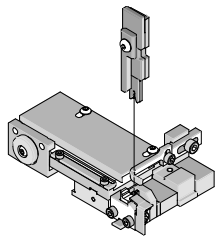
T2 Terminator Tooling

molex

Application Tooling Specification Sheet



Order No. 63910-9800

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

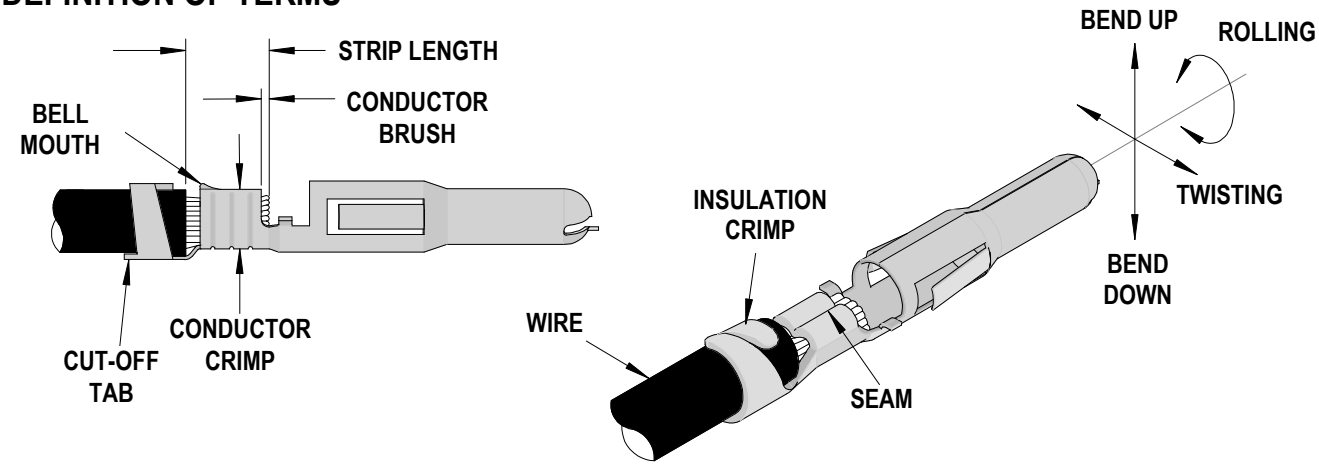
SCOPE

Products: MLX™ Crimp Terminals, 14-20 AWG.

Terminal Series No.	Terminal Order No.		Wire Size		Insulation Diameter				Strip Length	
					IPC/WHMA-A620 (1)		Terminal (2)			
			AWG	mm²	mm	In.	mm	In.	mm	In.
42023	02-08-2003	02-08-2009	14-20	2.00-0.50	2.65-3.30	.104-.130	1.52-3.30	.060-.130	3.96-5.54	.156-.218
	02-08-2005	02-08-2011								
	02-08-2007	02-08-2012								
42024	02-08-1001	02-08-1005	14-20	2.00-0.50	2.65-3.30	.104-.130	1.52-3.30	.060-.130	3.96-5.54	.156-.218
	02-08-1003	02-08-1007								

1) To achieve optimum IPC-A620 insulation crimps, use this insulation OD range.
(2) Overall insulation OD specification for terminal.
To achieve optimum IPC-A620 insulation crimps for 2.08-2.50mm (.082-.098") diameter, use Terminator 63910-7500.
To achieve optimum IPC-A620 insulation crimps for 2.41-2.95mm (.095-.116") diameter, use Terminator 63910-9900.

DEFINITION OF TERMS



CRIMP SPECIFICATION

Terminal Series No.	Bell mouth		Cut-off Tab Maximum		Conductor Brush	
	Mm	In.	mm	In.	mm	In.
42023	0.25-0.51	.010-.020	0.13	.005	0.38-0.70	.015-.027
42024	0.25-0.51	.010-.020	0.13	.005	0.38-0.70	.015-.027

Terminal Series No.	Bend up	Bend down	Twist	Roll	Punch Width mm (Ref)				Seam
					Conductor		Insulation		
	Degree		Degree		mm	In	mm	In	
42023	3	3	4	8	2.30	.090	3.60	.142	Seam shall not be open and no wire allowed out of the crimping area
42024	3	3	4	8	2.30	.090	3.60	.142	

After crimping, the conductor profile should measure the following.

