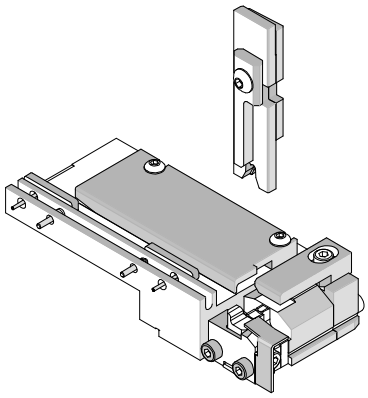
T Style Terminator Tooling Specification Sheet Part No. 63840-4100



FEATURES

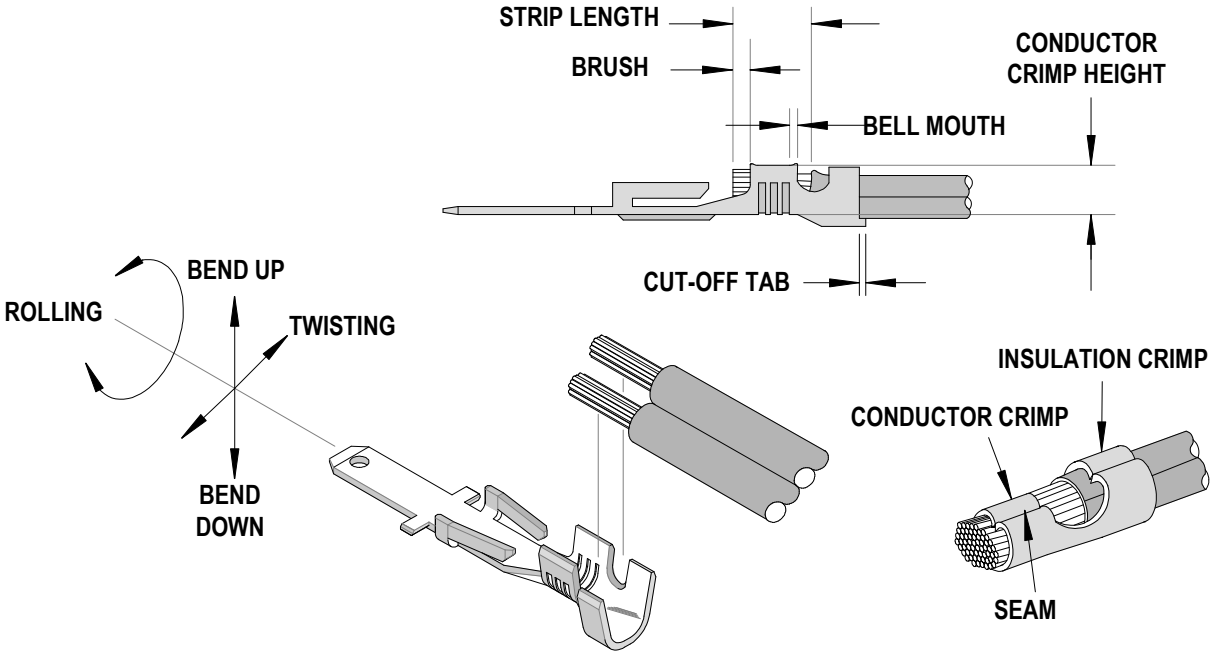
- It is ideally suited for mid-volume bench operations
- This terminator can be installed in the TM42 and Base Unit adapter for 3BF press
- Quick punch removal with the push of a button for fast and easy tooling change
- Flexible and inexpensive

SCOPE

Products: Sabre™ Crimp Terminal 14-18 AWG and Double 18 AWG wires placed vertically-Standard Insulation Crimp.

