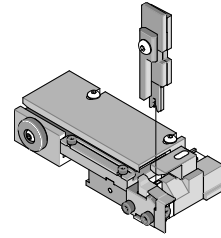


T2 Terminator Tooling

molex

Application Tooling Specification Sheet


Order No. 63850-5100

FEATURES

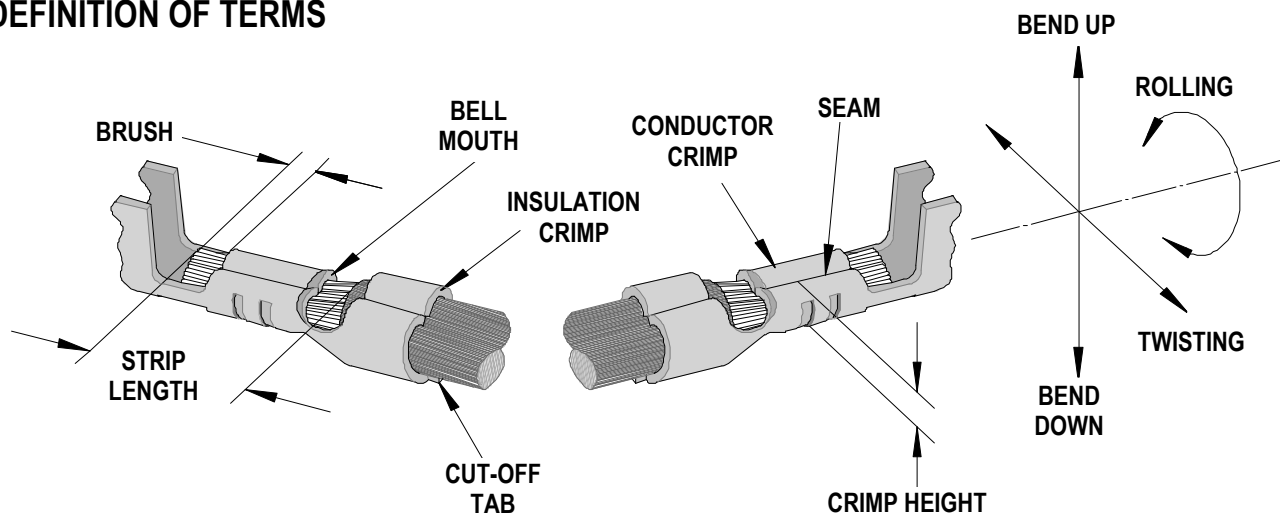
- This terminator can be installed in the TM42 and the TM40 press or Base Unit adapter for 3BF press
- It is ideally suited for mid-volume bench operations
- Quick punch removal with the push of a button for fast and easy tooling change
- Track adjustment capabilities in the T2 Terminators for improved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

Products: 2.50mm (.098") Pitch Crimp Terminals, 22-28 AWG.

Terminal Series No.	Terminal Order No.		Wire Size		Insulation Diameter				Strip Length	
					IPC/WHMA-A60 (1)		Terminal (2)			
			AWG	mm ²	mm	In.	mm	In.	mm	In.
35074	35074-8001	35074-9002	22-28	0.35-0.08	1.20-1.65	.047-.065	1.15-1.80	(.045-.071	2.30-2.80	.091-.110
50351	50351-8000		22-28	0.35-0.08	1.20-1.65	.047-.065	1.15-1.80	(.045-.071	2.30-2.80	.091-.110
57915	57915-8001	57915-9002	22-28	0.35-0.08	1.20-1.65	.047-.065	1.15-1.80	(.045-.071	2.30-2.80	.091-.110
(1) To achieve optimum IPC-A620 Class 2 insulation crimps, use this insulation OD.										
(2) Overall insulation OD specification for terminal.										

