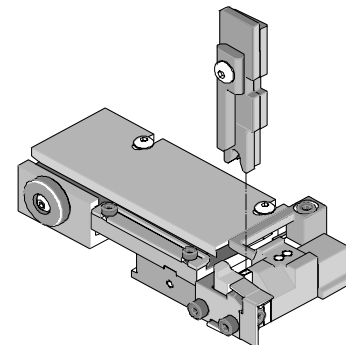




T2 Terminator Tooling Specification Sheet Part No. 63855-6000



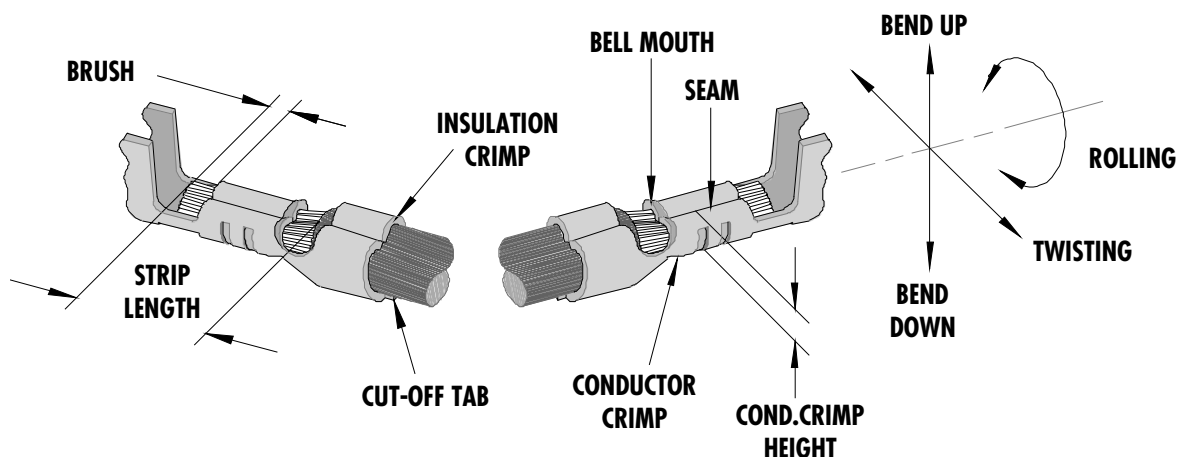
FEATURES

- This terminator can be installed in the TM42 and the TM40 press or Base Unit adapter for 3BF press
- It is ideally suited for mid-volume bench operations
- 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

Terminal Series No.		Wire Size		Insulation Diameter		Strip Length	
		AWG	mm ²	mm	In.	mm	In.
19417-0011	Male (Tin)	14-16	2.00-1.27	2.87-3.53	.113-.139	4.20-5.00	.165-.197
19417-0025	Male (Gold)	14-16	2.00-1.27	2.87-3.53	.113-.139	4.20-5.00	.165-.197
19417-0027	Male (Tin)	14-16 Long	2.00-1.27	2.87-3.53	.113-.139	4.20-5.00	.165-.197
19417-0029	Male (Gold)	14-16 Long	2.00-1.27	2.87-3.53	.113-.139	4.20-5.00	.165-.197
19420-0001	Female (Tin)	14-16	2.00-1.27	2.87-3.53	.113-.139	4.20-5.00	.165-.197
19420-0003	Female (Gold)	14-16	2.00-1.27	2.87-3.53	.113-.139	4.20-5.00	.165-.197

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 Max.		Conductor Brush	
	mm	In.	mm	In.	mm	In.
19417-0011	0.25-1.25	.010-.049	0.50	.020	0.15-0.65	.006-.026
19417-0025	0.25-1.25	.010-.049	0.50	.020	0.15-0.65	.006-.026
19417-0027	0.25-1.25	.010-.049	0.50	.020	0.15-0.65	.006-.026
19417-0029	0.25-1.25	.010-.049	0.50	.020	0.15-0.65	.006-.026
19420-0001	0.25-1.25	.010-.049	0.50	.020	0.15-0.65	.006-.026
19420-0003	0.25-1.25	.010-.049	0.50	.020	0.15-0.65	.006-.026