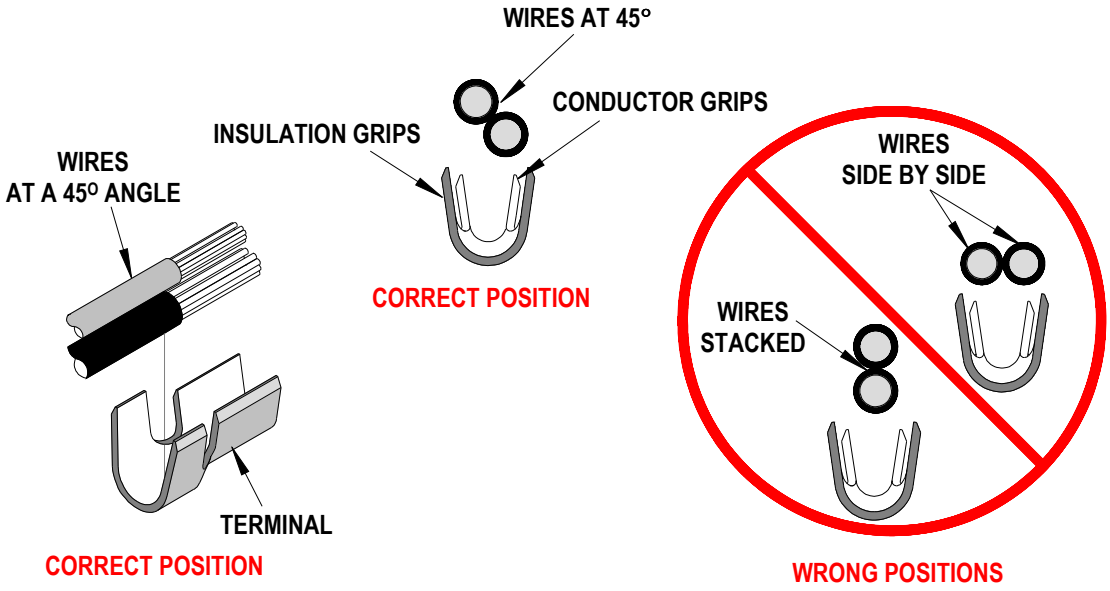
Terminal Series No.	Terminal Order No.		Wire Size		Insulation Diameter		Strip Length	
			AWG	mm²	mm	In.	mm	In.
43178	43178-2001	43178-6001	14-18	2.00-0.80	3.03-4.57	.119-.180	3.96-5.54	.156-.218
	43178-2002	43178-6002						
	43178-2001	43178-6001	✳18 (2) Vertical	0.80 (2)	3.03-4.57	.119-.180	3.96-5.54	.156-.218
	43178-2002	43178-6002						
✳ See Wire Orientation on next page.								

DEFINITION OF TERMS



Wire Feeding Orientation

This Terminator and crimp was developed for (2) 18 AWG wires placed at a 45º angle orientation from one another. Wires must be positioned as shown, to capture all wire strands in crimp. See the following illustrations below.



CRIMP SPECIFICATIONS

Terminal Series No.	Bell mouth		Cut-off Tab Maximum		Conductor Brush	
	mm	In.	mm	In.	mm	In.
43178	0.25-1.00	.010-.039	0.50	.019	1.50	.059

Terminal Series No.	Bend up	Bend down	Twist	Roll	Punch Width (Ref)				Seam
					Conductor		Insulation		
	Degree		Degree		mm	In	mm	In	
43178	3	3	4	8	3.40	.133	4.80	.189	Seam shall not be open and no wire allowed out of the crimping area

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.
43178	14	0.80	1.80-1.90	.071-.075	222.4	50.00
	16	1.30	1.70-1.80	.067-.071	133.5	30.00
	18	0.80	1.65-1.75	.065-.069	88.9	20.00
	18 DBL	0.80 (2)	1.75-1.85	.069-.073	88.9	20.00

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 63840-4100				
Item	**Order No**	**Engineering No.**	**Description**	**Quantity**
Perishable Tooling				
	63840-4170	63840-4170	Tool Kit (All "Y" Items)	REF
1	63444-3409	63444-3409	Conductor Punch	1 Y
2	63445-3443	63445-3443	Conductor Anvil	1 Y
3	63446-4820	63446-4820	Insulation Punch	1 Y
4	63445-4817	63445-4817	Insulation Anvil	1 Y
5	63443-0002	63443-0002	Cut-Off Plunger	1 Y
6	63443-0012	63443-0012	Front Plunger Retainer	1 Y
Other Components				
7	11-18-5415	60842A111	Anvil Mount	1
8	11-18-5440	60842A117	Rear Cover	1
9	11-40-4039	8302-5	Front Plunger Striker	1
10	11-40-4068	8302-102	Drag Finger	1
11	11-40-4069	8302-103	Pivot Pin	2
12	11-40-4144	8302-110	Torsion Spring	1
13	11-40-4145	8302-111	Torsion Spring (Stop Finger)	1
14	11-40-4231	8329-10	Stop Finger	1
15	63443-0009	63443-0009	Scrap Chute	1
16	63443-0021	63443-0021	Mounting Key	1
17	63700-0539	63700-0539	Heavy Duty Cut-Off Plunger Spring	1
18	63840-6011	63840-6011	Wire Stop	1
19	63840-6020	63840-6020	Terminal Track	1
Hardware				
20	N/A	N/A	M4 by 6 Long SHCS	1**
21	N/A	N/A	M4 by 10 Long BHCS	2**
22	N/A	N/A	M4 by 12 Long SHCS	1**
23	N/A	N/A	M4 by 16 Long SHCS	1**
24	N/A	N/A	M4 by 24 Long SHCS	2**
25	N/A	N/A	#10-32 by 3/8" Long BHCS	1**
26	N/A	N/A	3mm by 6 Long Roll Pin	1**
27	N/A	N/A	3/64" Diameter Spirol Pin	2**
** Available from an industrial supply company such as MSC (1-800-645-7270).				

