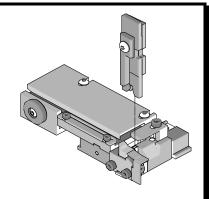


T2 Terminator Tooling Specification Sheet Part No. 63856-3100



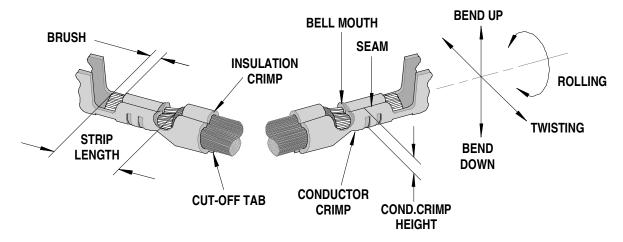
FEATURES

- 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
- T2 Terminator has standardized tooling with the Molex FineAdjust Applicator which will reduce your inventory requirements

SCOPE

Terminal	Wire Size		Insulation	Diameter	Strip Length		
Series No.	AWG	mm²	mm	ln.	mm	ln.	
42023-****	16-20	0.50-1.30	1.52-2.28	.060090	3.96-5.54	.156218	
42024-***	16-20	0.50-1.30	1.52-2.28	.060090	3.96-5.54	.156218	

DEFINITION OF TERMS



The above terminal drawing is a generic terminal representation. It is not an image of a terminal listed in the scope.

UNCONTROLLED COPY Doc No: ATS-638563100 Release Date: 09-30-04 Page 1 of 6 Revision Date: 04-16-08

Revision: B

CRIMP SPECIFICATION

Terminal	Bell	mouth	Cut-off	Tab Max.	Conductor Brush		
Series No.	mm	ln.	mm	ln.	mm	ln.	
42023-****	.2551	.010020	.13	.005	.3870	.015027	
42024-***	.2551	.010020	.13	.005	.3870	.015027	

Terminal	Bend up Bend down		Twist	Roll	Punch Width mm (Ref)			(Ref)	Coom	
Series No.	Degree		Degree		Conductor		Insulation		Seam Seam shall not be open	
Selles No.					mm	ln	mm	In	and no wire allowed out	
42023-****	3	3	4	8	2.30	.090	3.20	.126	of the crimping area	
42024-***	3	3	4	8	2.30	.090	3.20	.126	or the chimping area	

After crimping, the conductor profile should measure the following.

	Wiro	Ci-o		Dull Force Min					
Terminal Series No.	Wire Size		Hei	ght	Wie	dth	Pull Force Min.		
	AWG	mm 2	mm	In	mm	In	N	Lb.	
42023-****	16	1.30	1.45-1.55	.057061	2.31-2.51	.091099	200.2	45.0	
42023-****	18	0.80	1.27-1.37	.050054	2.28-2.48	.090098	133.4	30.0	
42023-****	20	0.50	1.14-1.24	.045049	2.24-2.44	.088096	62.3	14.0	
42024-***	16	1.30	1.45-1.55	.057061	2.31-2.51	.091099	200.2	45.0	
42024-***	18	0.80	1.27-1.37	.050054	2.28-2.48	.090098	133.4	30.0	
42024-***	20	0.50	1.14-1.24	.045049	2.24-2.44	.088096	62.3	14.0	

Pull Force should be measured with no influence from the insulation crimp.

The above specifications are guidelines to an optimum crimp.