Terminal Series No.	Bend up Bend down		Twist Roll		Punch Width mm (Ref)				Seam
	Degree		Degree		Conductor		Insulation		
					mm	In	mm	In	
19417-0011	5	5	4	8	2.50	.098	4.30	.169	Seam shall not be open and no wire allowed out of the crimping area
19417-0025	5	5	4	8	2.50	.098	4.30	.169	
19417-0027	5	5	4	8	2.50	.098	4.30	.169	
19417-0029	5	5	4	8	2.50	.098	4.30	.169	
19420-0001	5	5	4	8	2.50	.098	4.30	.169	
19420-0003	5	5	4	8	2.50	.098	4.30	.169	

After crimping, the conductor profile should measure the following.

Terminal Series No.	Wire Size		Conductor Crimp Height		Insulation Crimp Height		Pull Force Min.	
	AWG	mm ²	mm	In.	Mm (Ref)	In. (Ref)	N	Lb.
19417-0011	14	2.00	1.65-1.75	.065-.069	3.40 max.	.130 max.	222.6	50.00
19417-0011	16	1.27	1.60-1.70	.063-.067	3.40 max.	.130 max.	133.5	30.00
19417-0025	14	2.00	1.65-1.75	.065-.069	3.40 max.	.130 max.	222.6	50.00
19417-0025	16	1.27	1.60-1.70	.063-.067	3.40 max.	.130 max.	133.5	30.00
19417-0027	14	2.00	1.65-1.75	.065-.069	3.40 max.	.130 max.	222.6	50.00
19417-0027	16	1.27	1.60-1.70	.063-.067	3.40 max.	.130 max.	133.5	30.00
19417-0029	14	2.00	1.65-1.75	.065-.069	3.40 max.	.130 max.	222.6	50.00
19417-0029	16	1.27	1.60-1.70	.063-.067	3.40 max.	.130 max.	133.5	30.00
19420-0001	14	2.00	1.45-1.55	.057-.061	3.40 max.	.130 max.	222.6	50.00
19420-0001	16	1.27	1.40-1.50	.055-.059	3.40 max.	.130 max.	133.5	30.00
19420-0003	14	2.00	1.45-1.55	.057-.061	3.40 max.	.130 max.	222.6	50.00
19420-0003	16	1.27	1.40-1.50	.055-.059	3.40 max.	.130 max.	133.5	30.00