Assembly Drawing

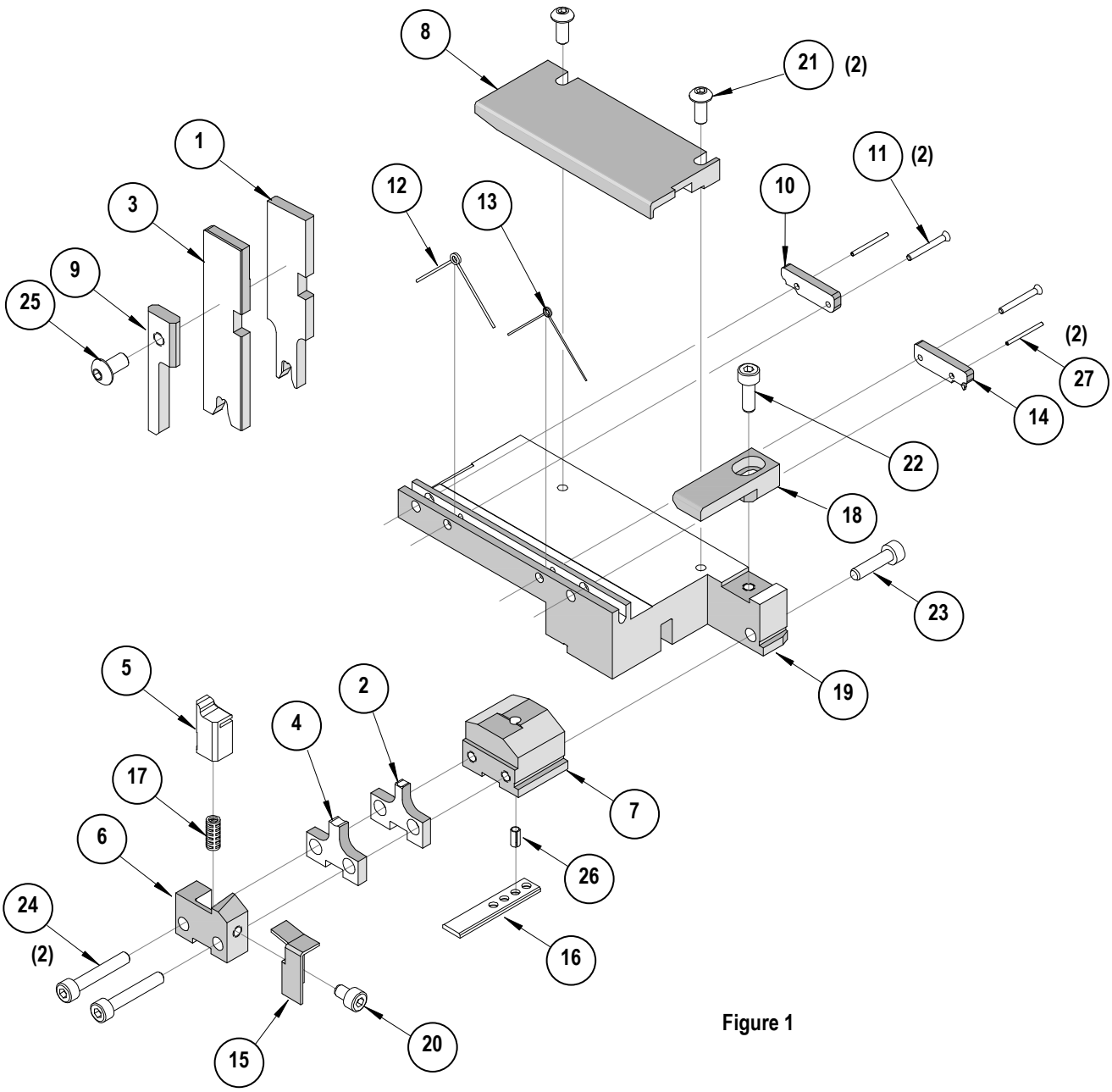


Figure 1

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 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.

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