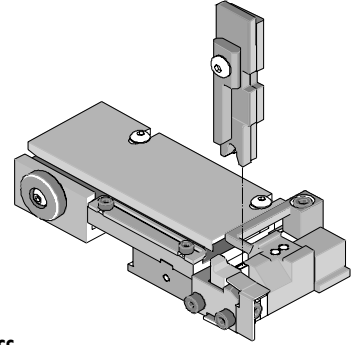




T2 Terminator Tooling Specification Sheet Part No. 63855-6100



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

MX150L™ Male Terminal for 18-24 AWG Wire, Metal Strip Carrier.

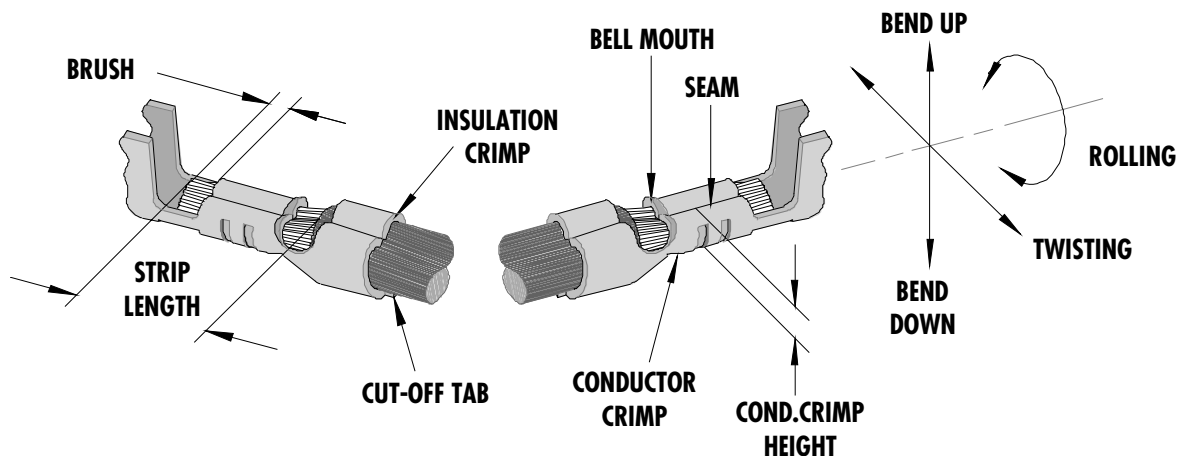
Terminal Order No.		Wire Size		Insulation Diameter		Strip Length	
		AWG	mm ²	mm	In.	mm	In.
19417-0024	Male (Tin)	18-22	0.83-0.36	2.36-2.74	.093-.108	4.20-5.00	.165-.197
19417-0026	Male (Gold)	18-22	0.83-0.36	2.36-2.74	.093-.108	4.20-5.00	.165-.197
19417-0028	Male (Tin) Long	18-22	0.83-0.36	2.36-2.74	.093-.108	4.20-5.00	.165-.197
19417-0030	Male (Gold) Long	18-22	0.83-0.36	2.36-2.74	.093-.108	4.20-5.00	.165-.197
19417-0024	Male (Tin)	24	0.20	1.00 Nom.	.039 Nom.	4.20-5.00	.165-.197
19417-0026	Male (Gold)	24	0.20	1.00 Nom.	.039 Nom.	4.20-5.00	.165-.197
19417-0028	Male (Tin) Long	24	0.20	1.00 Nom.	.039 Nom.	4.20-5.00	.165-.197
19417-0030	Male (Gold) Long	24	0.20	1.00 Nom.	.039 Nom.	4.20-5.00	.165-.197

Note: Terminals will accommodate the following wire specification:

1. (18-22 AWG) UL1015 wires.
2. (24 AWG) UL20251 wire.

For 24 AWG wire, see Tool Qualification Notes, Item 2 on page 2.

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	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 Seam shall not be open and no wire allowed out of the crimping area
					Conductor		Insulation		
	Degree	Degree	mm	In	mm	In			
19417	5	5	4	8	2.10	.082	3.40	.133	

After crimping, the conductor profile should measure the following.

