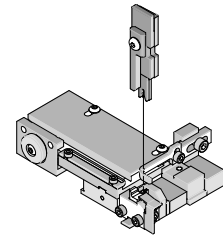




T2 Terminator Tooling

Application Tooling Specification Sheet



Order No. 63910-1400

FEATURES

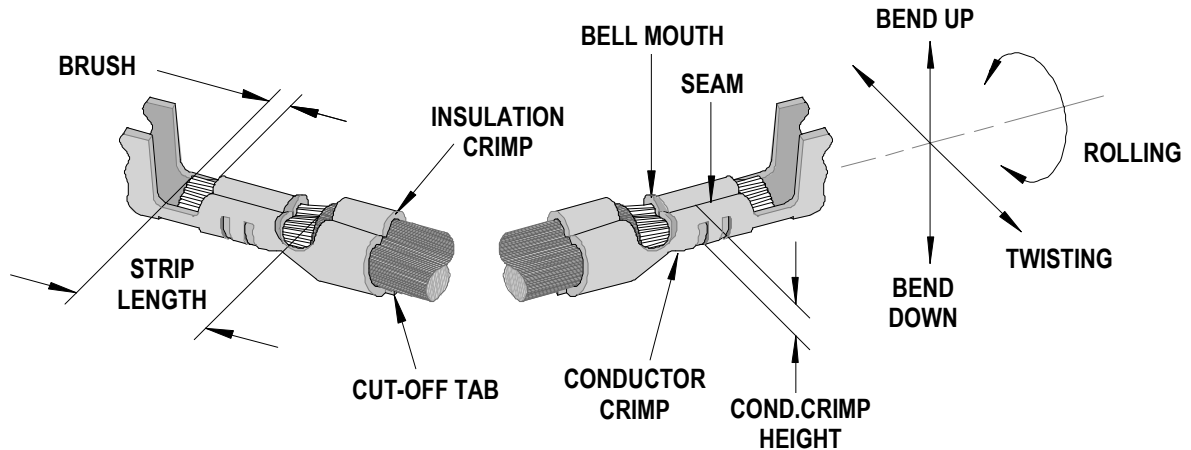
- It is ideally suited for mid-volume bench operations
- This terminator can be installed in the TM42 and the TM40 press or Base Unit adapter for 3BF press
- Quick punch removal with the push of a button for fast and easy tooling change
- Track adjustment capabilities in the T2 Terminators for improved 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: Low Force Micro-Fit 3.0™ Crimp Terminal, 20-24 AWG.

Terminal Series No.	Terminal Order No.		Wire Size		Insulation Diameter		Strip Length	
			AWG	mm ²	mm	In.	mm	In.
46235	46235-0001	46235-0002	20-24	0.50-0.20	1.30-1.85	.051-.073	2.54-2.92	.100-.115
	46235-5001	46235-5002						

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.
46235	0.05-0.40	.002-.016	0.25	.010	0.20-0.80	.008-.031

Terminal Series No.	Bend up	Bend down	Twist	Roll	Punch Width (Ref)				Seam Seam shall not be open And no wire allowed out
	Degree		Degree		Conductor		Insulation		
					mm	In.	mm	In.	
46235	3	3	4	8	1.20	.047	1.90	.075	

After crimping, the crimp profiles should measure the following:

Terminal Series No.	Wire Size		Conductor				Pull Force Minimum	
			Crimp Height		Crimp Width (Ref)			
	AWG	mm ²	mm	In.	mm	In.	N	Lb.
46235	20	0.50	0.76-0.81	.030-.032	1.25	.049	57.9	13.0
	22	0.35	0.71-0.76	.028-.030	1.25	.049	35.6	8.0
	24	0.20	0.66-0.71	.026-.028	1.25	.049	22.3	5.0

