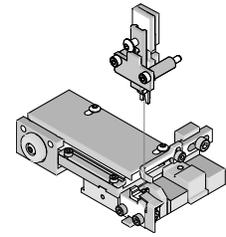




T2 Terminator Tooling

Application Tooling Specification Sheet



Order No. 63911-1500

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

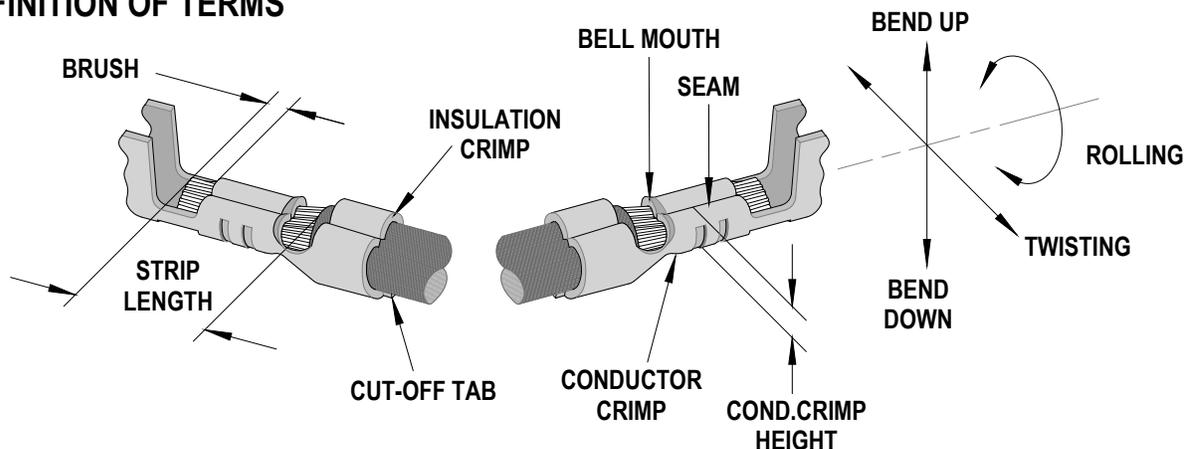
SCOPE

Products: 1.50mm (.059") Pitch CLIK-Mate™ Wire-to-Board Crimp Terminals, 24-28 AWG and 0.2 and 0.08mm.

Terminal Series No.	Terminal Order No.	Wire Size		Insulation Diameter				Strip Length	
				IPC/WHMA-A620 (1)		Terminal (2)			
		AWG	mm ²	mm	In.	mm	In.	mm	In.
502579	502579-0000	24	--	0.09 – 1.2	0.035 – 0.047	0.8 -1.2	.031 - .047	1.50-1.90	.059-.075
		26	--	0.09 – 1.2	0.035 – 0.047	0.8 -1.2	.031 - .047		
		28	--	0.09 – 1.2	0.035 – 0.047	0.8 -1.2	.031 - .047		
		--	0.20	0.09 – 1.2	0.035 – 0.047	0.8 -1.2	.031 - .047		
		--	0.08	0.09 – 1.2	0.035 – 0.047	0.8 -1.2	.031 - .047		

(1) To achieve optimum IPC-A620 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.
502579	0.10 - 0.40	.004-.016	0.10	.004	0.10 - 0.60	.004 -.024

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 (Max)		Degree (Max)		mm	In	mm	In	
502579	3	3	3	8	1.00	.039	1.10	.043	

After crimping, the conductor profile should measure the following.

Terminal Series No.	Wire Size		Conductor Crimp				♦ Pull Force Minimum	
			Crimp Height		Crimp Width (Ref.)			
	AWG	mm²	mm	In.	mm	In.	N	Lb.
502579	24	--	0.60-0.65	.024-.026	1.00	0.039	29.4	6.61
	26	--	0.59-0.64	.023-.025	1.00	0.039	19.6	4.41
	♦28	--	0.56-0.61	.022-.024	1.00	0.039	9.8	2.20
	--	0.20	0.60-0.65	.024-.026	1.00	0.039	29.4	6.61
	--	♦0.08	0.56-0.61	.022-.024	1.00	0.039	9.8	2.20

♦ **Note:** To achieve optimum pull force a conductor crimp height of 0.54-0.59mm is recommended for 28awg (0.08mm) wire. This will allow a minimum Cpk value of 1.67.
This lower crimp height range produces a mechanically sound crimp. However, electrical performance may vary..