Terminal Order No.	Wire Size		Conductor Crimp Height		Insulation Crimp Height		Pull Force Min.	
	AWG	mm ²	mm	In.	Mm (Ref)	In. (Ref)	N	Lb.
19417-0024	18	0.83	1.35-1.45	.053-.057	3.00 max.	.118 max.	89.0	20.00
19417-0024	20	0.58	1.25-1.35	.049-.053	3.00 max.	.118 max.	57.9	13.00
19417-0024	22	0.36	1.15-1.25	.045-.049	3.00 max.	.118 max.	35.6	8.00
19417-0024	24	0.20	1.05-1.15	.041-.045	3.00 max.	.118 max.	22.2	5.00
19417-0026	18	0.83	1.35-1.45	.053-.057	3.00 max.	.118 max.	89.0	20.00
19417-0026	20	0.58	1.25-1.35	.049-.053	3.00 max.	.118 max.	57.9	13.00
19417-0026	22	0.36	1.15-1.25	.045-.049	3.00 max.	.118 max.	35.6	8.00
19417-0026	24	0.20	1.05-1.15	.041-.045	3.00 max.	.118 max.	22.2	5.00
19417-0028	18	0.83	1.35-1.45	.053-.057	3.00 max.	.118 max.	89.0	20.00
19417-0028	20	0.58	1.25-1.35	.049-.053	3.00 max.	.118 max.	57.9	13.00
19417-0028	22	0.36	1.15-1.25	.045-.049	3.00 max.	.118 max.	35.6	8.00
19417-0028	24	0.20	1.05-1.15	.041-.045	3.00 max.	.118 max.	22.2	5.00
19417-0030	18	0.83	1.35-1.45	.053-.057	3.00 max.	.118 max.	89.0	20.00
19417-0030	20	0.58	1.25-1.35	.049-.053	3.00 max.	.118 max.	57.9	13.00
19417-0030	22	0.36	1.15-1.25	.045-.049	3.00 max.	.118 max.	35.6	8.00
19417-0030	24	0.20	1.05-1.15	.041-.045	3.00 max.	.118 max.	22.2	5.00

Pull Force should be measured with no influence from the insulation crimp.
The above specifications are guidelines to an optimum crimp.

 **Tool Qualification Notes:**

1. This Terminator was qualified to the above specifications with UL1015 wires for 18-22 AWG and UL20251 wire for 24 AWG.
2. For the 24 AWG wire, the insulation crimp has clearance around the wire and does not provide strain relief, even at the nominal reference crimp height of 2.11 mm (.083").

PARTS LIST

T2 Terminator 63855-6100				
Item	Order No	Engineering No.	Description	Quantity
Perishable Tooling				
	63855-6170	63855-6170	Tool Kit (All "Y" Items)	REF
1	63444-2137	63444-2137	Conductor Punch	1 Y
2	63445-2162	63445-2162	Conductor Anvil	1 Y
3	63454-0022	63454-0022	Insulation Punch	1 Y
4	63445-3440	63445-3440	Insulation Anvil	1 Y
5	63443-0035	63443-0035	Cut-Off Plunger	1 Y
6	63443-0036	63443-0036	Front Plunger Retainer	1 Y
Other Components				
7	63800-8504	63800-8504	Wire Stop	1
8	11-18-4083	60707-8	Front Cover	1
9	63443-0009	63443-0009	Scrape Chute	1
10	63443-0021	63443-0021	Lower Tooling Key	1
11	63443-2508	63443-2508	Anvil Mount	1
12	63443-3160	63443-3160	Front Plunger Striker	1
13	63443-6013	63443-6013	Rear Cover	1
14	63700-0539	63700-0539	Cut-off Plunger Spring	1
Frame				
15	63800-8800	63800-8800	T2 Terminator-Frame Wide Track	1
Hardware				
16	N/A	N/A	M3 by 6Lg. SHCS	2**
17	N/A	N/A	M4 by 6Lg. SHCS	1**
18	N/A	N/A	M4 by 12Lg. BHCS	2**
19	N/A	N/A	M4 by 50Lg. SHCS	2**
20	N/A	N/A	M4 by 12Lg SHCS	1**
21	N/A	N/A	3MM by 6Lg. Roll Pin	1**
22	N/A	N/A	#10-32 by 1/4"Lg. BHCS	1**
** Available from an industrial supply company such as MSC (1-800-645-7270).				