* 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 63910-1400				
Item	Order No	Engineering No.	Description	Quantity
Perishable Tooling				
	63910-1470	63910-1470	Tool Kit (All "Y" Items)	REF
1	63457-0037	63457-0037	Conductor Punch	1 Y
2	63455-0051	63455-0051	Conductor Anvil	1 Y
3	63446-1902	63446-1902	Insulation Punch	1 Y
4	63445-1910	63445-1910	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	11-40-4039	8302-5	Plunger Striker	1
10	63443-0009	63443-0009	Front Scrap Chute	1
11	63443-0025	63443-0025	Key	1
12	63443-0085	63443-0085	Wire Stop L-Bracket	1
13	63443-0090	63443-0090	Wire Stop	1
14	63443-1717	63443-1717	Height Spacer	1
15	63443-2216	63443-2216	Coarse Spacer (16.00mm)	1
16	63443-2302	63443-2302	Fine Spacer (3.10mm)	1
17	63443-6001	63443-6001	Rear Cover	1
Frame				
18	63800-8500	63800-8500	T2 Terminator	1
Hardware				
19	N/A	N/A	M3 by 6 Long SHCS	2**
20	N/A	N/A	M3 by 6 Long FHCS	1**
21	N/A	N/A	M4 by 6 Long SHCS	2**
22	N/A	N/A	M4 by 12 Long BHCS	2**
23	N/A	N/A	M4 by 14 Long SHCS	2**
24	N/A	N/A	M4 by 50 Long SHCS	2**
25	N/A	N/A	M5 by 12 Long SHCS	1**
26	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

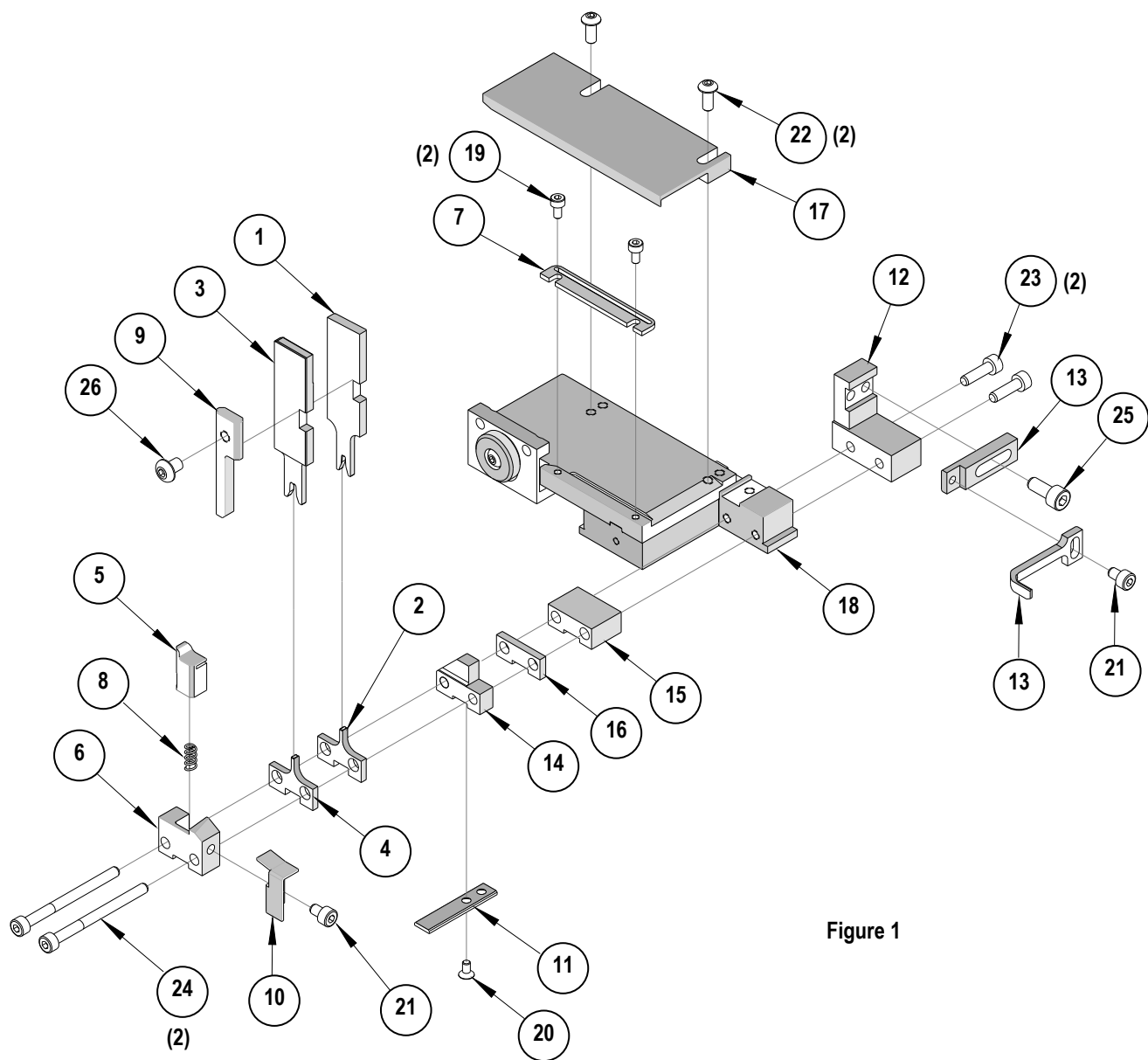


Figure 1

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).

