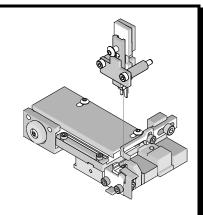


T2 Terminator Tooling Specification Sheet Order No. 63911-1400



FEATURES

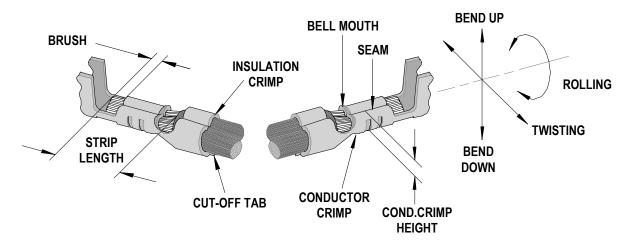
- It is ideally suited for mid-volume bench operations
- This terminator can be installed in the TM42 and the TM40 press or Base Unit adapter for 3BF press
- Quick punch removal with the push of a button for fast and easy tooling change
- Track adjustment capabilities in the T2 Terminators for improved control of the bell mouth size and cutoff tablength
- T2 Terminator has standardized tooling with the Molex FineAdjust Applicator which will reduce your inventory requirements

SCOPE

Products: 1.75mm (.069") Pitch Wire-to-Board Crimp Terminal, 24-28 AWG (0.08 and 0.20mm²).

Terminal	Terminal	Wire Size			Insulation	Strip Length			
Series No.	Order No.			IPC/WHM	A-A620+	Termin	al ++	Outp Length	
		AWG	mm²	mm	ln.	mm	ln.	mm	ln.
502057	502057-1000	24-26	0.220.12	1.00-1.27	.039050	0.85-1.27	.033050	- 1.50-1.80	.059071
			0.20	1.00-1.27	.039050	0.85-1.27	.033050		
		28	0.079	1.00-1.27	.039050	0.85-1.27	.033050		
			0.08	1.00-1.27	.039050	0.85-1.27	.033050		
◆To achieve optimum IPC-A620 Class 2 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.

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CRIMP SPECIFICATION

Terminal Series No.	Bell n	nouth	Cut-off Tab	Maximum	Conductor Brush		
reminiai Senes No.	mm	ln.	mm	ln.	mm	ln.	
502057	0.10035	.004014	0.10	.004	0.10-0.5	.004020	

	Bend up Bend down		Twist	Roll	Punch Width mm (Ref)			(Ref)	Seam	
Terminal Series No.	Degree		Degree		Conductor		Insulation			
					mm	In	mm	In	Seam shall not be open and	
502057	3	2	3	5	1.00	.039	1.20	.047	no wire allowed out of the crimping area	

After crimping, the conductor profile should measure the following.

Terminal Series No.	Wire Size			uctor Height	Insulation Crimp Height		Pull Force Minimum	
	AWG	mm ²	mm	ln.	mm	ln.	N	Lb.
	24	0.22	0.60-0.65	.024026	1.55	.061	29.4	6.6
		0.02	0.60-0.65	.024026	1.60	.063	29.4	6.6
502057	26	0.12	0.59-0.64	.023025	1.50	.059	19.6	4.4
	28	0.079	0.56-0.61	.022024	1.40	.055	9.8	2.2
		0.08	0.56-0.61	.022024	1.40	.055	9.8	2.2

