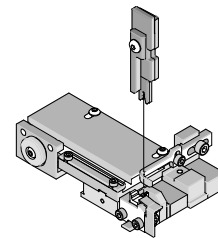


## T2 Terminator Tooling

# molex

## Application Tooling Specification Sheet


**Order No. 63910-8400**

### FEATURES

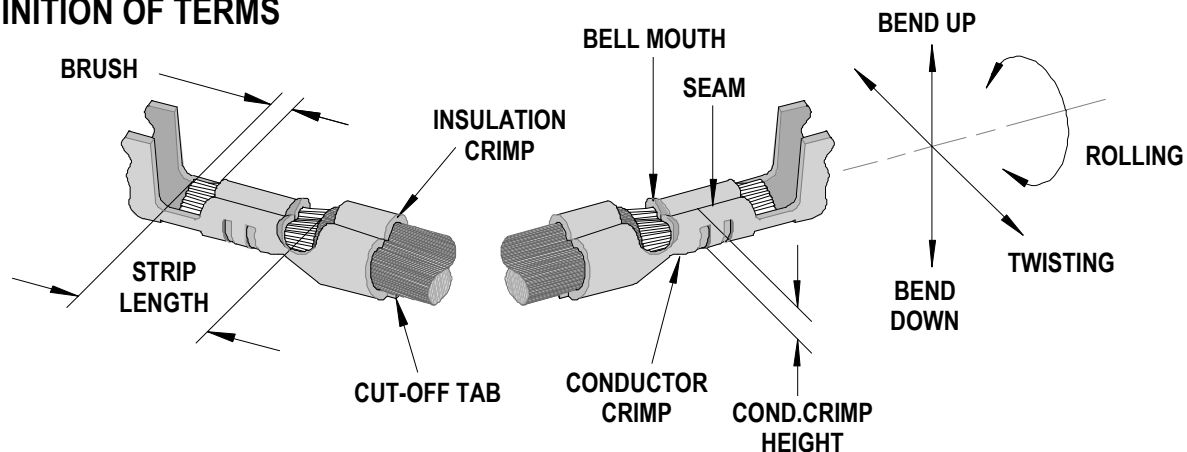
- It is ideally suited for mid-volume bench operations
- This terminator can be installed in the TM42 and the TM40 press or Base Unit adapter for 3BF press
- Quick punch removal with the push of a button for fast and easy tooling change
- Track adjustment capabilities in the T2 Terminators for improved 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: MX150L™ Female Terminal for 18-24 AWG Wire.

Terminal Series No.	Terminal Order No.		Wire Size		Insulation Diameter		Strip Length	
			AWG	mm <sup>2</sup>	mm	In.	mm	In.
19420	19420-0002	Female (Tin)	18-22	0.83-0.36	2.36-2.74	.093-.108	4.20-5.00	.165-.197
	19420-0004	Female (Gold)	18-22	0.83-0.36	2.36-2.74	.093-.108	4.20-5.00	.165-.197
	19420-0002	Female (Tin)	24	0.20	1.00 Nom.	.039 Nom.	4.20-5.00	.165-.197
	19420-0004	Female (Gold)	24	0.20	1.00 Nom.	.039 Nom.	4.20-5.00	.165-.197
<b>Note: Terminals will accommodate the following wire specification:</b> 1. (18-22 AWG) UL1015 wires. 2. (24 AWG) UL20251 wire. For 24 AWG wire, see Tool Qualification Notes, Item 2 on page 2. For TXL-style insulation, see Tool Qualification Notes, Item 3 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 Maximum		Conductor Brush	
	mm	In.	mm	In.	mm	In.
19420	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	
19420	5	5	4	8	2.00	.079	3.40	.133	

After crimping, the conductor profile should measure the following.

Terminal Series No.	Wire Size		Conductor Crimp Height		Insulation Crimp Height Maximum		Pull Force Minimum	
	AWG	mm <sup>2</sup>	mm	In.	Mm (Ref)	In. (Ref)	N	Lb.
19420	18	0.83	1.15-1.25	.045-.049	3.00	.118	89.0	20.00
	20	0.58	1.10-1.20	.043-.047	3.00	.118	57.9	13.00
	22	0.36	1.05-1.15	.041-.045	3.00	.118	35.6	8.00
	24	0.20	1.00-1.10	.039-.043	3.00	.118	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 Applicator 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 2.11mm (.083").
3. TXL-style automotive wire can be crimped but the insulation crimp will not fully contact the wire insulation.