DEFINITION OF TERMS



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

CRIMP SPECIFICATION

Terminal Series No.	Bell mouth		Cut-off Tab Maximum		Conductor Brush	
	mm	In.	mm	In.	mm	In.
35074	0.05-0.40	.002-.016	0.20	.008	0.00-0.80	.000-.032
50351	0.05-0.40	.002-.016	0.20	.008	0.00-0.80	.000-.032
57915	0.05-0.40	.002-.016	0.20	.008	0.00-0.80	.000-.032

Terminal Series No.	Bend up	Bend down	Twist	Roll	Punch Width (Ref)				Seam Seam shall not be open and no wire allowed out of the crimping area
	Degree	Degree	mm	In	Conductor		Insulation		
					mm	In	mm	In	
35074	3	3	3	6	1.20	.047	1.80	.071	
50351	3	3	3	6	1.20	.047	1.80	.071	
57915	3	3	3	6	1.20	.047	1.80	.071	

After crimping, the crimp profiles should measure the following:

Terminal Series No.	Wire Size		Conductor				Insulation				Pull Force Minimum	
			Crimp Height		Crimp Width (Ref)		Crimp Height (Ref)		Crimp Width (Ref)			
	AWG	mm²	mm	In.	mm	In.	mm	In.	mm	In.	N	Lb.
35074	22	0.35	0.84-0.89	.033-.035	1.20	.047	1.70	.067	1.80	.071	39.2	8.8
	24	0.20	0.76-0.81	.030-.032	1.20	.047	1.70	.067	1.80	.071	29.4	6.6
	26	0.12	0.71-0.76	.028-.030	1.20	.047	1.70	.067	1.80	.071	19.6	4.4
	28	0.08	0.67-0.72	.026-.028	1.20	.047	1.70	.067	1.80	.071	9.8	2.2
50351	22	0.35	0.84-0.89	.033-.035	1.20	.047	1.70	.067	1.80	.071	39.2	8.8
	24	0.20	0.76-0.81	.030-.032	1.20	.047	1.70	.067	1.80	.071	29.4	6.6
	26	0.12	0.71-0.76	.028-.030	1.20	.047	1.70	.067	1.80	.071	19.6	4.4
	28	0.08	0.67-0.72	.026-.028	1.20	.047	1.70	.067	1.80	.071	9.8	2.2
57915	22	0.35	0.84-0.89	.033-.035	1.20	.047	1.70	.067	1.80	.071	39.2	8.8
	24	0.20	0.76-0.81	.030-.032	1.20	.047	1.70	.067	1.80	.071	29.4	6.6
	26	0.12	0.71-0.76	.028-.030	1.20	.047	1.70	.067	1.80	.071	19.6	4.4
	28	0.08	0.67-0.72	.026-.028	1.20	.047	1.70	.067	1.80	.071	9.8	2.2