Terminal Series No.	Wire Size		Conductor Crimp				Pull Force Minimum	
			Height		Width			
	AWG	mm^2	mm	In	mm	In	N	Lb.
42023	14	2.00	1.70-1.80	.067-.071	2.33-2.53	.092-.100	222.4	50.0
	16	1.30	1.45-1.55	.057-.061	2.31-2.51	.091-.099	200.2	45.0
	18	0.80	1.27-1.37	.050-.054	2.28-2.48	.090-.098	133.4	30.0
	20	0.50	1.14-1.24	.045-.049	2.24-2.44	.088-.096	62.3	14.0
42024	14	2.00	1.70-1.80	.067-.071	2.33-2.53	.092-.100	222.4	50.0
	16	1.30	1.45-1.55	.057-.061	2.31-2.51	.091-.099	200.2	45.0
	18	0.80	1.27-1.37	.050-.054	2.28-2.48	.090-.098	133.4	30.0
	20	0.50	1.14-1.24	.045-.049	2.24-2.44	.088-.096	62.3	14.0

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

T2 Terminator 63910-9800				
Item	**Order No**	**Engineering No.**	**Description**	**Quantity**
Perishable Tooling				
	63910-9870	63910-9870	Tool Kit (All "Y" Items)	REF
1	63444-2313	63444-2313	Conductor Punch	1 Y
2	63445-2343	63445-2343	Conductor Anvil	1 Y
3	63446-3622	63446-3622	Insulation Punch	1 Y
4	63445-3643	63445-3643	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				
7	11-18-4083	60707-8	Feed Guide	1
8	11-24-1067	4996-4	Cut-Off Plunger Spring	1
9	63443-0009	63443-0009	Front Scrap Chute	1
10	63443-0024	63443-0024	Key	1
11	63443-0085	63443-0085	Wire Stop L-Bracket	1
12	63443-0090	63443-0090	Wire Stop	1
13	63443-1716	63443-1716	Height Spacer (18.60mm)	1
14	63443-2214	63443-2214	Coarse Spacer (14.00mm)	1
15	63443-2318	63443-2318	Fine Spacer (3.90mm)	1
16	63443-2801	63443-2801	Front Plunger Striker	1
17	63443-2908	63443-2908	Wire Hold Down Plunger	1
18	63443-6013	63443-6013	Rear Cover	1
19	63443-7201	63443-7201	Spring Cover	1
20	63600-1057	63600-1057	Wire Hold Down Spring	1
21	63600-2972	63600-2972	Collar	2
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 5/8"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

