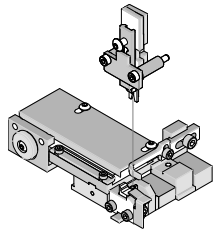
T2 Terminator Tooling	molex Application Tooling Specification Sheet	 Order No. 63911-4200

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

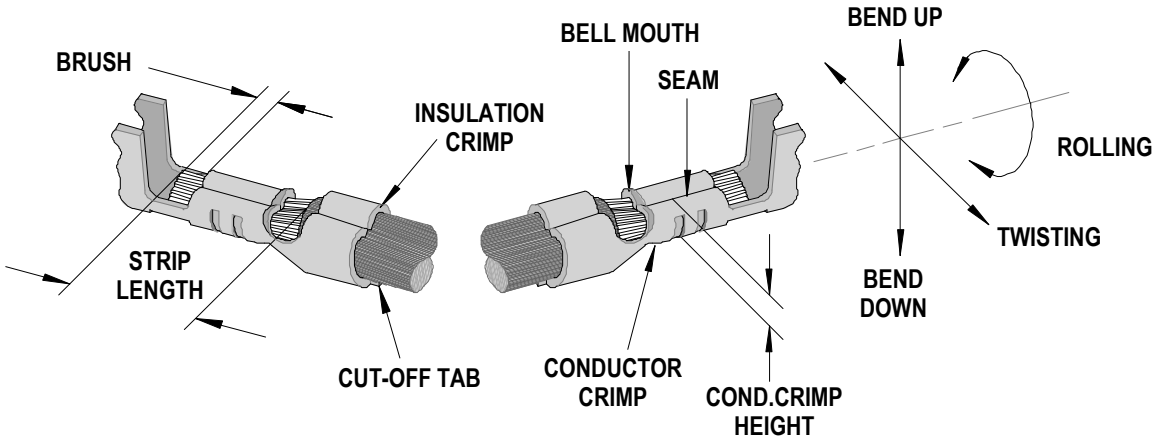
SCOPE

Products: 1.50mm (.059") Pico-SPOX™ Female Crimp Terminal, 24-30 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.
87421	87421-0000	87421-0001	24-30	0.20-0.05	0.90-1.15	.035-.045	0.70-1.15	.027-.045	1.05-1.54	.041-.061

(1) To achieve optimum IPC-A620 Class 2 insulation crimps, use this insulation OD range
(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 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.
87421	0.05-0.40	.002-.016	0.15	.006	0.00-0.50	.000-.020

Terminal Series No.	Bend up Bend down		Twist Roll		Punch Width mm (Ref)				Seam
	Degree		Degree		Conductor		Insulation		Seam shall not be open and no wire allowed out of the crimping area
					mm	In	mm	In	
87421	3	3	3	3	1.00	.039	1.10	.043	

After crimping, the conductor profile should measure the following.

Terminal Series No.	Wire Size		Conductor Crimp Height		Pull Force Minimum	
	AWG	mm^2	mm	In.	N	Lb.
87421	24	0.20	0.56-0.60	.022-.024	29.4	6.6
	26	0.12	0.52-0.58	.020-.023	19.6	4.4
	28	0.08	0.52-0.58	.020-.023	9.8	2.2
	30	0.05	0.52-0.58	.020-.023	4.9	1.1

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 63911-4200				
Item	**Order No**	**Engineering No.**	**Description**	**Quantity**
Perishable Tooling				
	63911-4270	63911-4270	Tool Kit (All "Y" Items)	REF
1	63444-1002	63444-1002	Conductor Punch	1 Y
2	63445-1010	63445-1010	Conductor Anvil	1 Y
3	63446-1110	63446-1110	Insulation Punch	1 Y
4	63445-1129	63445-1129	Insulation Anvil	1 Y
5	63443-0005	63443-0005	Front Cut-Off Plunger	1 Y
6	63443-0012	63443-0012	Front Plunger Retainer	1 Y
Other Components (REF 114250)				
7	11-18-4094	60709A111	Front Cover	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	63443-1703	63443-1703	Height Spacer (17.30mm)	1
14	63443-2217	63443-2217	Coarse Spacer (17.00mm)	1
15	63443-2306	63443-2306	Fine Spacer (3.30mm)	1
16	63443-2801	63443-2801	Front Plunger Striker	1
17	63443-2908	63443-2908	Wire Hold Down Plunger	1
18	63443-6003	63443-6003	Rear Cover	1
19	63443-7201	63443-7201	Spring Cover	1
20	63600-2972	63600-2972	Collar	2
21	63600-0021	63600-0021	Wire Hold Down Spring	1
Frame				
22	63800-8500	63800-8500	T2 Terminator	1
23	63860-2015	63860-2015	Drag Frame Modified	1
Hardware				
24	N/A	N/A	M3 by 6 Long SHCS	2**
25	N/A	N/A	M3 by 6 Long FHCS	1**
26	N/A	N/A	M4 by 6 Long SHCS	2**
27	N/A	N/A	M4 by 12 Long BHCS	2**
28	N/A	N/A	M4 by 14 Long SHCS	2**
29	N/A	N/A	M4 by 30 Long SHCS	2**
30	N/A	N/A	M4 by 50 Long SHCS	2**
31	N/A	N/A	M5 by 12 Long SHCS	1**
32	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

