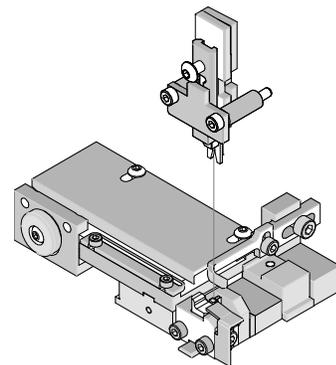




# T2 Terminator Tooling Specification Sheet Order No. 63911-1200



## 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

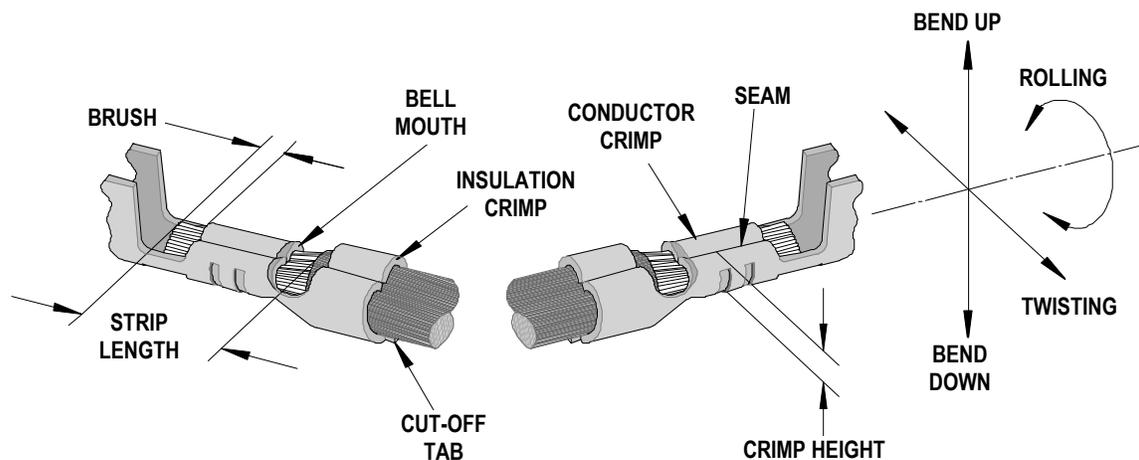
## SCOPE

Products: OBD II 1.52mm (.060") Crimp Terminal, 0.30-0.50mm<sup>2</sup> and 20-22 AWG.

Terminal Series No.	Terminal Order No.	Wire Size		Insulation Diameter				Strip Length	
				IPC/WHMA-A620 ♦		Terminal ♦♦			
		AWG	mm <sup>2</sup>	mm	In.	mm	In.	mm	In.
57964	57964-9702	AVS-0.3, CAVS-0.3	0.37	1.40-2.30	.055-.090	1.40-2.30	.055-.090	3.60-4.80	.142-.189
		22AWG	0.35						
		AVS-0.5, CAVS-0.5	0.56						
		20AWG	0.50						

♦ To achieve optimum IPC-A620 insulation crimps, use this insulation OD range.  
♦♦ 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.
57964	0.20-0.80	.008-.031	0.20	.008	0.30-1.50	.012-.059

Terminal Series No.	Bend up	Bend down	Twist	Roll	Punch Width mm (Ref)				Seam
	Degree		Degree		Conductor		Insulation		
					mm	In	mm	In	
57964	3	3	4	6	1.80	.071	2.30	.091	Seam shall not be open and no wire allowed out of the crimping area

After crimping, the conductor profile should measure the following.

Terminal Series No.	Wire Size	Actual mm <sup>2</sup>	Conductor Crimp				Pull Force Minimum	
			Crimp Height		Crimp Width (Ref.)		N	Lb.
			mm	In.	mm	In.		
57964	0.3, 0.3f	0.37	1.05-1.15	.041-.045	1.90	.075	58.8	13.2
	22AWG	0.35	1.05-1.15	.041-.045	1.90	.075	58.8	13.2
	0.5, 0.5f	0.56	1.15-1.25	.045-.049	1.90	.075	88.2	19.8
	20AWG	0.50	1.15-1.25	.045-.049	1.90	.075	88.2	19.8

Terminal Series No.	Wire Size	Actual mm <sup>2</sup>	Insulation			
			Crimp Height (Max.)		Crimp Width (Ref.)	
			mm	In.	mm	In.
57964	0.3, 0.3f	0.37	2.60	.102	2.65	.104
	22AWG	0.35	2.60	.102	2.65	.104
	0.5, 0.5f	0.56	2.60	.102	2.65	.104
	20AWG	0.50	2.60	.102	2.65	.104

Pull Force should be measured with no influence from the insulation crimp.  
The above specifications are guidelines to an optimum crimp.