Doc No: ATS-638563100 Releas Revision: B Revisio

Release Date: 09-30-04 Revision Date: 04-16-08

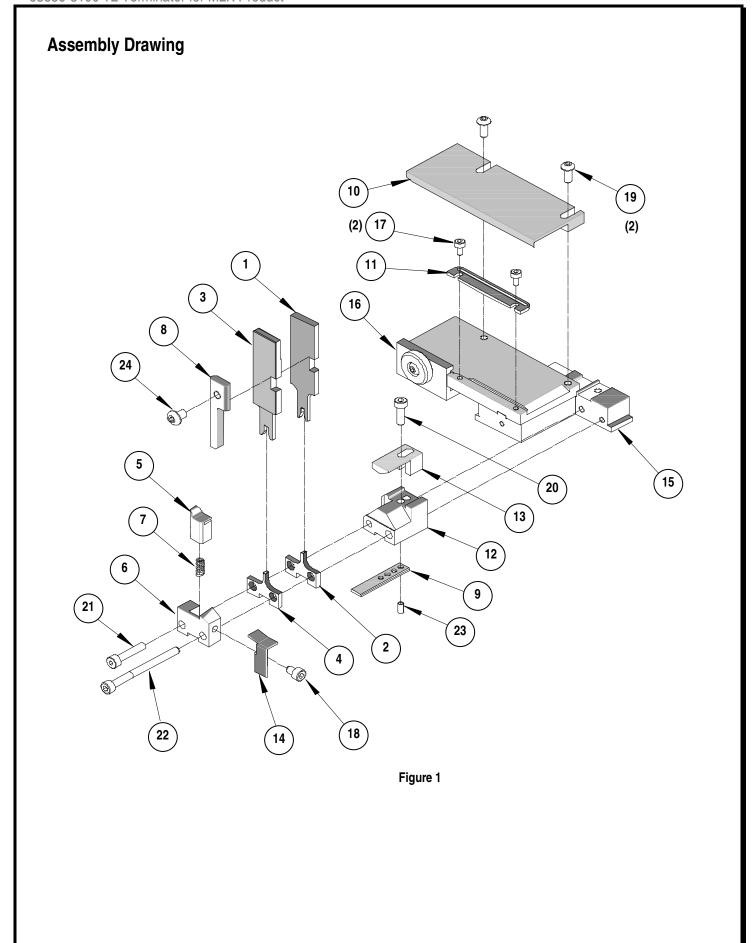
PARTS LIST

Item	Order No	Engineering No.	Description	Quantity
	63856-3100	63856-3100	T2 Terminator (Fig. 1)	REF
1	63444-2313	63444-2313	Conductor Punch	1 Y
2	63445-2343	63445-2343	Conductor Anvil	1 Y
3	63446-3212	63446-3212	Insulation Punch	1 Y
4	63445-3216	63445-3216	Insulation Anvil	1 Y
5	63443-0002	63443-0002	Cut-Off Plunger	1 Y
6	63443-0012	63443-0012	Front Plunger Retainer	1 Y
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	63443-6011	63443-6011	Rear Cover	1
11	11-18-4083	60707-8	Front Cover	1
12	63443-2415	63443-2415	Anvil Mount	1
13	63443-4006	63443-4006	Wire Stop	1
14	63443-0009	63443-0009	Scrap 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**
	63856-3170	63856-3170	Tool Kit (All Y Items)	1

Doc No: ATS-638563100 Release Date: 09-30-04 Revision: B Revision Date: 04-16-08

^{*} Frame part - To be modified.

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



Doc No: ATS-638563100 Revision: B Release Date: 09-30-04 Revision Date: 04-16-08

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).

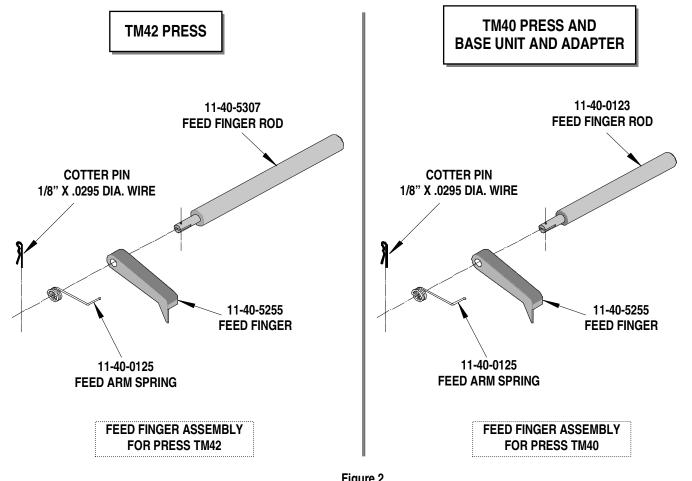


Figure 2

UNCONTROLLED COPY Doc No: ATS-638563100 Release Date: 09-30-04 Revision: B Revision Date: 04-16-08

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
- 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

Molex Application Tooling Group

1150 E. Diehl Road Naperville, IL 60563 Tel: (630) 969-4550 Fax: (630) 505-0049

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

UNCONTROLLED COPY Doc No: ATS-638563100 Release Date: 09-30-04 Page 6 of 6 Revision Date: 04-16-08

Revision: B