**PARTS LIST**

<b>T2 Terminator 63910-8400</b>				
<b>Item</b>	<b>Order No</b>	<b>Engineering No.</b>	<b>Description</b>	<b>Quantity</b>
<b>Perishable Tooling</b>				
	63910-8470	63910-8470	Tool Kit (All "Y" Items)	REF
1	63444-2037	63444-2037	Conductor Punch	1 Y
2	63445-2068	63445-2068	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	Front Cut-Off Plunger	1 Y
6	63443-0036	63443-0036	Front Plunger Retainer	1 Y
<b>Other Components</b>				
7	11-18-4083	60707-8	Feed Guide	1
8	63443-0009	63443-0009	Front Scrap Chute	1
9	63443-0024	63443-0024	Key	1
10	63443-0085	63443-0085	Wire Stop L-Bracket	1
11	63443-0090	63443-0090	Wire Stop	1
12	63443-1712	63443-1712	Height Spacer	1
13	63443-2206	63443-2206	Coarse Spacer (6.00mm)	1
14	63443-2208	63443-2208	Coarse Spacer (8.00mm)	1
15	63443-2312	63443-2312	Fine Spacer (3.60mm)	1
16	63443-3160	63443-3160	Plunger Striker	1
17	63443-6013	63443-6013	Rear Cover	1
18	63700-0539	63700-0539	Cut-Off Plunger Spring	1
<b>Frame</b>				
19	63800-8800	63800-8800	T2 Terminator	1
<b>Hardware</b>				
20	N/A	N/A	M3 by 6 Long SHCS	2**
21	N/A	N/A	M3 by 6 Long FHCS	1**
22	N/A	N/A	M4 by 6 Long SHCS	2**
23	N/A	N/A	M4 by 12 Long BHCS	2**
24	N/A	N/A	M4 by 14 Long SHCS	2**
25	N/A	N/A	M4 by 50 Long SHCS	2**
26	N/A	N/A	M5 by 12 Long SHCS	1**
27	N/A	N/A	#10-32 by 1/4" Long BHCS	1**
** Available from an industrial supply company such as MSC (1-800-645-7270).				