**PARTS LIST**

<b>T2 Terminator 63911-1200</b>				
<b>Item</b>	<b>Order No</b>	<b>Engineering No.</b>	<b>Description</b>	<b>Quantity</b>
<b>Perishable Tooling</b>				
	63911-1270	63911-1270	Tool Kit (All "Y" Items)	REF
1	63444-1826	63444-1826	Conductor Punch	1 Y
2	63445-1846	63445-1846	Conductor Anvil	1 Y
3	63454-0081	63454-0081	Insulation Punch	1 Y
4	63445-2645	63445-2645	Insulation Anvil	1 Y
5	63443-0003	63443-0003	Front Cut-Off Plunger	1 Y
6	63443-0012	63443-0012	Front Plunger Retainer	1 Y
<b>Other Components (REF 111250)</b>				
7	11-18-4083	60707-8	Feed Guide	1
8	63443-0009	63443-0009	Front Scrap Chute	1
9	63443-0025	63443-0025	Key	1
10	63443-0085	63443-0085	Wire Stop L-Bracket	1
11	63443-0090	63443-0090	Wire Stop	1
12	63443-1717	63443-1717	18.70mm Height Spacer	1
13	63443-2215	63443-2215	15.00mm Coarse Spacer	1
14	63443-2308	63443-2308	3.40mm Fine Spacer	1
15	63443-2802	63443-2802	Front Plunger Striker	1
16	63443-2912	63443-2912	Wire Hold Down Plunger	1
17	63443-6009	63443-6009	Rear Cover	1
18	63443-7201	63443-7201	Spring Cover	1
19	63600-0021	63600-0021	Wire Hold Down Spring	1
20	63600-2972	63600-2972	Collar	2
21	11-24-1067	4996-4	Cut-Off Plunger Spring	1
<b>Frame</b>				
22	63800-8500	63800-8500	T2 Terminator	1
<b>Hardware</b>				
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 3/8" Long BHCS	1**
** Available from an industrial supply company such as MSC (1-800-645-7270).				