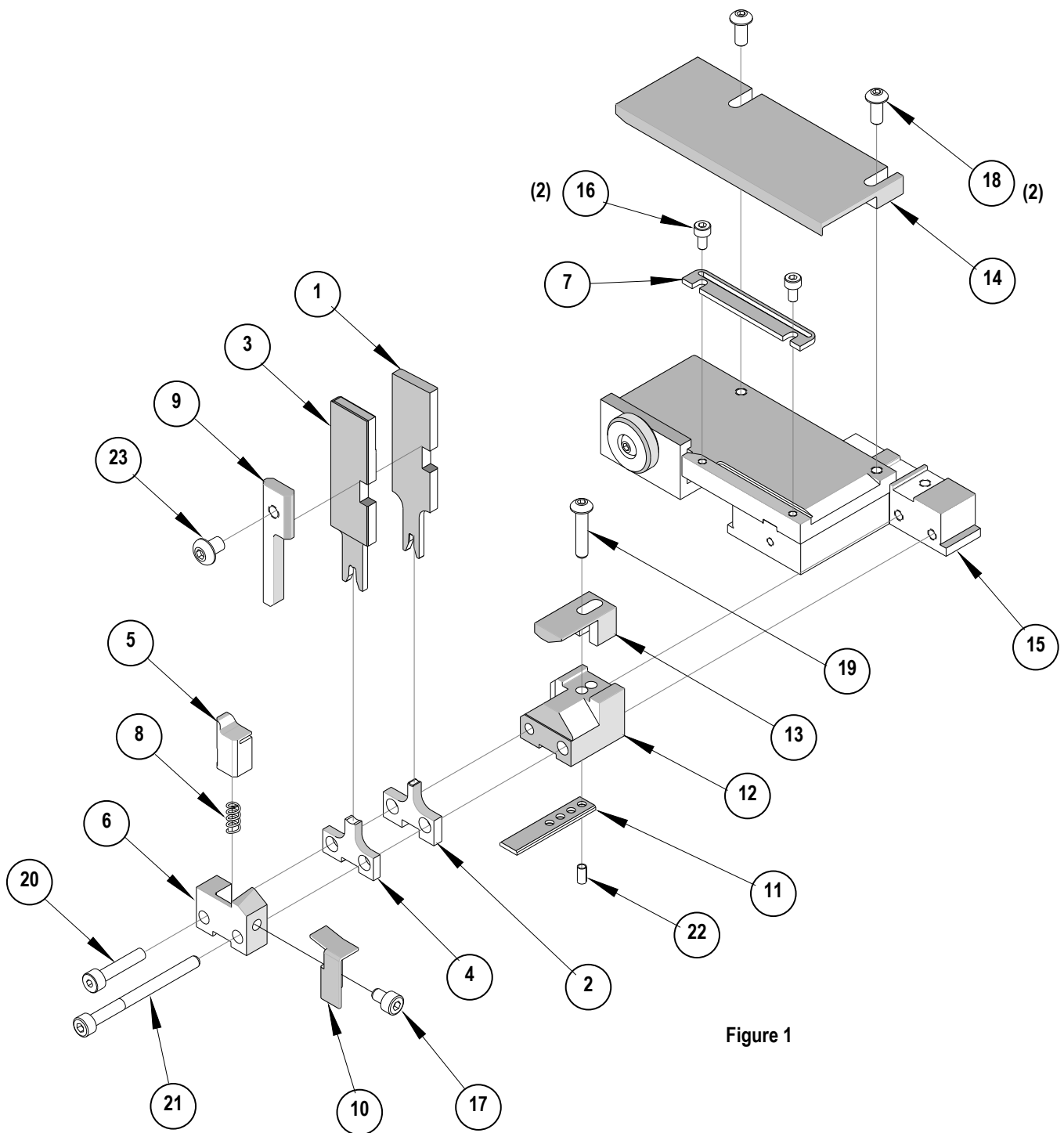
T Tool Qualification Notes:

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

T-2 Terminator 63850-5100				
Item	Order No	Engineering No.	Description	Quantity
Perishable Tooling				
	63850-5170	63850-5170	Tool Kit (All "Y" Items)	REF
1	634441210	634441210	Conductor Punch	1 Y
2	634451220	634451220	Conductor Anvil	1 Y
3	634461816	634461816	Insulation Punch	1 Y
4	634451819	634451819	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	11-18-4083	60707-8	Feed Guide	1
8	11-24-1067	4996-4	Cut-off Plunger Spring	1
9	11-40-4039	8302-5	Plunger Striker Front	1
10	634430009	634430009	Scrap Chute Front	1
11	63443-0021	63443-0021	Lower Tooling Key	1
12	634432405	634432405	Anvil Mount	1
13	634434005	634434005	Wire Stop	1
14	63443-6003	63443-6003	Rear Cover	1
Frame				
15	63800-8500	63800-8500	T2 Terminator	1
Hardware				
16	N/A	N/A	M3 by 6 Long SHCS	2**
17	N/A	N/A	M4 by 6 Long SHCS	1**
18	N/A	N/A	M4 by 10 Long BHCS	2**
19	N/A	N/A	M4 by 16 Long BHCS	1**
20	N/A	N/A	M4 by 20 Long SHCS	1**
21	N/A	N/A	M4 by 50 Long SHCS	1**
22	N/A	N/A	3MM by 6 Long Roll Pin	1**
23	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).