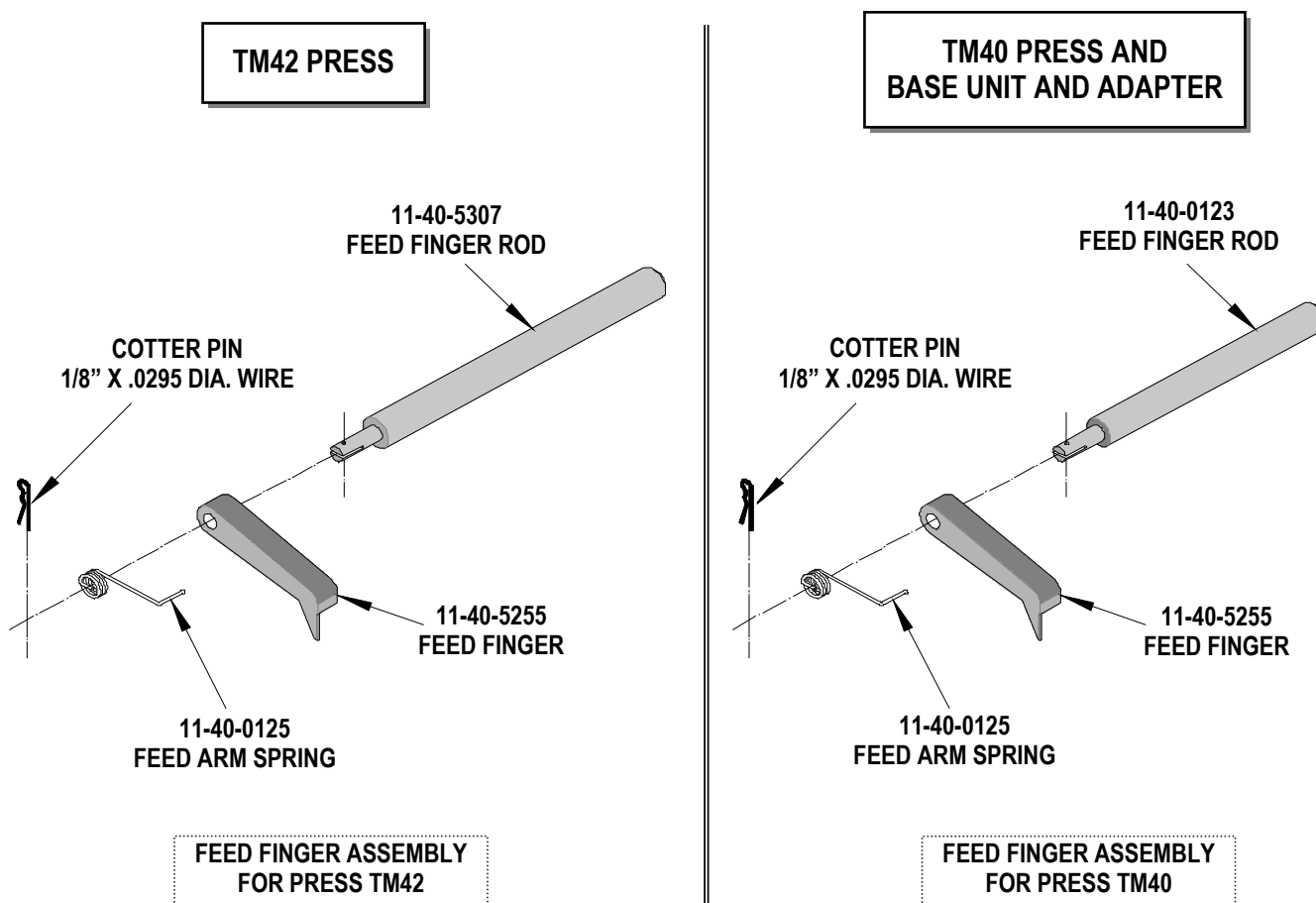


Figure 2

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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