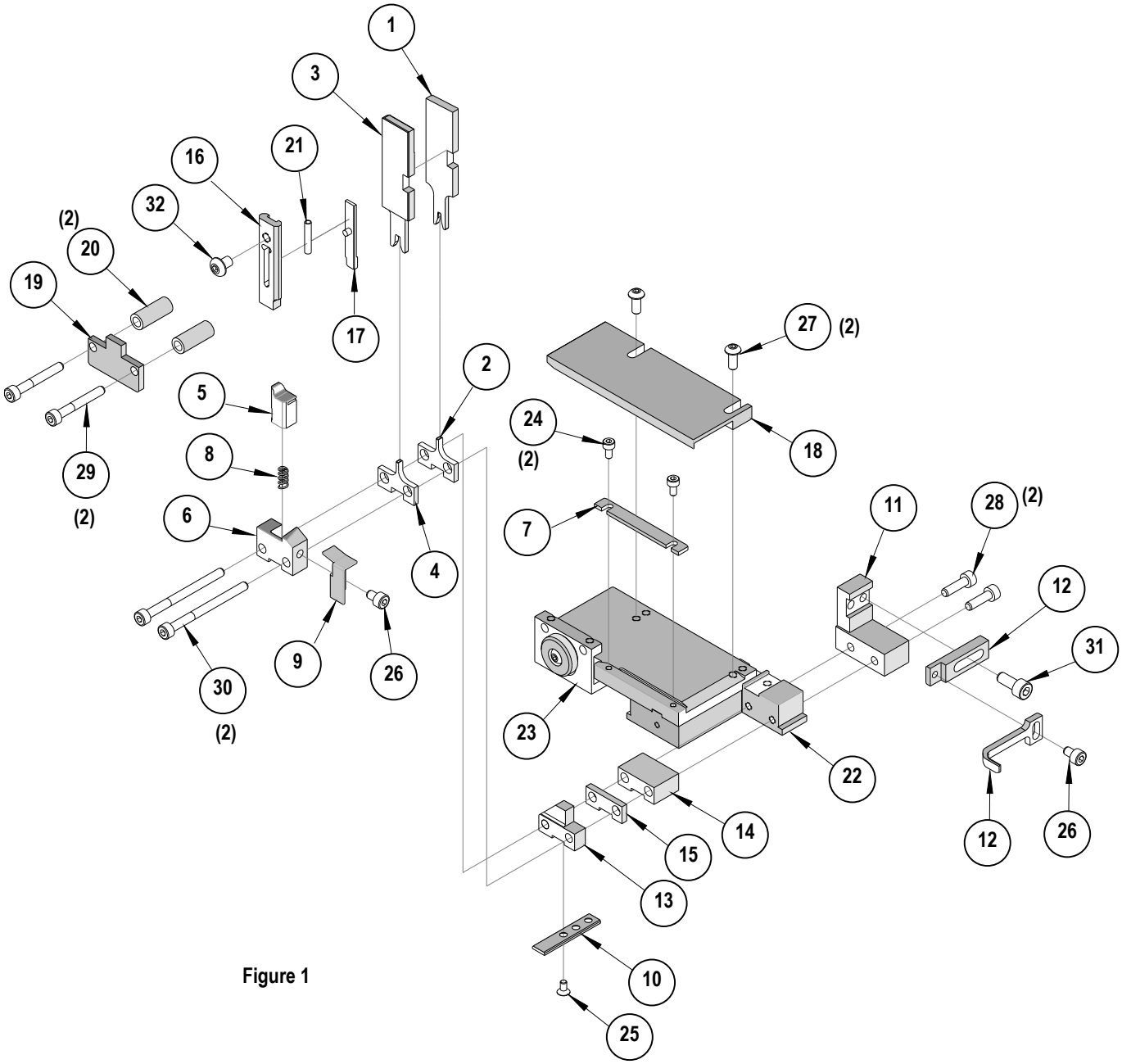


Figure 1

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).

