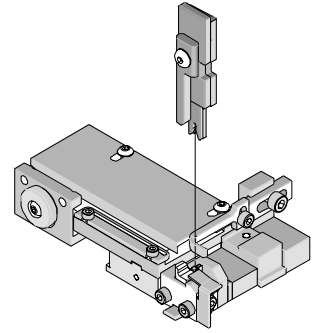




T2 Terminator Tooling Specification Sheet Order No. 63910-7600



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

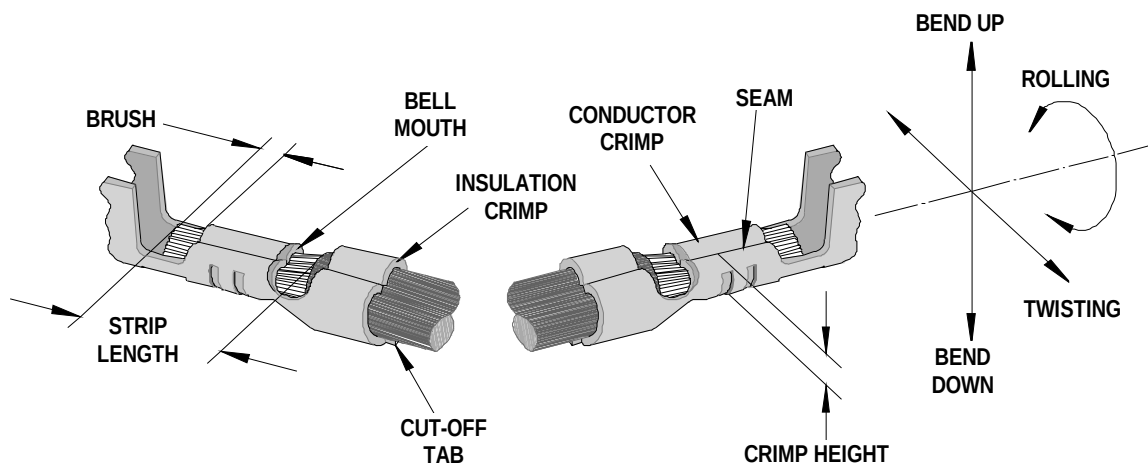
SCOPE

Products: 2.00mm (.079") Pitch Crimp Terminal, 22-28 AWG.

Terminal Series No.	Terminal Order No.	Wire Size		Insulation Diameter		Strip Length	
		AWG	mm ²	mm	In.	mm	In.
56086	56086-8000	22-28	0.34-0.08	0.85-1.50	.033-.059	1.60-2.10	.063-.083
59370	59370-8000	22-28	0.34-0.08	1.50 Maximum	.059 Maximum	1.60-2.10	.063-.083

Note: 56086 - Insulation OD: 1.15-1.45mm will provide optimum A-620 crimps
59370 - Insulation OD: 1.10-1.50mm will 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.
56086	0.05-0.30	.002-.012	0.25	.010	0.00-0.60	.000-.024
59370	0.05-0.30	.002-.012	0.25	.010	0.00-0.60	.000-.024

Terminal Series No.	Bend up Bend down		Twist Roll		Punch Width mm (Ref)				Seam
					Conductor		Insulation		
	Degree		Degree		mm	In	mm	In	
56086	4	2	3	8	1.20	.047	1.60	.063	Seam shall not be open and no wire allowed out of the crimping area
59370	3	3	3	6	1.20	.047	1.60	.063	

After crimping, the conductor profile should measure the following.

Terminal Series No.	Wire Size		Conductor Crimp Height		Insulation Crimp Height (Ref)		Pull Force Minimum	
	AWG	mm ²	mm	In.	mm	In.	N	Lb.
56086	22	0.34	0.84-0.89	.033-.035	2.05	.081	44.1	9.91
	24	0.20	0.76-0.81	.030-.032	2.00	.079	29.4	6.61
	26	0.12	0.71-0.76	.028-.030	1.90	.075	19.6	4.41
	28	0.08	0.67-0.72	.026-.028	1.75	.069	9.8	2.21
59370	22	0.34	0.70-0.75	.027-.029	1.75	.069	44.1	9.91
	24	0.20	0.67-0.72	.026-.028	1.70	.067	29.4	6.61
	26	0.12	0.61-0.66	.024-.026	1.60	.063	19.6	4.41
	28	0.08	0.57-0.62	.022-.024	1.35	.053	9.8	2.21

