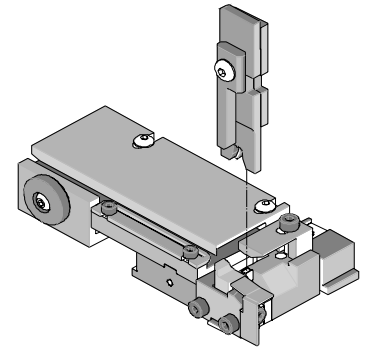




T2 Terminator Tooling Specification Sheet Part No. 63852-7000



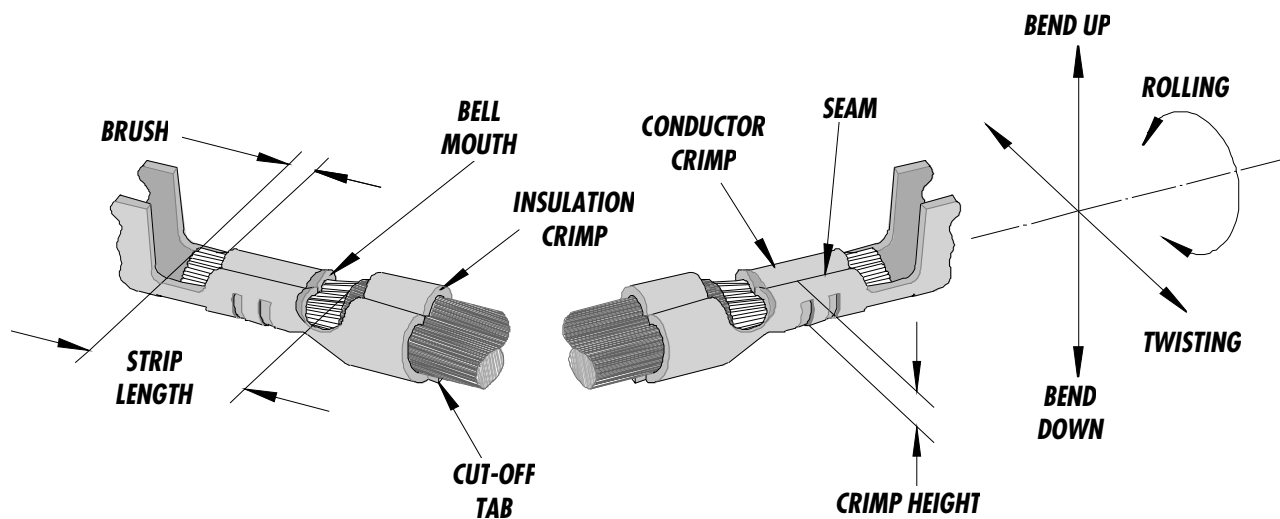
FEATURES

- 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

Terminal Series No.	Wire Size		Insulation Diameter		Strip Length	
	AWG	mm ²	mm	In.	mm	In.
87421-0000	24	0.20	1.15 max.	.045 max.	1.05-1.54	.041-.061
87421-0000	26	0.12	1.15 max.	.045 max.	1.05-1.54	.041-.061
87421-0000	28	0.08	1.15 max.	.045 max.	1.05-1.54	.041-.061
87421-0000	30	0.05	1.15 max.	.045 max.	1.05-1.54	.041-.061

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.
87421-0000	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 Seam shall not be open and no wire allowed out of the crimping area
	Degree		Degree		Conductor		Insulation		
	mm	In	mm	In	mm	In	mm	In	
87421-0000	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 Min.	
	AWG	mm ²	mm	In.	N	Lb.
87421-0000	24	0.20	0.56-0.60	.022-.024	29.4	6.6
87421-0000	26	0.12	0.52-0.58	.020-.023	19.6	4.4
87421-0000	28	0.08	0.52-0.58	.020-.023	9.8	2.2
87421-0000	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