Terminal Series No.	Wire Size		Insulation			
			Crimp Height (Maximum)		Crimp Width (Ref.)	
	AWG	mm²	mm	In.	mm	In.
502579	24	--	1.65	.065	1.10	0.043
	26	--	1.55	.061	1.10	0.043
	28	--	1.45	.057	1.10	0.043
	---	0.20	1.65	.057	1.10	0.043
	---	0.08	1.35	.053	1.10	0.043

■ 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 63911-1500				
Item	Order No	Engineering No.	Description	Quantity
Perishable Tooling				
	63911-1570	63911-1570	Tool Kit (All "Y" Items)	REF
1	63444-1007	63444-1007	Conductor Punch	1 Y
2	63445-1012	63445-1012	Conductor Anvil	1 Y
3	63446-1107	63446-1107	Insulation Punch	1 Y
4	63445-1102	63445-1102	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	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	63443-1717	63443-1717	18.70mm Height Spacer	1
14	63443-2201	63443-2201	1.0mm Coarse Spacer	1
15	63443-2216	63443-2216	16.00mm Coarse Spacer	1
16	63443-2304	63443-2304	3.20mm Fine Spacer	1
17	63443-2801	63443-2801	Front Plunger Striker	1
18	63443-2906	63443-2906	Wire Hold Down Plunger	1
19	63443-6003	63443-6003	Rear Cover	1
20	63443-7201	63443-7201	Spring Cover	1
21	63600-0021	63600-0021	Wire Hold Down Spring	1
22	63600-2972	63600-2972	Collar	2
Frame				
23	63800-8500	63800-8500	T2 Terminator	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

