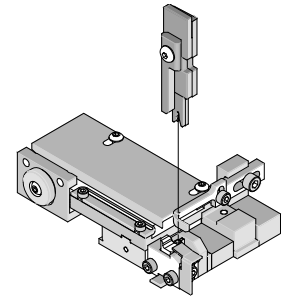




Order No. 63914-5200



Application Tooling Specification

FEATURES

- Ideally suited for mid-volume bench operations
- 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 bellmouth size and cut-off tab length
- T2 Terminator has standardized tooling with the Molex FineAdjust Applicator, which will reduce your inventory requirements

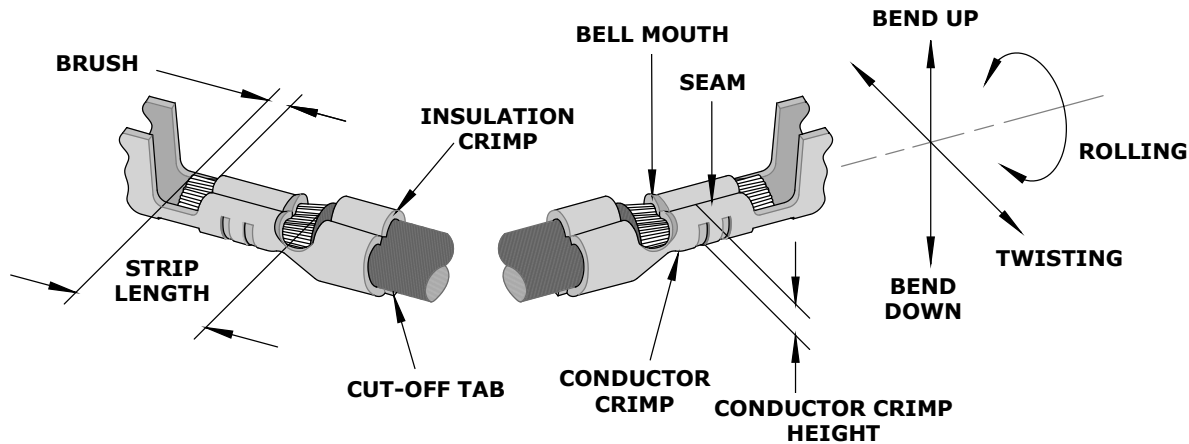
SCOPE

Products: 3.96mm (.156") Pitch SPOX Crimp Terminal, 18-24 AWG.

Terminal Series No.	Terminal Order No.		Wire Size		Insulation Diameter				Strip Length	
					Terminal (2)		IPC/WHMA-A-620 (1)			
					AWG	mm ²	mm	In.	mm	In.
5194	08-70-1031	39-00-0416	18-24	0.80-0.20	1.30-3.00	.051-.118	2.20-2.60	.087-.102	3.00-3.50	.118-.138
	39-00-0409	39-00-0021								

(1) To achieve optimum IPC/WHMA-A-620 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.	Bellmouth		Cut-Off Tab Maximum		Conductor Brush	
	mm	In.	mm	In.	mm	In.
5194	0.20-0.70	.008-.028	0.40	.016	0.00-1.00	.000-.039

Terminal Series No.	Bend Up	Bend Down	Twist	Roll	Punch Width mm (Ref)				Seam
	Degree	Degree	Degree	Degree	Conductor		Insulation		
					mm	In.	mm	In.	
5194	6	0	3	8	1.60	.063	2.80	.110	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		Conductor Crimp Height		Pull Force Minimum	
	AWG	mm ²	mm	In.	N	Lb.
	5194	18	0.80	1.10-1.20	.043-.047	88.1
20		0.50	1.07-1.17	.042-.046	58.7	13.20
22		0.35	0.96-1.06	.038-.042	39.1	8.80
24		0.20	0.90-1.00	.035-.039	29.4	6.60

