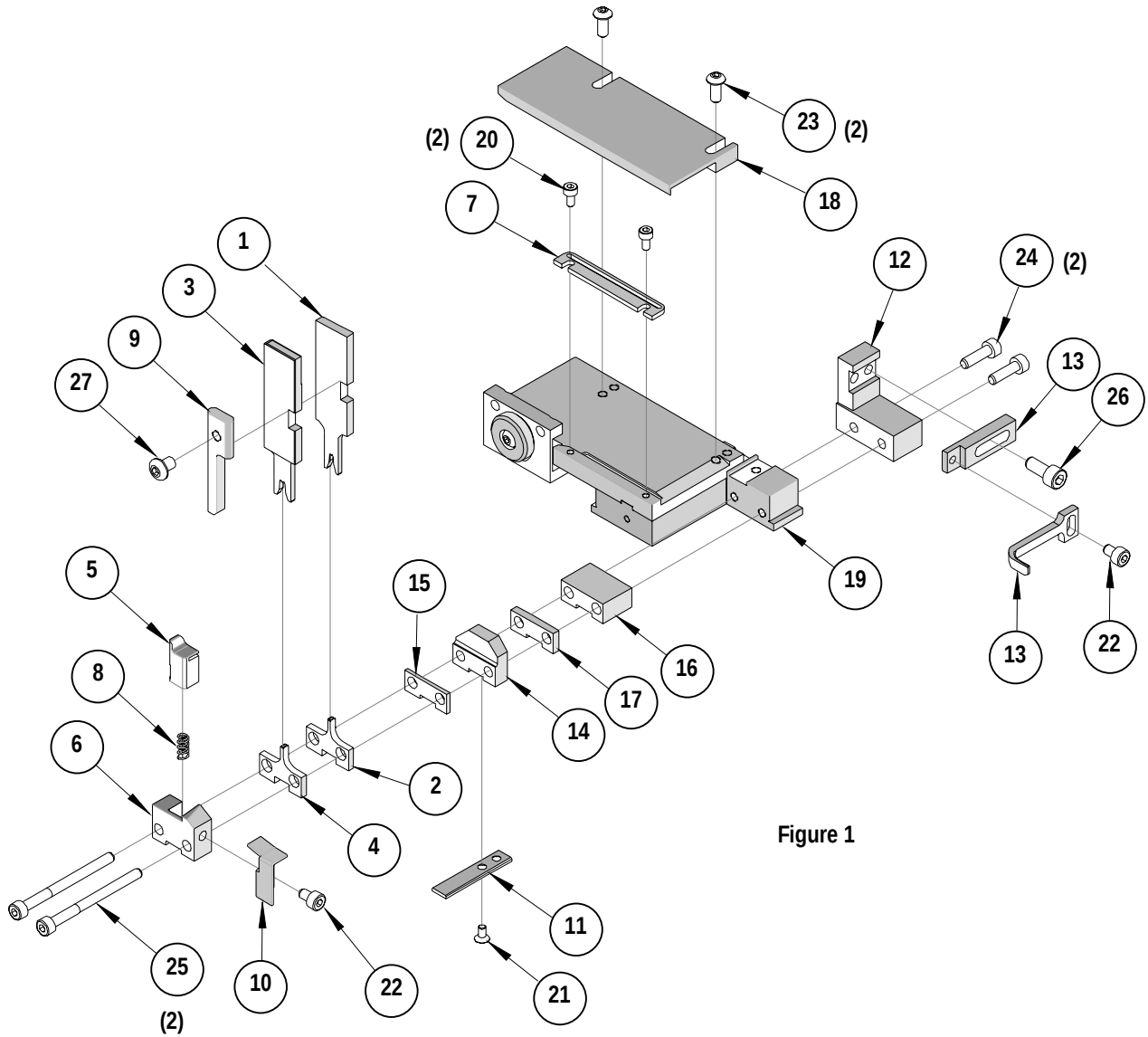
Pull Force should be measured with no influence from the insulation crimp.

The above specifications are guidelines to an optimum crimp.