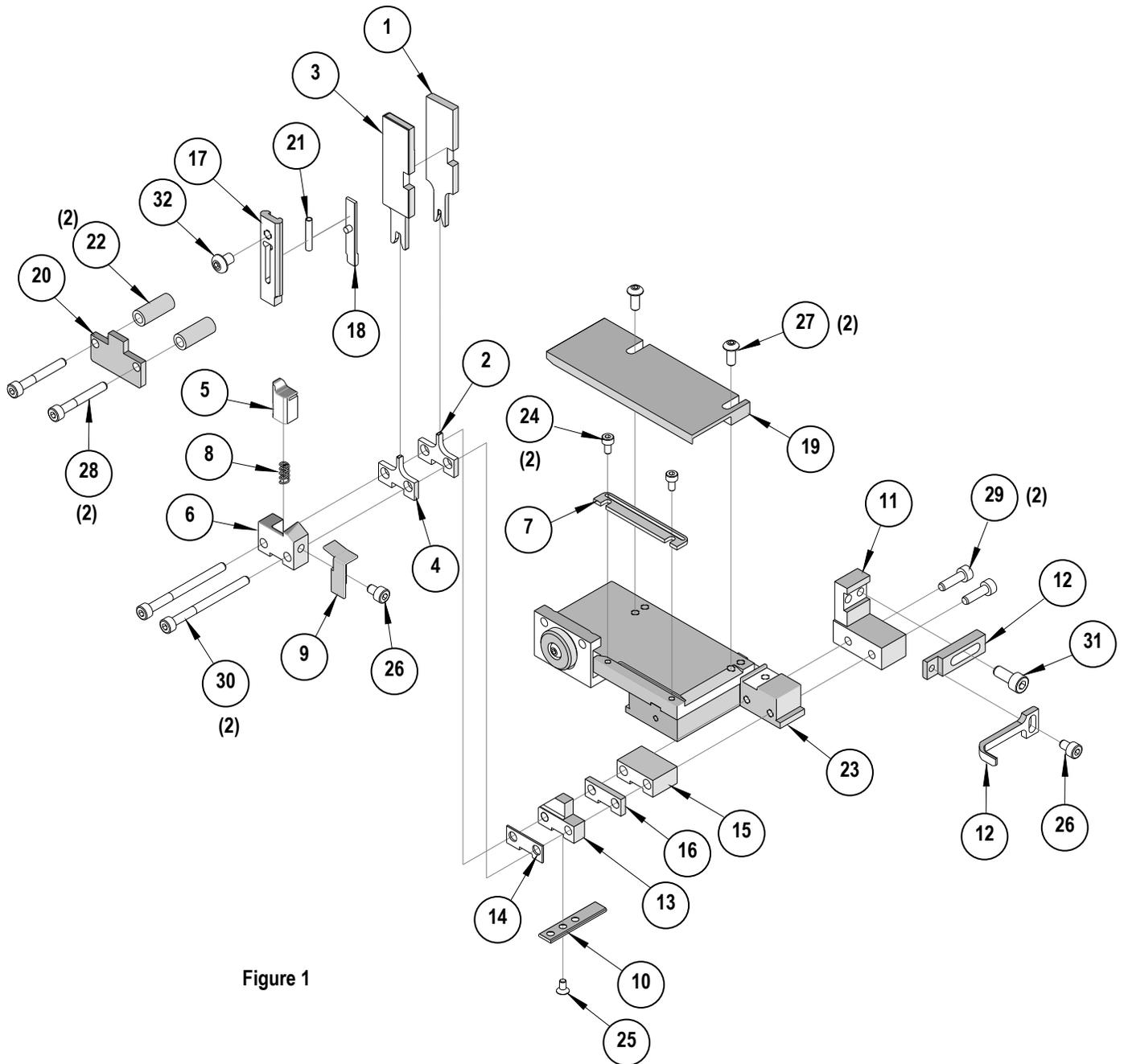


Figure 1

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).

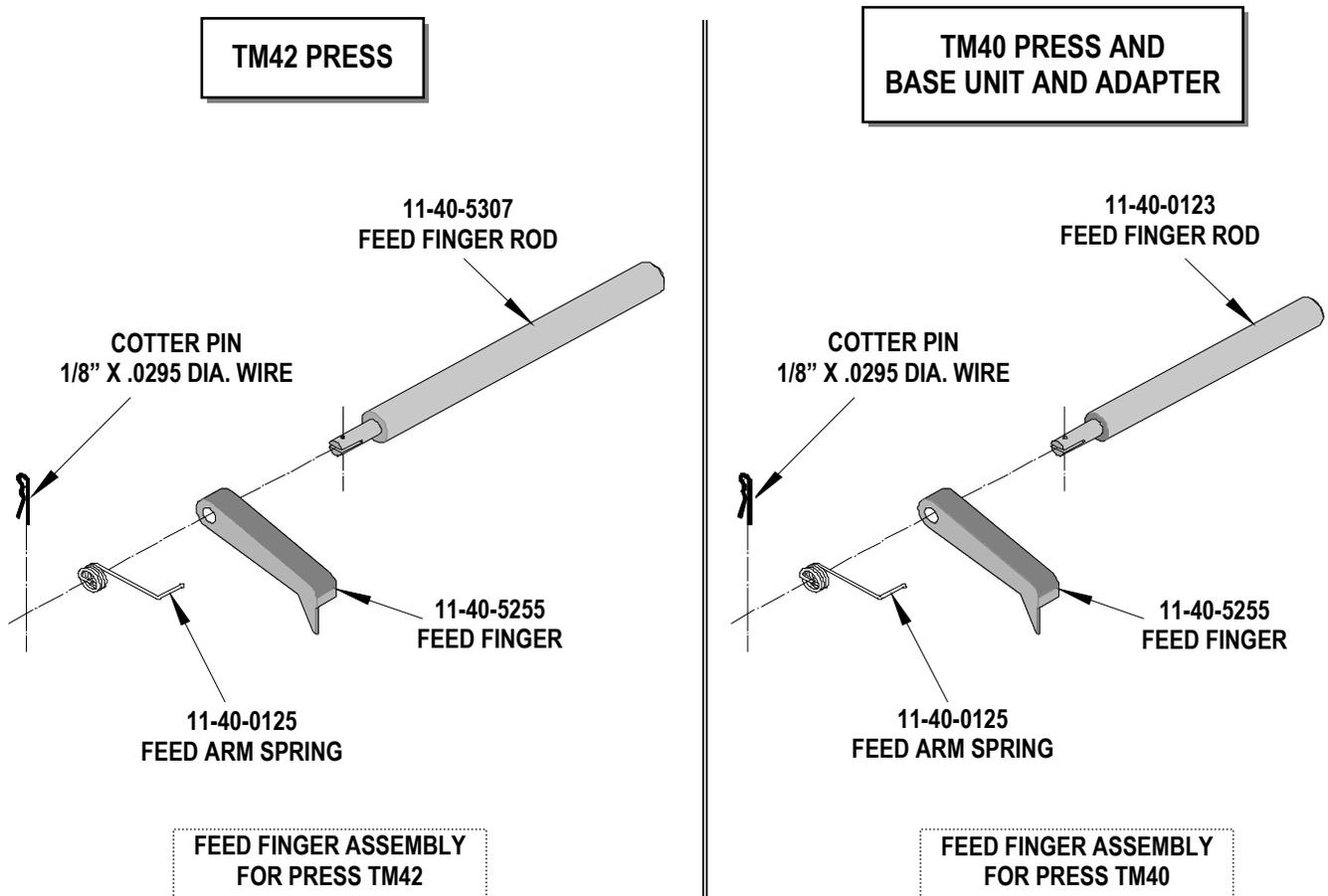


Figure 2

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.

<http://www.molex.com>