### Assembly Drawing

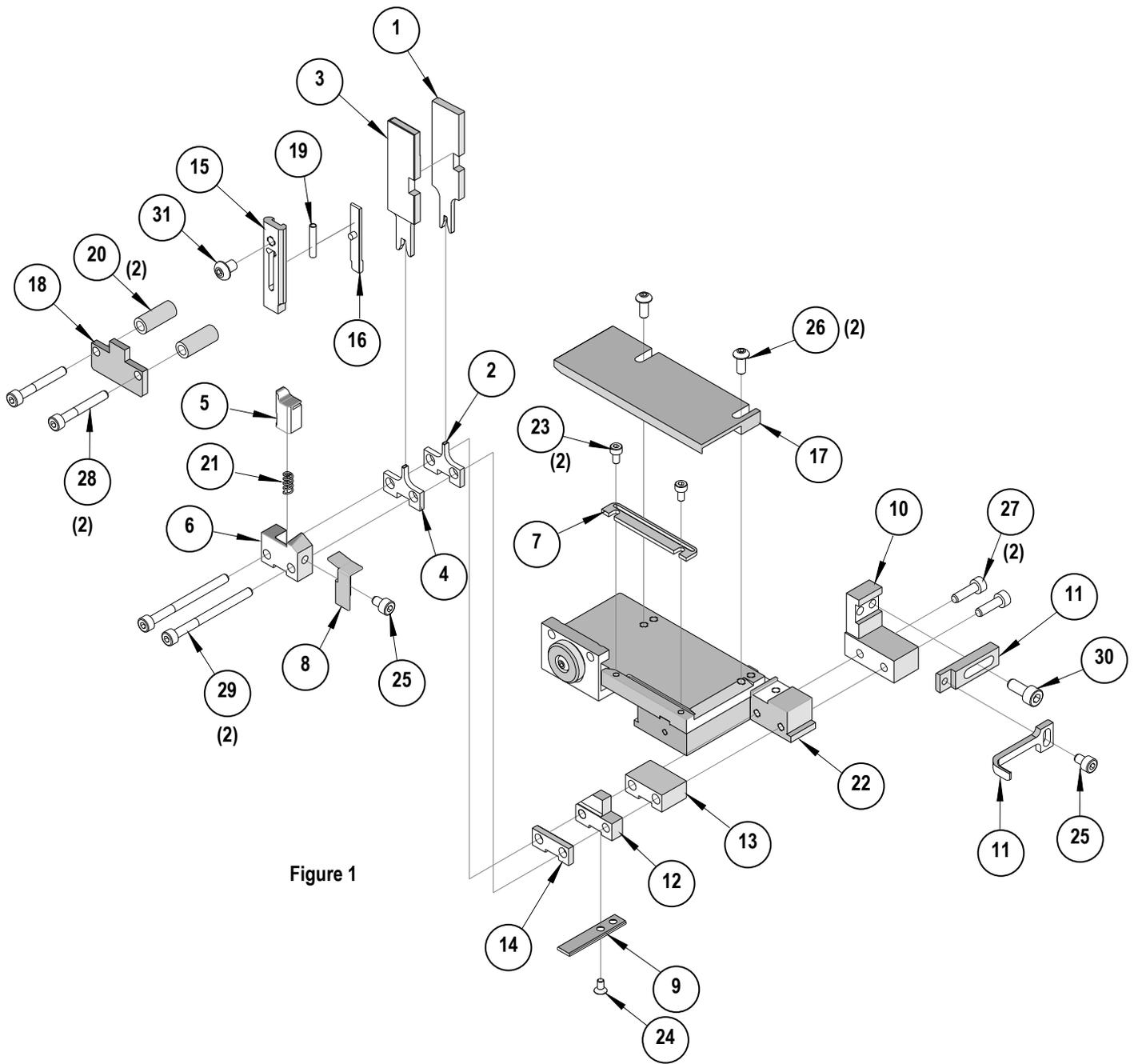


Figure 1

## 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).

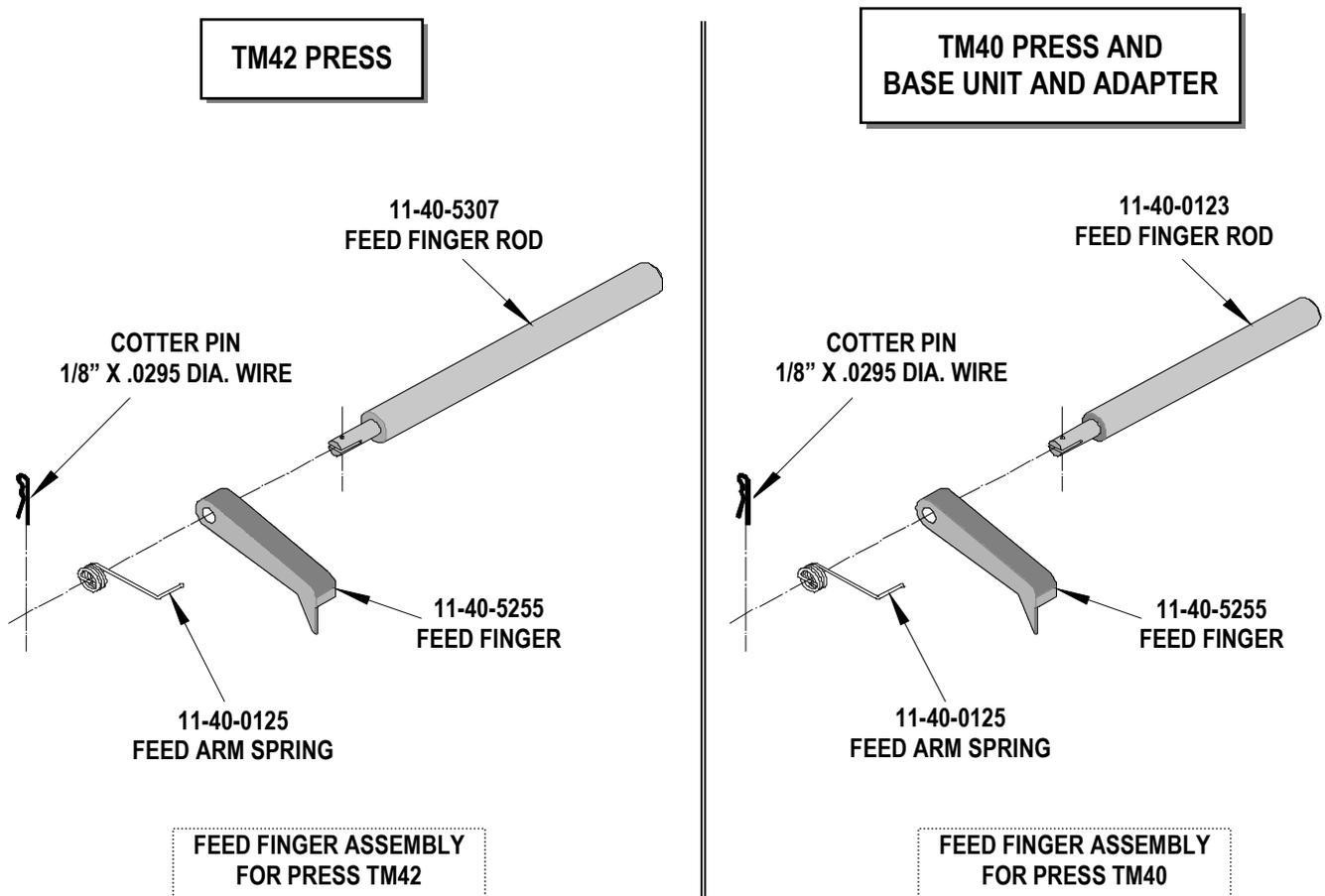


Figure 2

## 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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