PARTS LIST

T2 Terminator 63910-6400				
Item	Order No	Engineering No.	Description	Quantity
Perishable Tooling				
	63910-6470	63910-6470	Tool Kit (All "Y" Items)	REF
1	63444-1104	63444-1104	Conductor Punch	1 Y
2	63445-1110	63445-1110	Conductor Anvil	1 Y
3	63454-0070	63454-0070	Insulation Punch-Overlap	1 Y
4	63445-1505	63445-1505	Insulation Anvil	1 Y
5	63443-0002	63443-0002	Front Cut-Off Plunger	1 Y
6	63443-0012	63443-0012	Front Plunger Retainer	1 Y
Other Components (REF 106450)				
7	11-18-4083	60707-8	Feed Guide	1
8	11-24-1067	4996-4	Cut-Off Plunger Spring	1
9	11-40-4039	8302-5	Plunger Striker	1
10	63443-0009	63443-0009	Front Scrap Chute	1
11	63443-0025	63443-0025	Key	1
12	63443-0085	63443-0085	Wire Stop L-Bracket	1
13	63443-0090	63443-0090	Wire Stop	1
14	63443-1719	63443-1719	18.90mm Height Spacer	1
15	63443-2201	63443-2201	1.00mm Coarse Spacer	1
16	63443-2216	63443-2216	16.00mm Coarse Spacer	1
17	63443-2301	63443-2301	3.05mm Fine Spacer	1
18	63443-6003	63443-6003	Rear Cover	1
Frame				
19	63800-8500	63800-8500	T2 Terminator	1
Hardware				
20	N/A	N/A	M3 by 6 Long SHCS	2**
21	N/A	N/A	M3 by 6 Long FHCS	1**
22	N/A	N/A	M4 by 6 Long SHCS	2**
23	N/A	N/A	M4 by 12 Long BHCS	2**
24	N/A	N/A	M4 by 14 Long SHCS	2**
25	N/A	N/A	M4 by 50 Long SHCS	2**
26	N/A	N/A	M5 by 12 Long SHCS	1**
27	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



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).

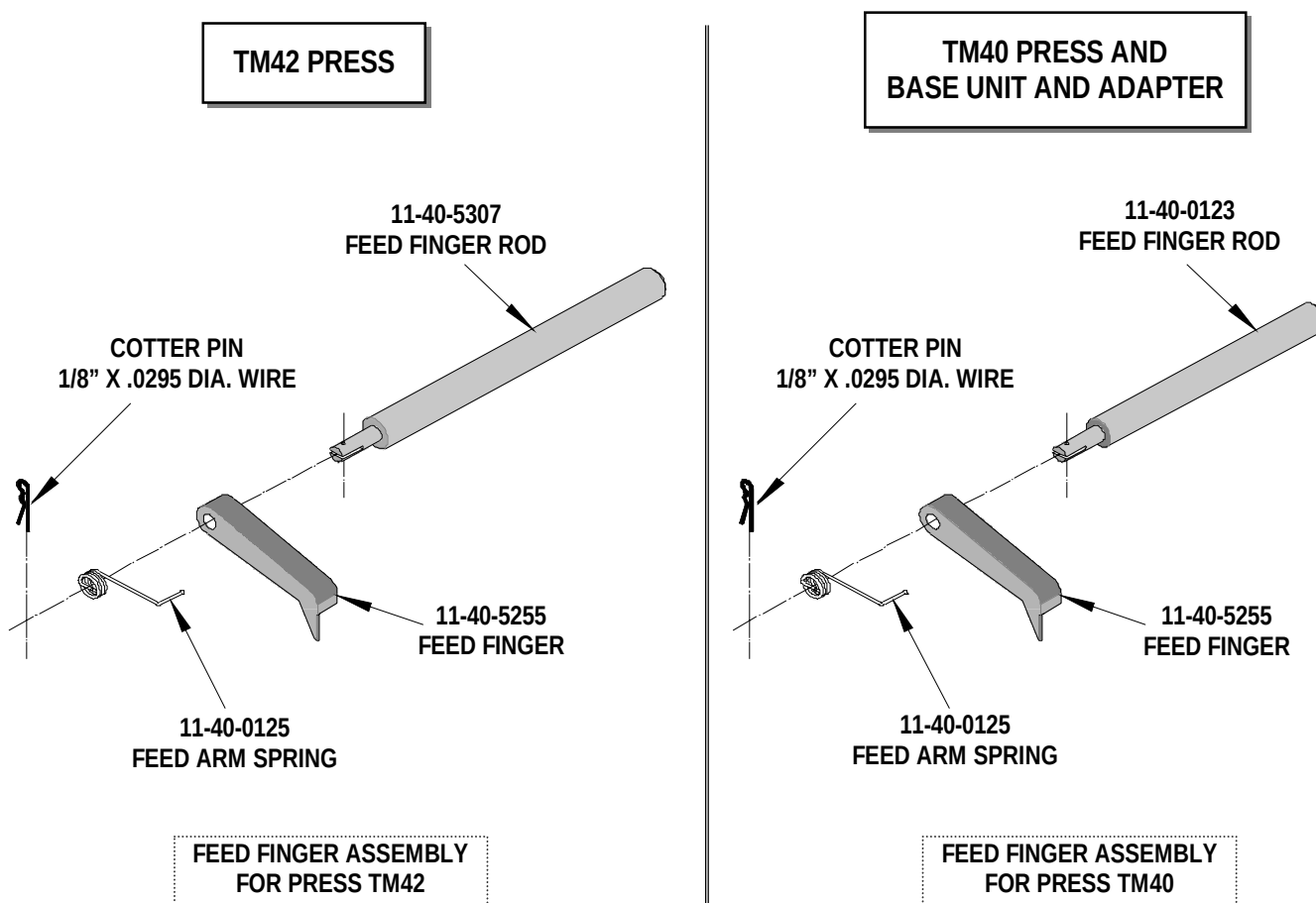


Figure 2

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.

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