Note

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

PARTS LIST

T2 Terminator 63914-5200				
Item	Order No.	Engineering No.	Description	Quantity
Perishable Tooling				
	63914-5270	63914-5270	Tool Kit (All "Y" Items)	REF
1	63444-1605	63444-1605	Conductor Punch	1 Y
2	63445-1641	63445-1641	Conductor Anvil	1 Y
3	63446-2827	63446-2827	Insulation Punch	1 Y
4	63456-2803	63456-2803	Insulation Anvil	1 Y
5	63443-0005	63443-0005	Front Cut-Off Plunger	1 Y
6	63443-0012	63443-0012	Front Plunger Retainer	1 Y
Other Components (REF 105350)				
7	11-18-4083	60707-8	Feed Guide	1
8	11-24-1067	4996-4	Cut-Off Plunger Spring	1
9	11-40-4039	8302-5	Plunger Striker	1
10	63443-0009	63443-0009	Front Scrap Chute	1
11	63443-0024	63443-0024	Key	1
12	63443-0085	63443-0085	Wire Stop L-Bracket	1
13	63443-0090	63443-0090	Wire Stop	1
14	63443-1719	63443-1719	18.90mm Height Spacer	1
15	63443-2216	63443-2216	16.00mm Coarse Spacer	1
16	63443-2302	63443-2302	3.10mm Fine Spacer	1
17	63443-6003	63443-6003	Rear Cover	1
Frame				
18	63800-8500	63800-8500	T2 Terminator	1
Hardware				
19	—	—	M3 by 6 Long SHCS	2*
20	—	—	M3 by 6 Long FHCS	1*
21	—	—	M4 by 6 Long SHCS	2*
22	—	—	M4 by 12 Long BHCS	2*
23	—	—	M4 by 14 Long SHCS	2*
24	—	—	M4 by 50 Long SHCS	2*
25	—	—	M5 by 12 Long SHCS	1*
26	—	—	#10-32 by 3/8" Long BHCS	1*
* Available from an industrial supply company.				

ASSEMBLY DRAWING

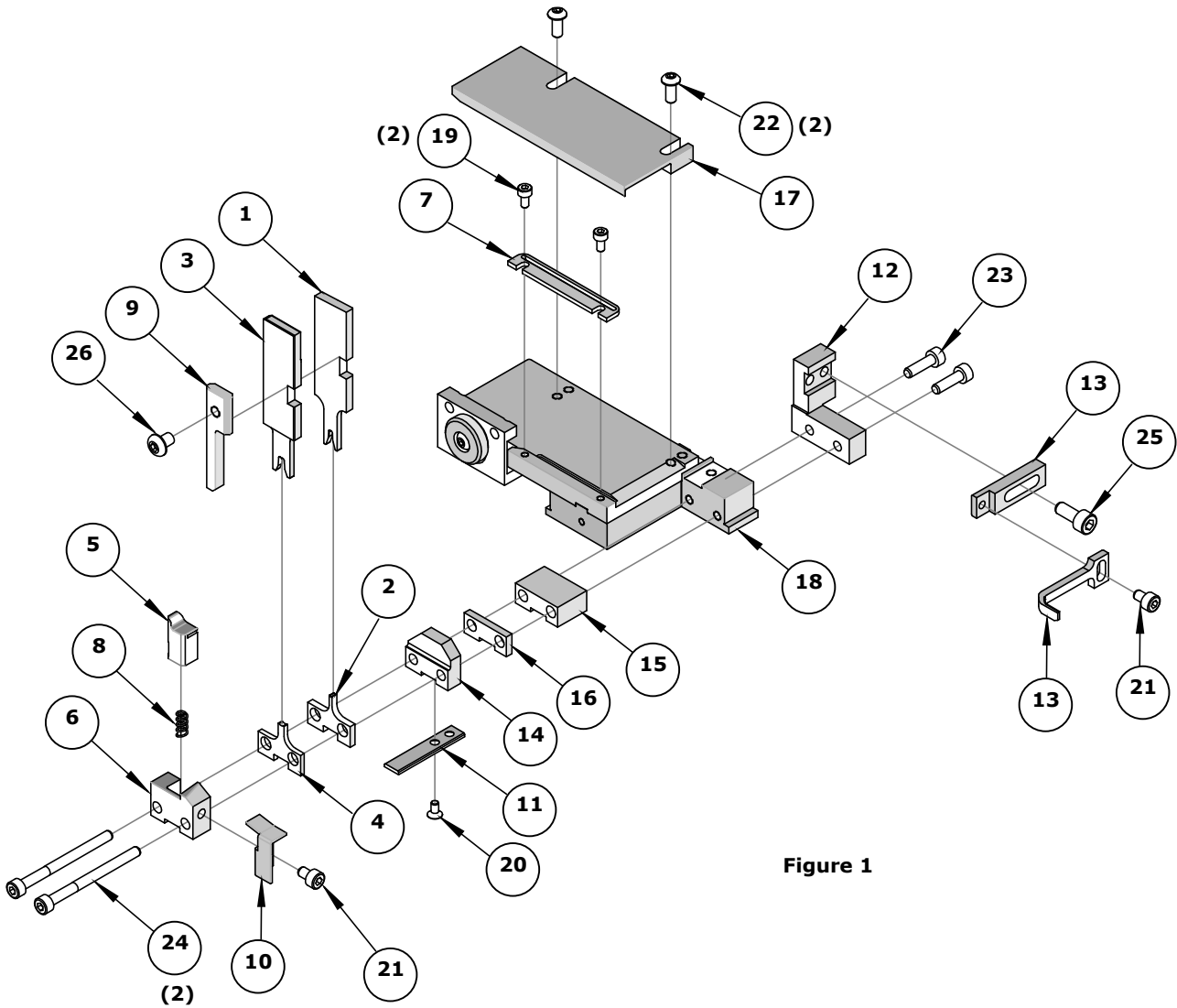


Figure 1

NOTES

Depending on the press vintage, a feed finger assembly is supplied with the T2 Terminator.