# Assembly Drawing

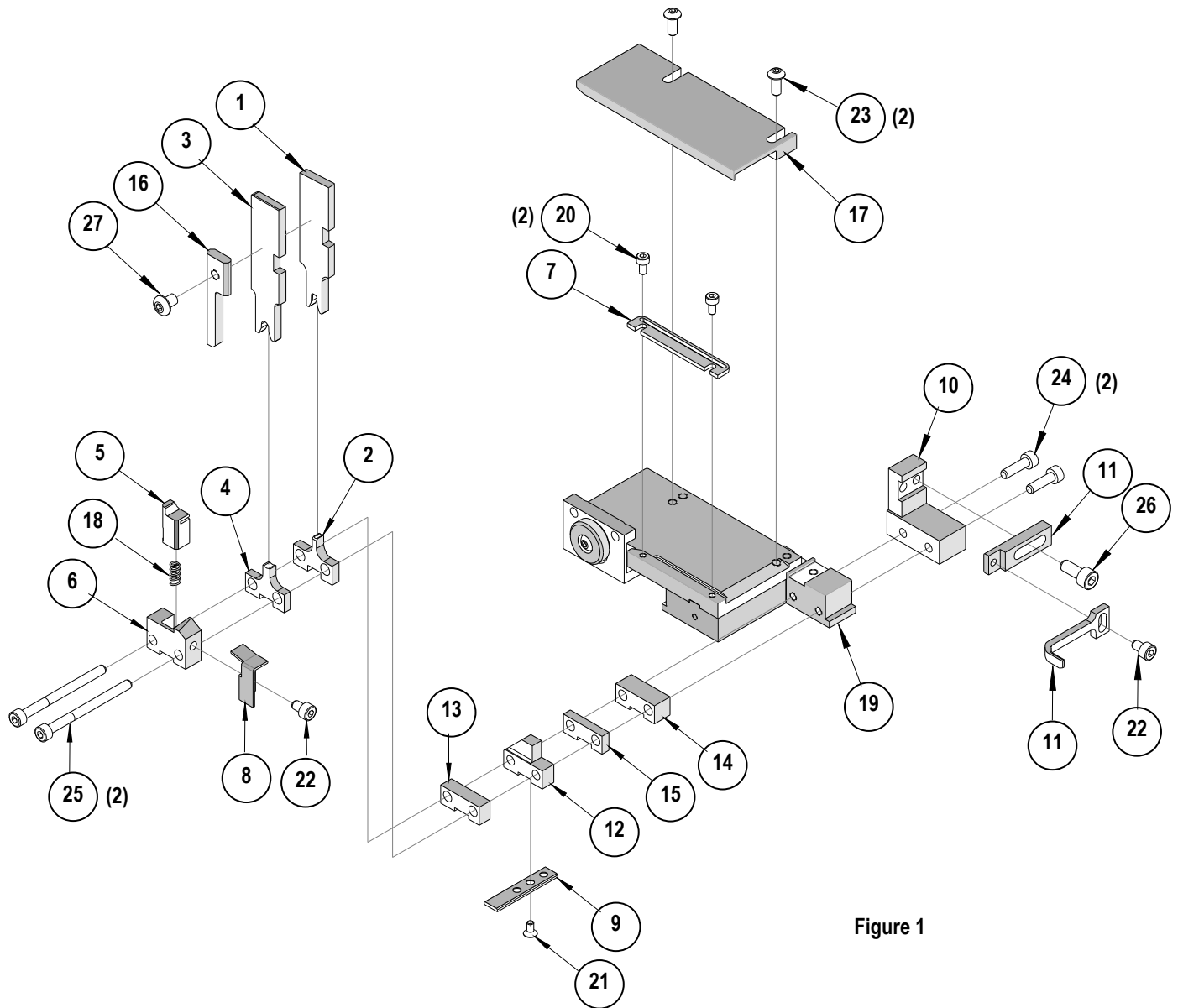


Figure 1

## 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).

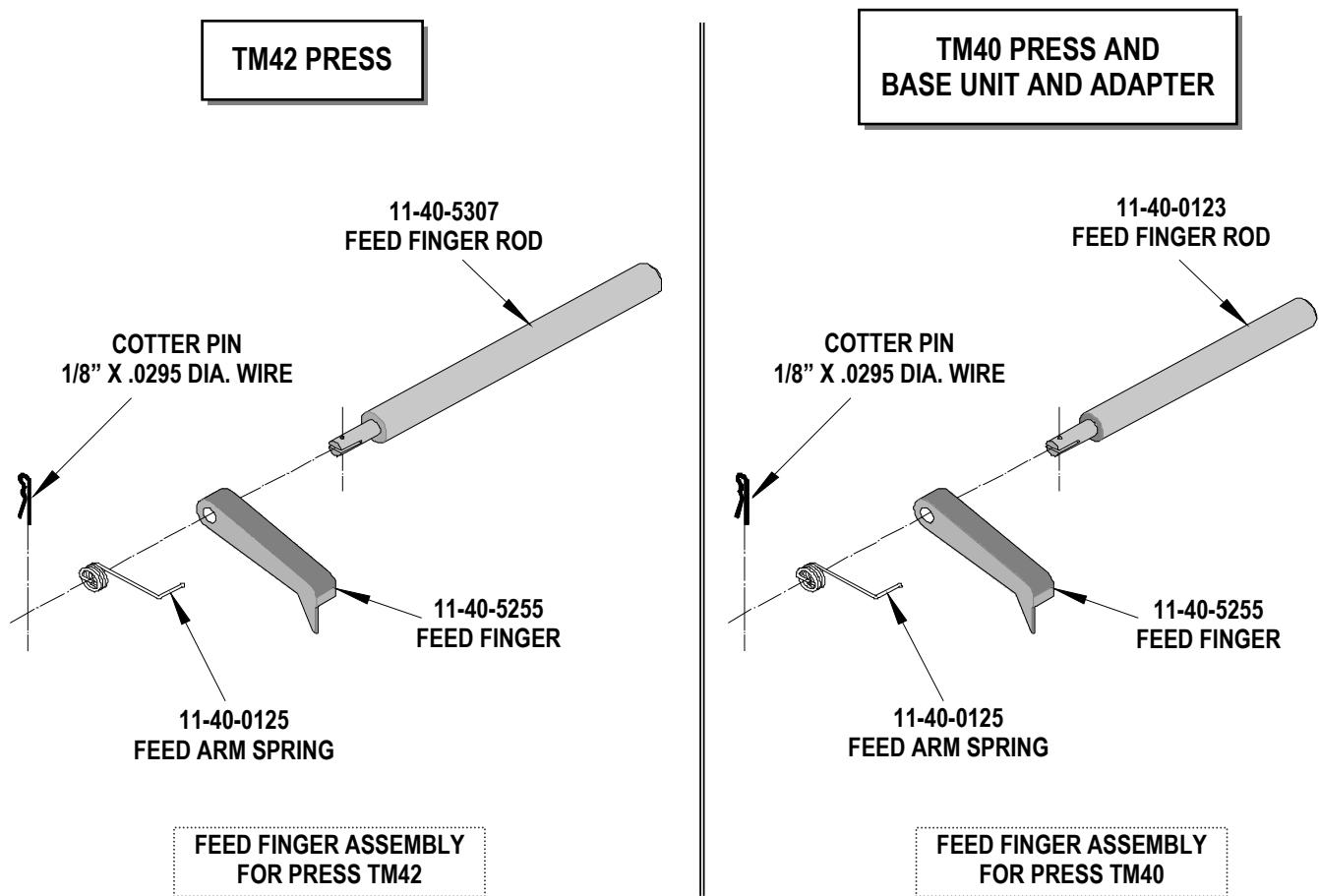


Figure 2

## 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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