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 63910-7600				
Item	Order No	Engineering No.	Description	Quantity
Perishable Tooling				
	63910-7670	63910-7670	Tool Kit (All "Y" Items)	REF
1	63444-1207	63444-1207	Conductor Punch	1 Y
2	63445-1213	63445-1213	Conductor Anvil	1 Y
3	63446-1614	63446-1614	Insulation Punch	1 Y
4	63445-1624	63445-1624	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 107650)				
7	11-18-4083	60707-8	Feed Guide	1
8	63443-0009	63443-0009	Front Scrap Chute	1
9	63443-0025	63443-0025	Key	1
10	63443-0085	63443-0085	Wire Stop L-Bracket	1
11	63443-0090	63443-0090	Wire Stop	1
12	63443-1716	63443-1716	18.60mm Height Spacer	1
13	63443-2217	63443-2217	17.00mm Coarse Spacer	1
14	63443-2310	63443-2310	3.10mm Coarse Spacer	1
15	63443-2802	63443-2802	Front Plunger Striker	1
16	63443-2906	63443-2906	Wire Hold Down Plunger	1
17	63443-6003	63443-6003	Rear Cover	1
18	63443-7201	63443-7201	Spring Cover	1
19	63600-0021	63600-0021	Wire Hold Down Spring	1
20	63600-2972	63600-2972	Collar	2
21	63700-0539	63700-0539	Cut-Off Plunger Spring	1
Frame				
22	63800-8500	63800-8500	T2 Terminator	1
Hardware				
23	N/A	N/A	M3 by 6 Long SHCS	2**
24	N/A	N/A	M3 by 6 Long FHCS	1**
25	N/A	N/A	M4 by 6 Long SHCS	2**
26	N/A	N/A	M4 by 12 Long BHCS	2**
27	N/A	N/A	M4 by 14 Long SHCS	2**
28	N/A	N/A	M4 by 30 Long SHCS	2**
29	N/A	N/A	M4 by 50 Long SHCS	2**
30	N/A	N/A	M5 by 12 Long SHCS	1**
31	N/A	N/A	#10-32 by 3/8" Long Flat Point SSS	1**
32	N/A	N/A	#10-32 Hex Jam Nut	1**
** Available from an industrial supply company such as MSC (1-800-645-7270).				