Item	Order No	Engineering No.	Description	Quantity
	63852-7000	63852-7000	T2 Terminator (Fig. 1)	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	63443-0003	63443-0003	Cut-Off Plunger	1 Y
6	63443-0012	63443-0012	Front Plunger Retainer	1
7	11-24-1067	4996-4	Cut-off Plunger Spring	1
8	63443-3160	63443-3160	Front Plunger Striker	1
9	63443-0021	63443-0021	Lower Tooling Key	1
10	63443-6003	63443-6003	Front Cover	1
11	11-18-4094	60709A111	Rear Cover	1
12	63443-2402	63443-2402	Anvil Mount	1
13	63443-4025	63443-4025	Wire Stop	1
14	63443-0009	63443-0009	Scrape Chute	1
15	63800-8500	63800-8500	T2 Terminator	1
16	63860-2015	63860-2015	* Drag Frame (Modified)	1
17	N/A	N/A	M3 by 6Lg. SHCS	2**
18	N/A	N/A	M4 by 6Lg. SHCS	1**
19	N/A	N/A	M4 by 12Lg. BHCS	2**
20	N/A	N/A	M4 by 16Lg. SHCS	1**
21	N/A	N/A	M4 by 20Lg. SHCS	1**
22	N/A	N/A	M4 by 50Lg. SHCS	1**
23	N/A	N/A	3MM by 6Lg. Roll Pin	1**
24	N/A	N/A	#10-32 by 3/8"Lg. BHCS	1**
	63852-7070	63852-7070	Tool Kit (All Y Items)	Ref

***T2 Terminator parts to be modified**

**** The following purchased parts are available from an Industrial supply company such as MSC (1-800-645-7270).**

Assembly Drawing

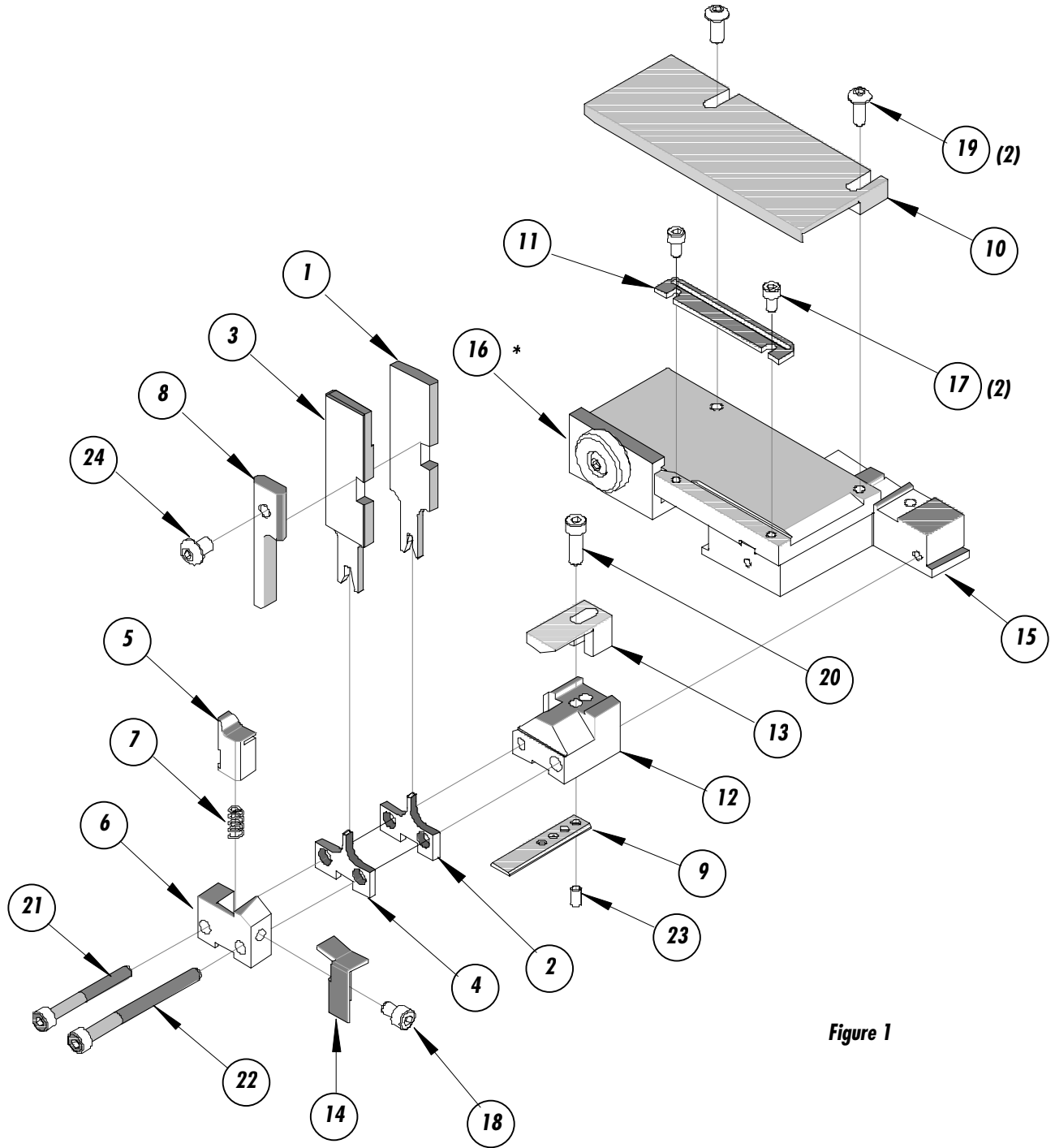


Figure 1

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).