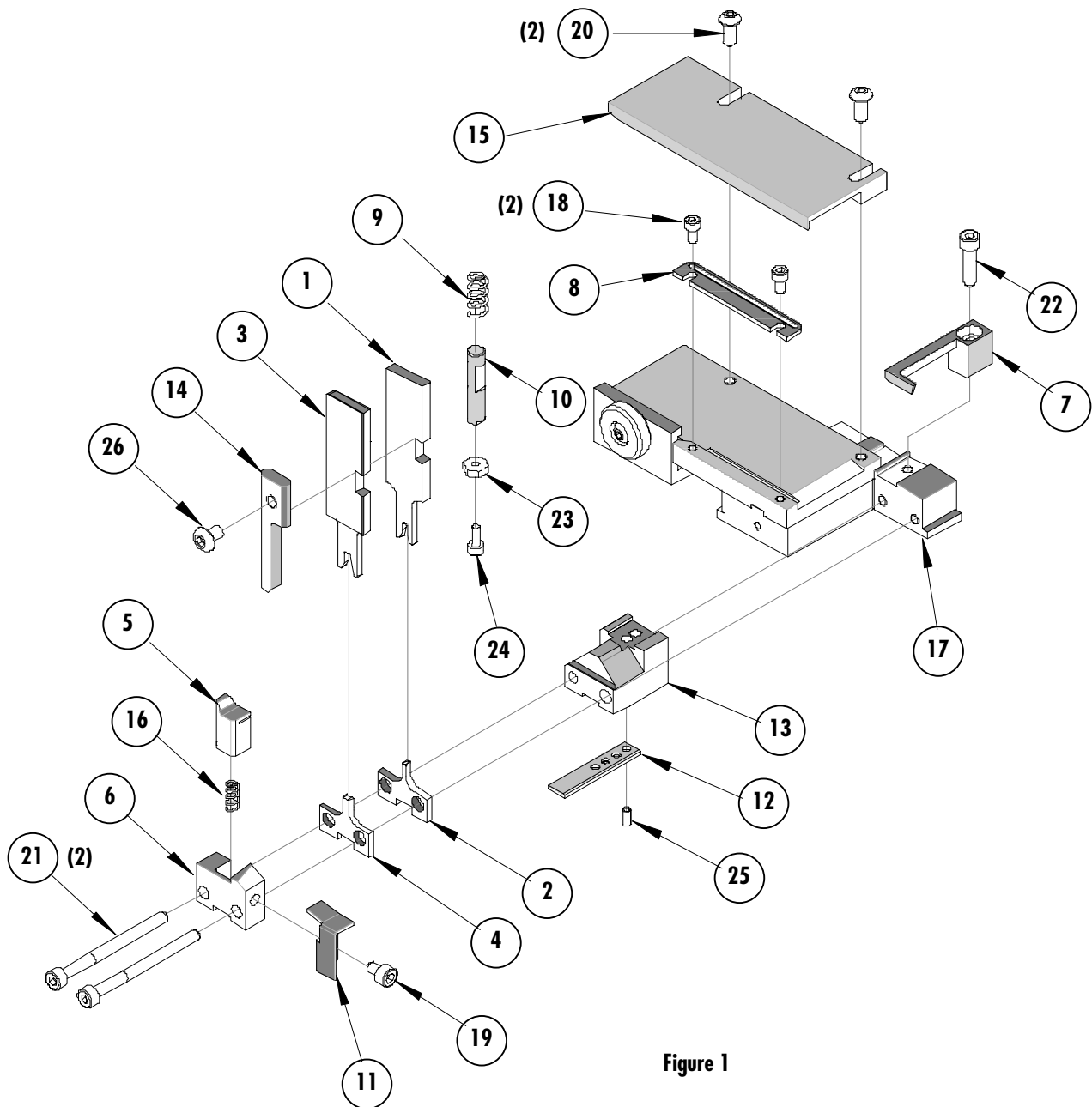
Pull Force should be measured with no influence from the insulation crimp.

The above specifications are guidelines to an optimum crimp.

PARTS LIST

Item	Order No	Engineering No.	Description	Quantity
	63855-6000	63855-6000	T2 Terminator (Fig. 1)	REF
1	63444-2524	63444-2524	Conductor Punch	1 Y
2	63455-2501	63455-2501	Conductor Anvil	1 Y
3	63460-4301	63460-4301	Insulation Punch	1 Y
4	63445-4322	63445-4322	Insulation Anvil	1 Y
5	63443-0035	63443-0035	Cut-Off Plunger	1 Y
6	63443-0036	63443-0036	Front Plunger Retainer	1 Y
7	63800-8504	63800-8504	Wire Stop	1
8	11-18-4083	60707-8	Front Cover	1
9	11-17-0022	1739-21	Hold Down Spring	1
10	11-24-1149	4996-37	Shank	1
11	63443-0009	63443-0009	Scrape Chute	1
12	63443-0021	63443-0021	Lower Tooling Key	1
13	63443-2508	63443-2508	Anvil Mount	1
14	63443-3160	63443-3160	Front Plunger Striker	1
15	63443-6013	63443-6013	Rear Cover	1
16	63700-0539	63700-0539	Cut-off Plunger Spring	1
17	63800-8800	63800-8800	T2 Terminator-Frame Wide Track	1
18	N/A	N/A	M3 by 6Lg. SHCS	2**
19	N/A	N/A	M4 by 6Lg. SHCS	1**
20	N/A	N/A	M4 by 12Lg. BHCS	2**
21	N/A	N/A	M4 by 50Lg. SHCS	2**
22	N/A	N/A	M4 by 12Lg SHCS	1**
23	N/A	N/A	#5-40 Hex Nut	1**
24	N/A	N/A	#5-40 by 3/4 LG. SHCS	1**
25	N/A	N/A	3MM by 6Lg. Roll Pin	1**
26	N/A	N/A	#10-32 by 1/4"Lg. BHCS	1**
	63855-6070	63855-6070	Tool Kit (All Y Items)	REF