Assembly Drawing

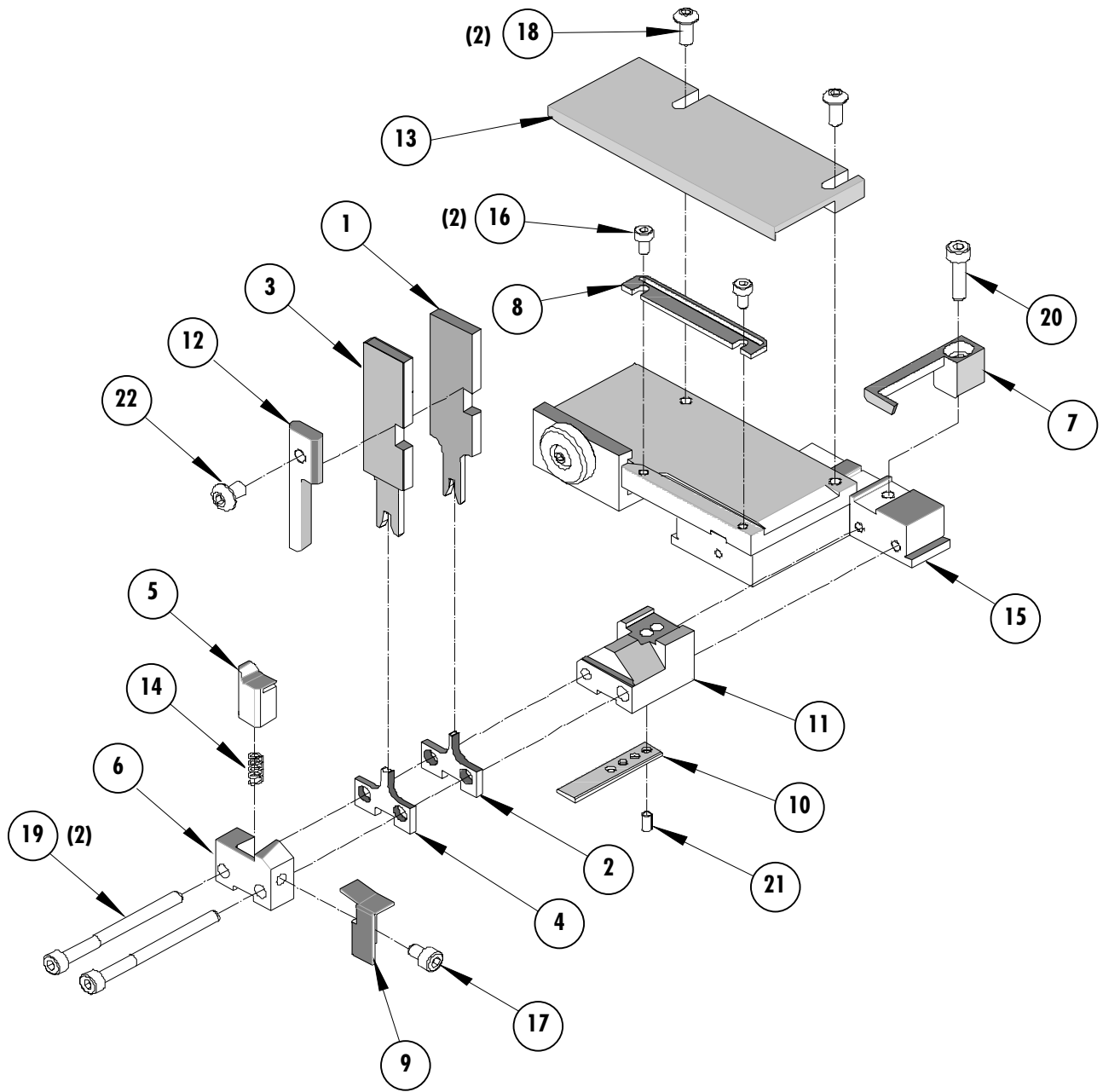


Figure 1

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).