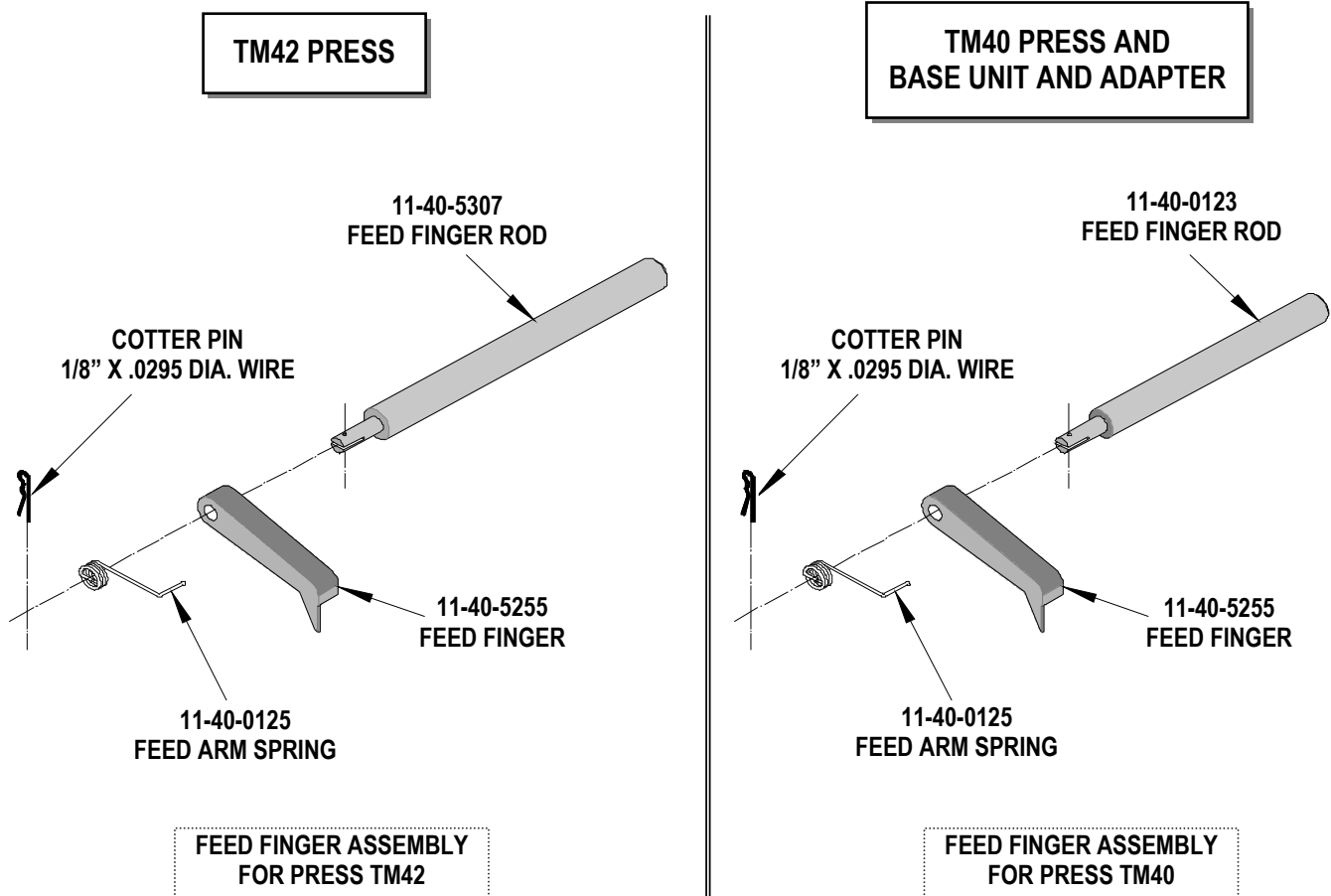


Figure 2

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.

<http://www.molex.com>

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