** The following purchased parts are 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).

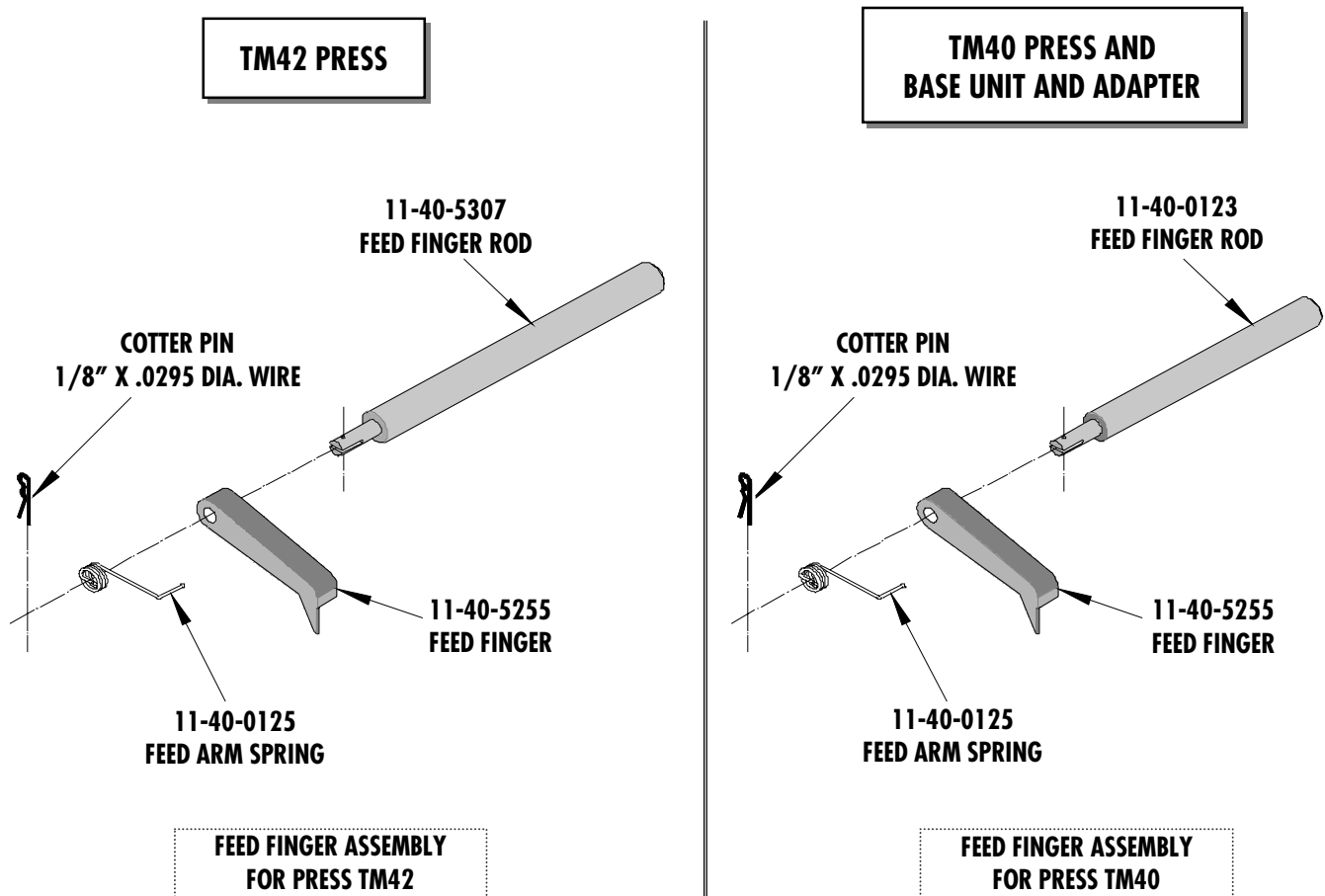


Figure 2

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 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.

Molex Application Tooling Group

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

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