1. To remove the existing feed finger assembly, loosen the M4 x 10mm set screw in the feed lever.
2. Select the T2 Feed finger assembly from the 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).

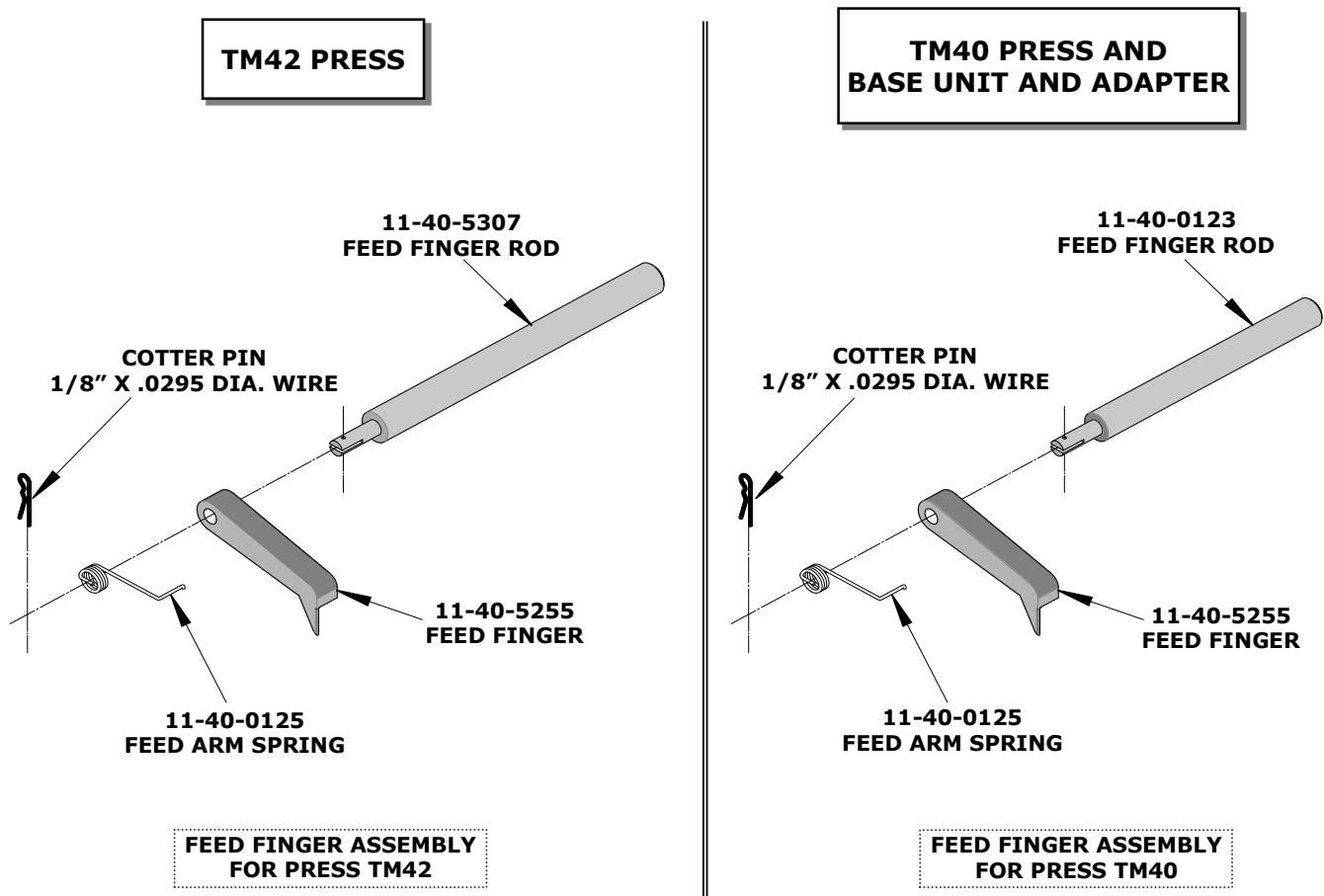


Figure 2

NOTES

1. Molex recommends that 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 the 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 or 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.

Application Tooling Support

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