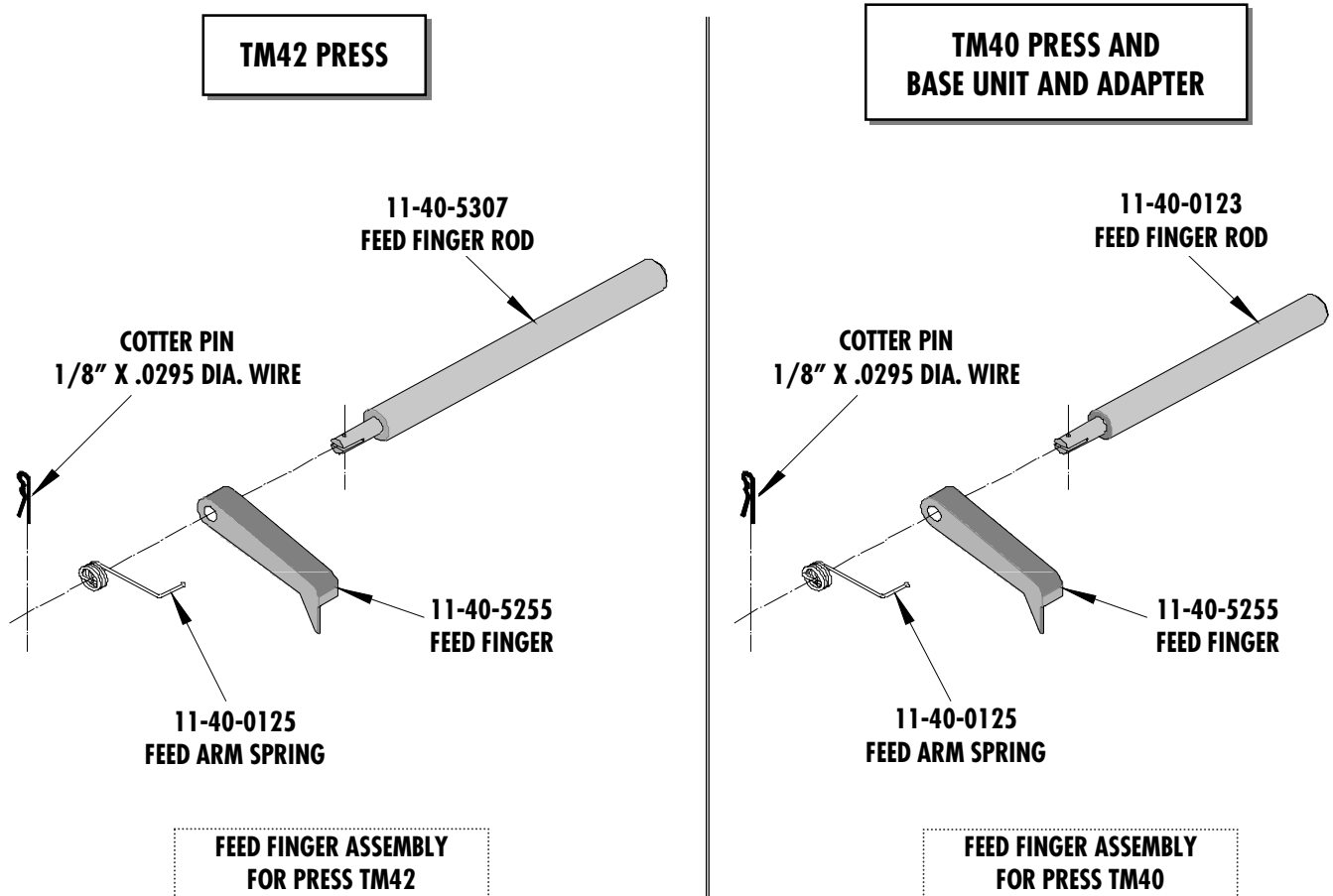


Figure 2

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.

Americas Headquarters
Lisle, Illinois 60532 U.S.A.
1-800-78MOLEX
amerinfo@molex.com

Far East North Headquarters
Yamato, Kanagawa, Japan
81-462-65-2324
feninfo@molex.com

Far East South Headquarters
Jurong, Singapore
65-6-268-6868
fesinfo@molex.com

European Headquarters
Munich, Germany
49-89-413092-0
eurinfo@molex.com

Corporate Headquarters
2222 Wellington Ct.
Lisle, IL 60532 U.S.A.
630-969-4550
Fax: 630-969-1352

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



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Как с нами связаться

Телефон: 8 (812) 309 58 32 (многоканальный)

Факс: 8 (812) 320-02-42

Электронная почта: org@eplast1.ru

Адрес: 198099, г. Санкт-Петербург, ул. Калинина, дом 2, корпус 4, литера А.