Assembly Drawing

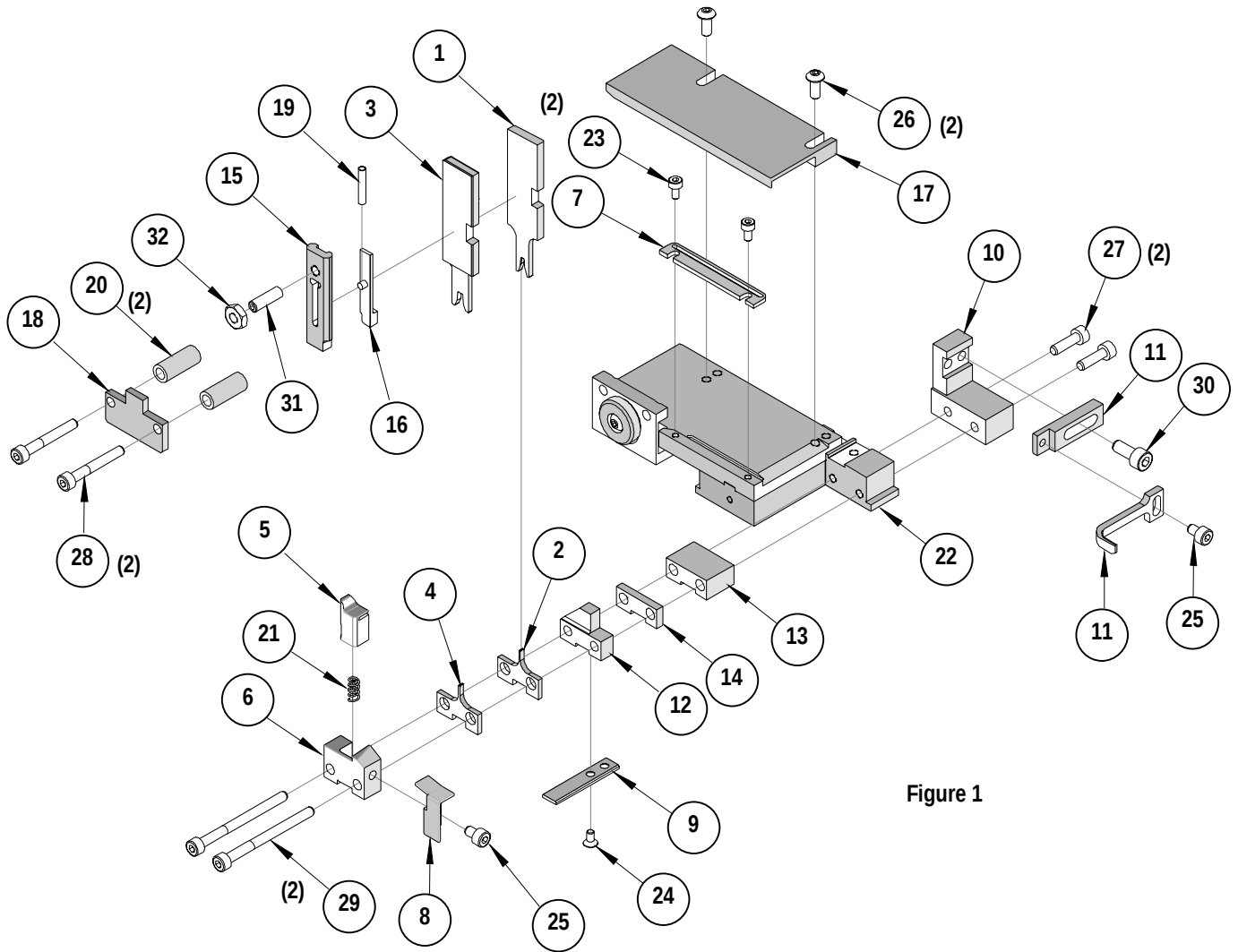


Figure 1

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).

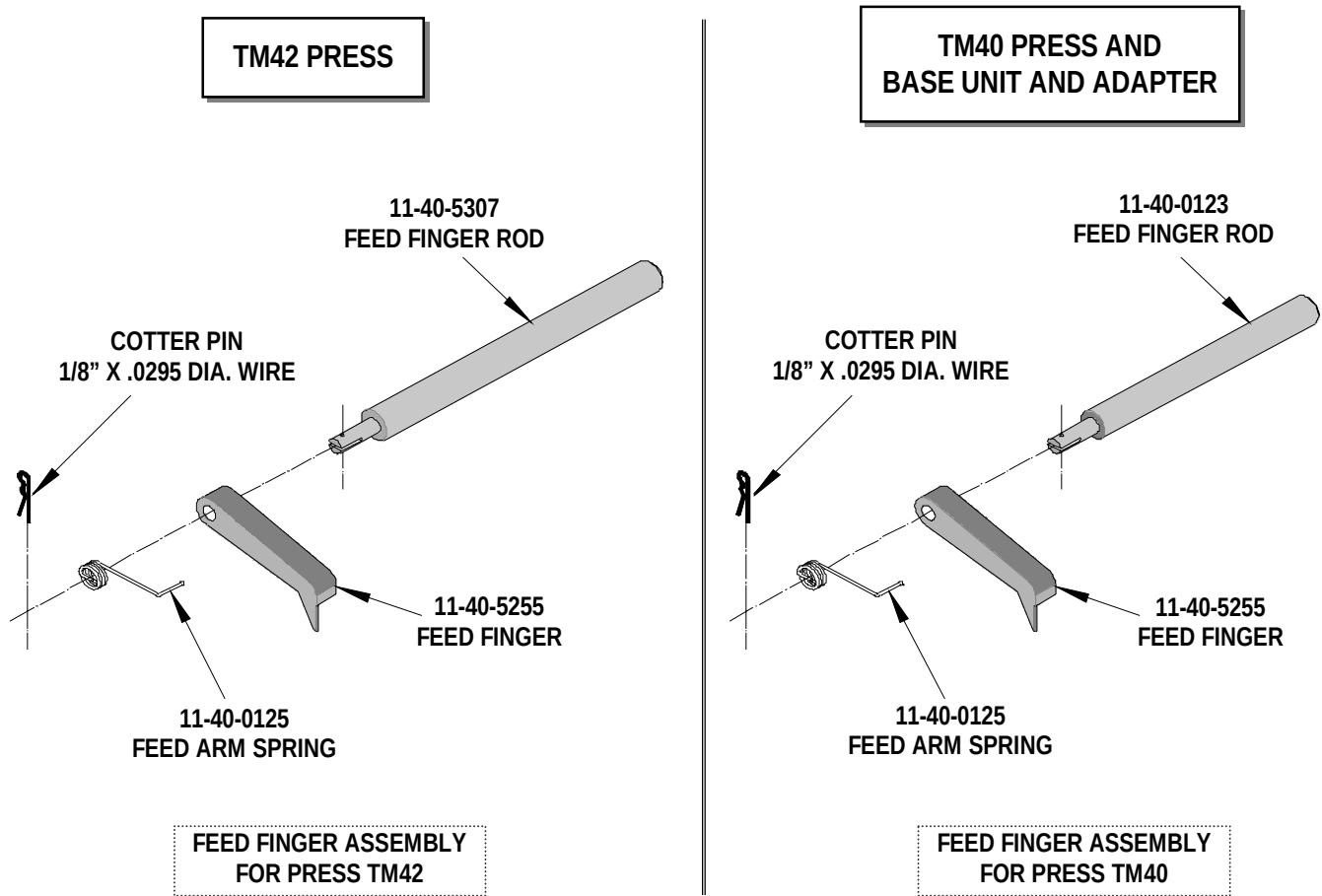


Figure 2

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 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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