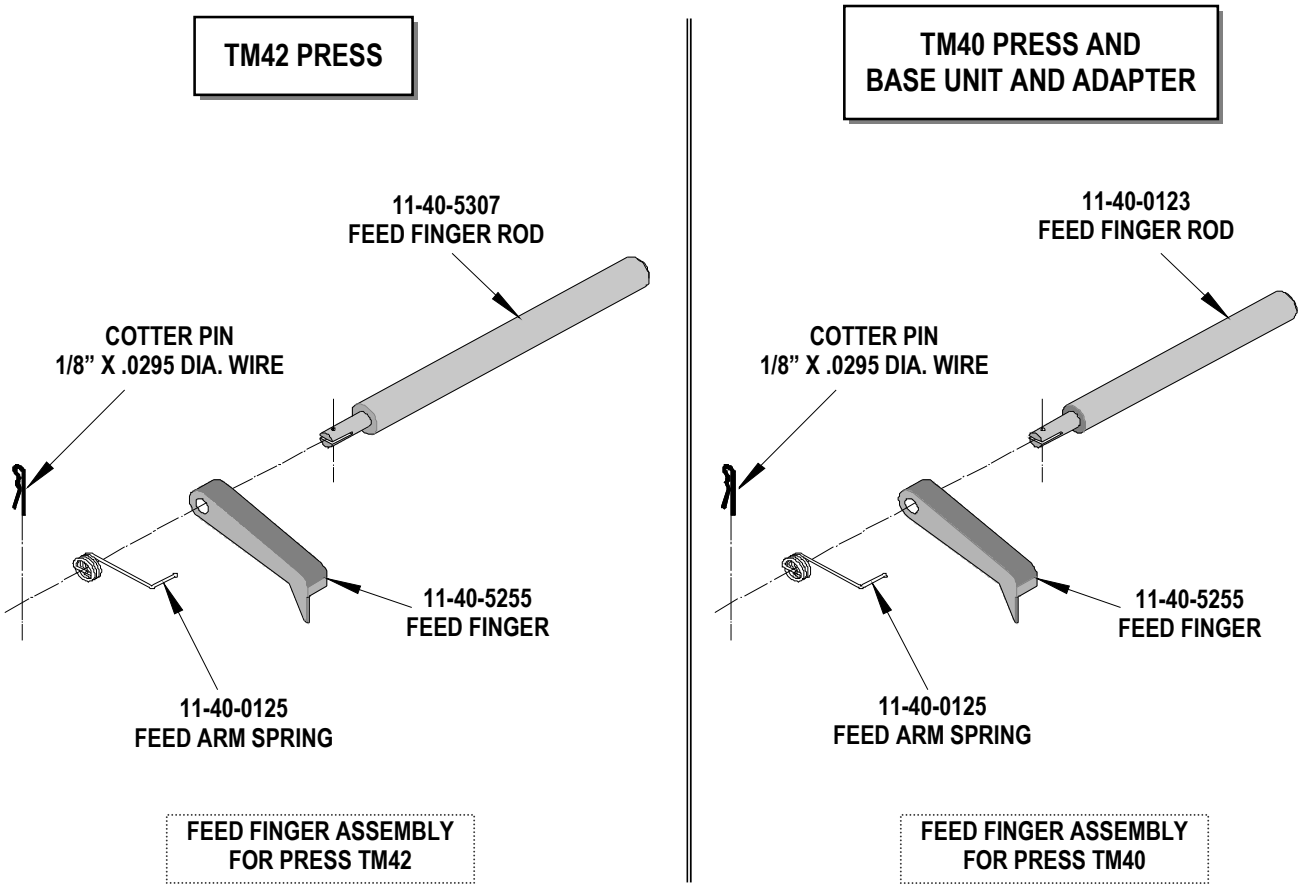


Figure 2

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 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.

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

Mouser Electronics

Authorized Distributor

Click to View Pricing, Inventory, Delivery & Lifecycle Information:

Molex:
63911-4270