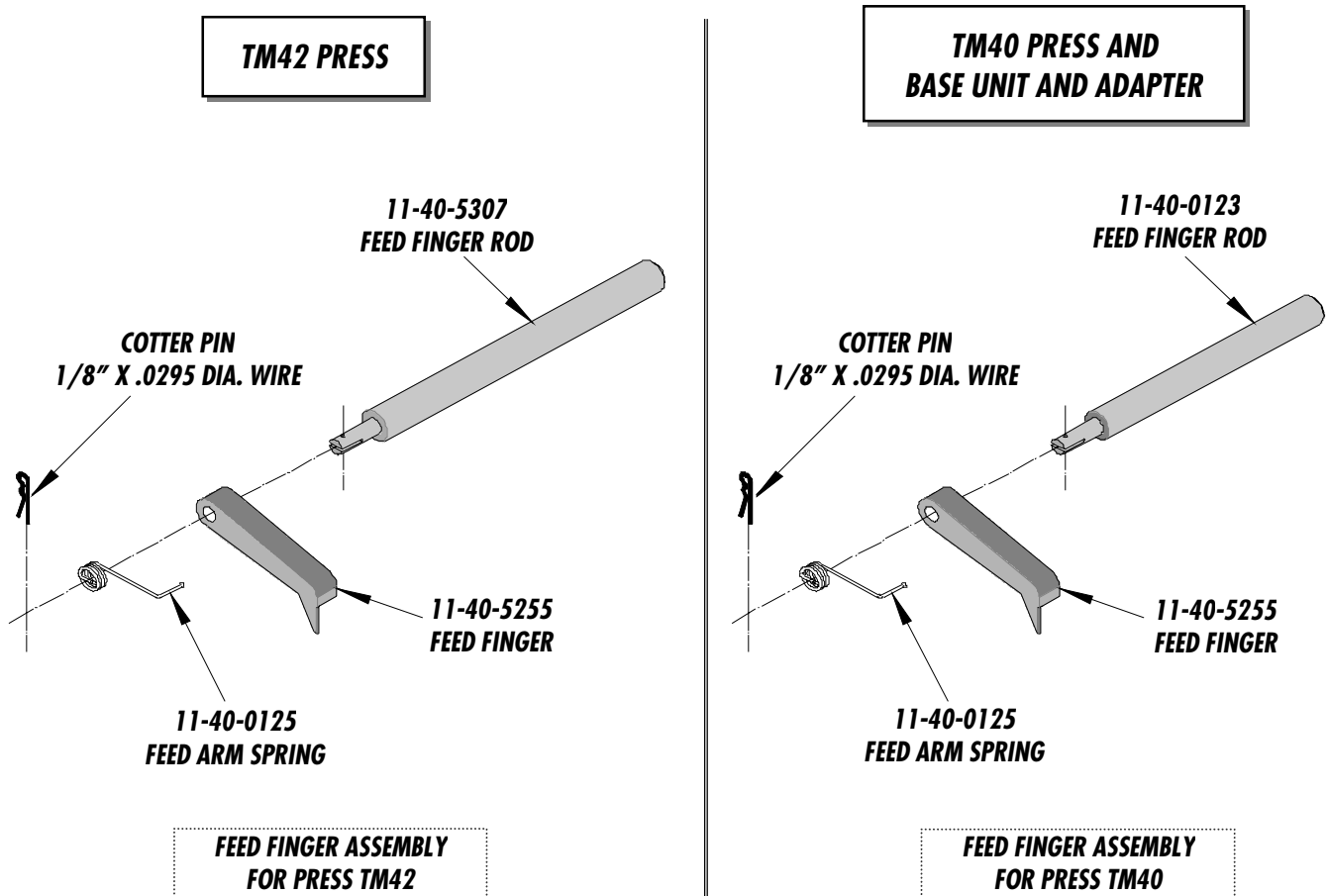


Figure 2

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

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