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

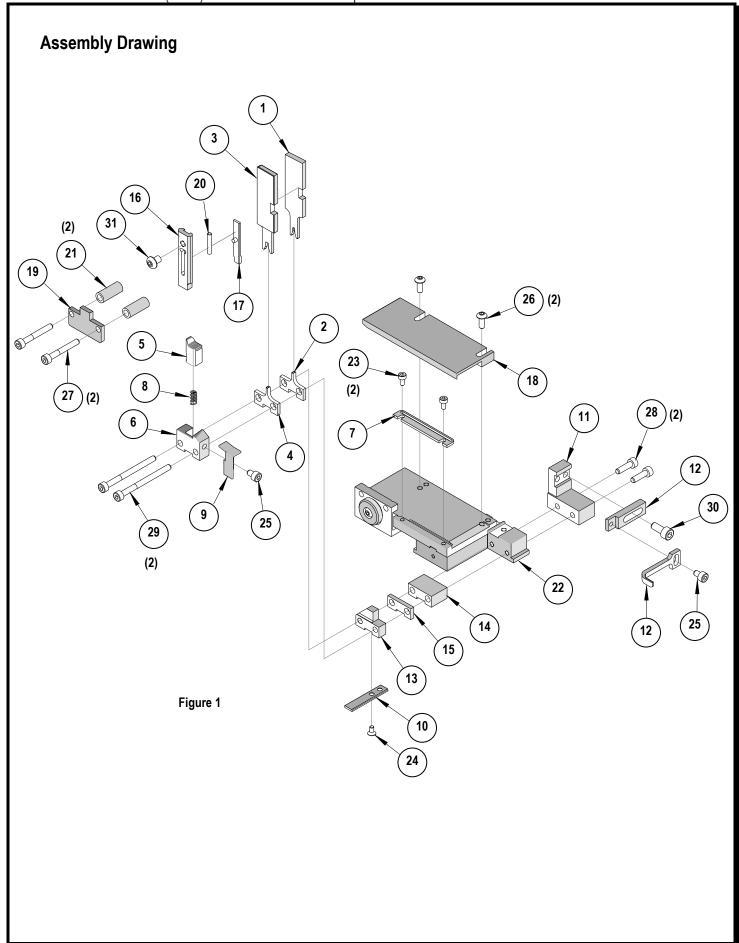
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PARTS LIST

T2 Terminator 63911-1400										
Item	Order No	Quantity								
Perishable Tooling										
	63911-1470	63911-1470	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	63446-1217	63446-1217	Insulation Punch	1 Y						
4	63445-1235	63445-1235	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 Componer	nts (REF 111450)							
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	63443-1714	63443-1714	18.40mm Height Spacer	1						
14	63443-2217	63443-2217	17.00mm Coarse Spacer	1						
15	63443-2306	63443-2306	3.30mm Fine Spacer	1						
16	63443-2801	63443-2801	Front Plunger Striker	1						
17	63443-2906	63443-2906	Wire Hold Down Plunger	1						
18	63443-6002	63443-6002	Rear Cover	1						
19	63443-7201	63443-7201	Spring Cover	1						
20	63600-0021	63600-0021	Wire Hold Down Spring	1						
21	63600-2972	63600-2972	Collar	2						
		Fra	me							
22	63800-8500	63800-8500	T2 Terminator	1						
		Hard	ware							
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**						
** Ava	** Available from an industrial supply company such as MSC (1-800-645-7270).									

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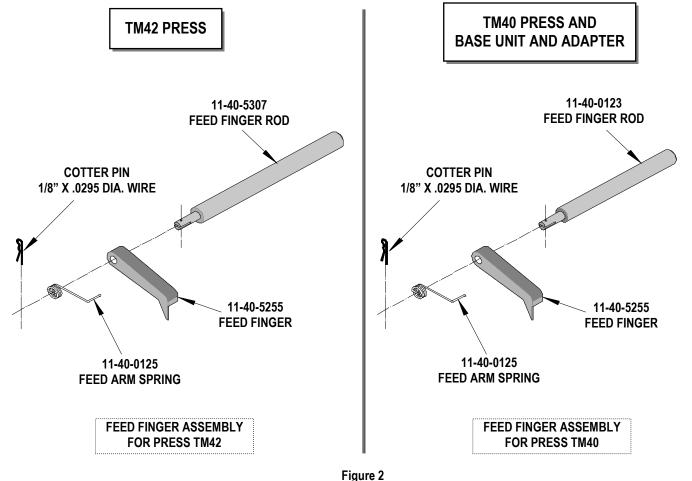


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NOTES

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).



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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.

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