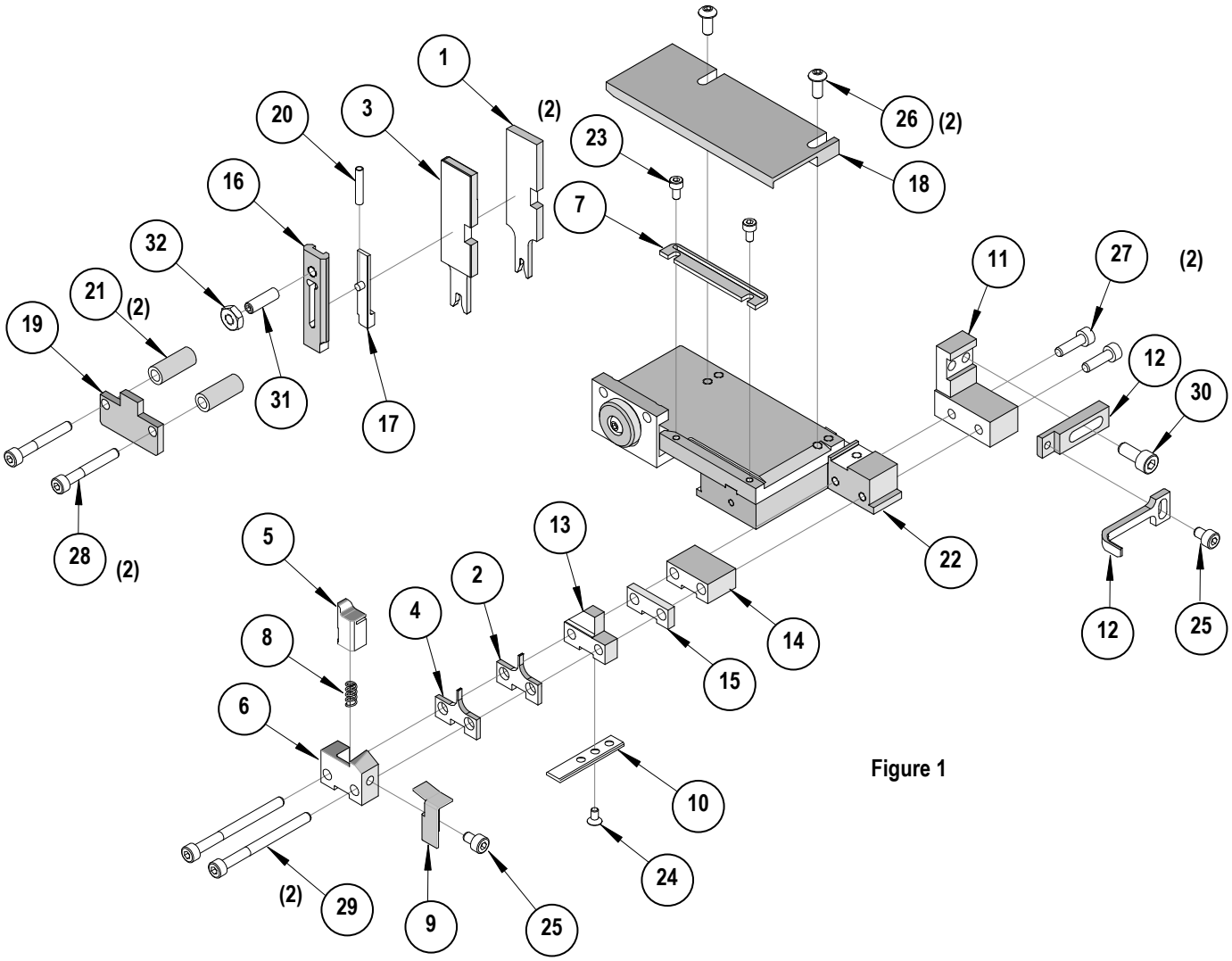


Figure 1

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).

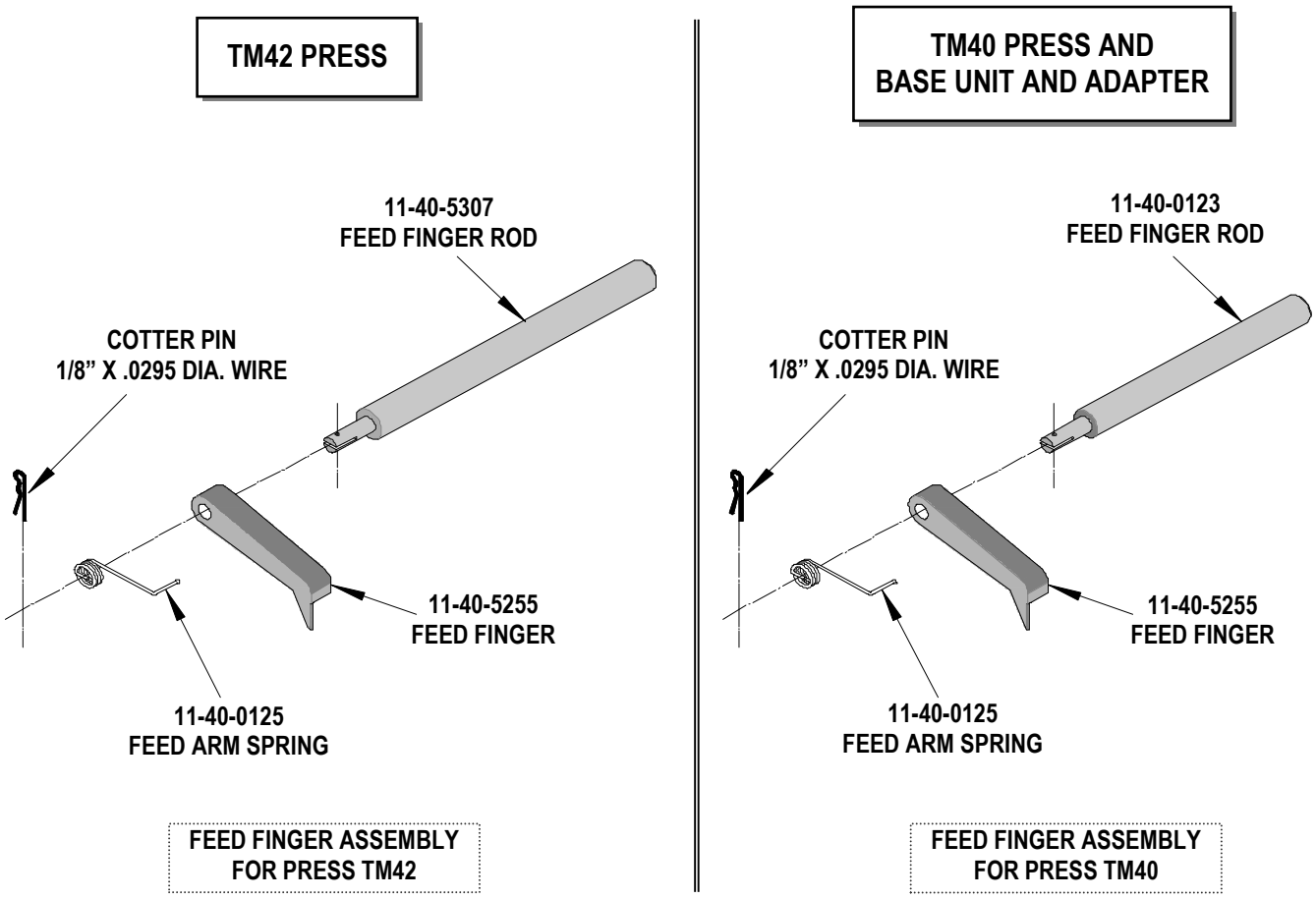


Figure 2

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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- Подбор аналогов;
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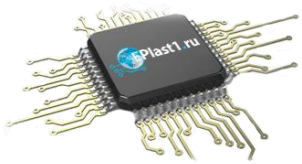
- Защита от снятия компонента с производства.



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