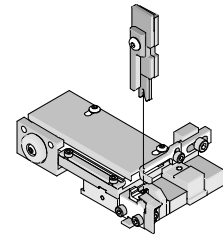




T2 Terminator Tooling

Application Tooling Specification Sheet



Order No. 63912-7900

FEATURES

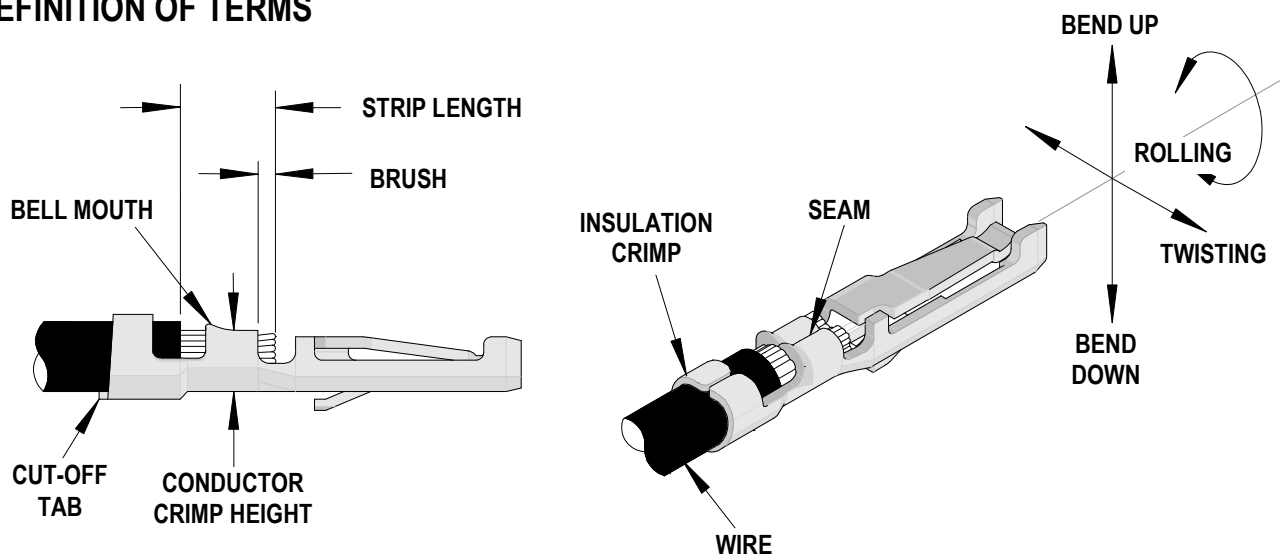
- It is ideally suited for mid-volume bench operations
- This terminator can be installed in the TM42 and the TM40 press or Base Unit adapter for 3BF press
- Quick punch removal with the push of a button for fast and easy tooling change
- Track adjustment capabilities in the T2 Terminators for improved 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

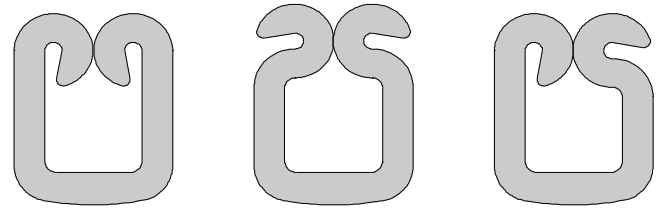
Products: 1.25mm (.049") PanelMate™, Crimp Terminal, 26-32 AWG.

Terminal Series No.	Terminal Order No.		Wire Size		Insulation Diameter		Strip Length	
			AWG	mm ²	mm	In.	mm	In.
50641	50641-8041	50641-8099	26-30	0.12-0.05	0.50-0.90	.020-.035	1.30-1.70	.051-.067
	50641-8052							
50753	50753-8041	50753-8099	30-32	0.05-0.03	0.40-0.55	.016-.022	1.30-1.70	.051-.067

DEFINITION OF TERMS



INSULATION CRIMP FORM



This crimp terminal is designed for miniaturization; therefore each dimension of insulation crimp portion appears small as compared to the terminal material thickness. In order to avoid insulation piercing the crimp forms by the insulation barrel, coining is provided inside of the insulation barrel. For this reason, various crimp forms will occur at the tip of the insulation crimp barrel shown in the figure below.

These crimp forms maybe changed completely by a small change in the wire, insulation punch or terminal.

These crimp forms are satisfactory for original function of the insulation crimp portion and it is confirmed that all of these forms below are acceptable insulation crimps.

CRIMP SPECIFICATION

Terminal Series No.	Bell mouth		Cut-off Tab Maximum		Conductor Brush	
	mm	In.	mm	In.	mm	In.
50641	0.05-0.30	.002-.012	0.15	.006	0.00-0.50	.000-.020
50753	0.50-0.30	.002-.012	0.15	.006	0.00-0.50	.000-.020

Terminal Series No.	Bend up Bend down		Twist	Roll	Punch Width mm (Ref)				Seam
	Degree				Conductor		Insulation		
	mm	In	mm	In	mm	In			
50641	3	3	4	8	0.80	.031	0.80	.031	Seam shall not be open and no wire allowed out of the crimping area
50753	3	3	4	8	0.80	.031	0.80	.031	

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.
50641	26	0.12	0.62-0.67	.024-.026	9.78	2.20
	28	0.08	0.58-0.63	.023-.025	9.78	2.20
	30	0.05	0.55-0.60	.021-.023	4.89	1.10
50753	30	0.05	0.47-0.52	.018-.020	4.89	1.10
	32	0.03	0.45-0.50	.017-.019	2.94	0.66

■ Tool Qualification Notes:

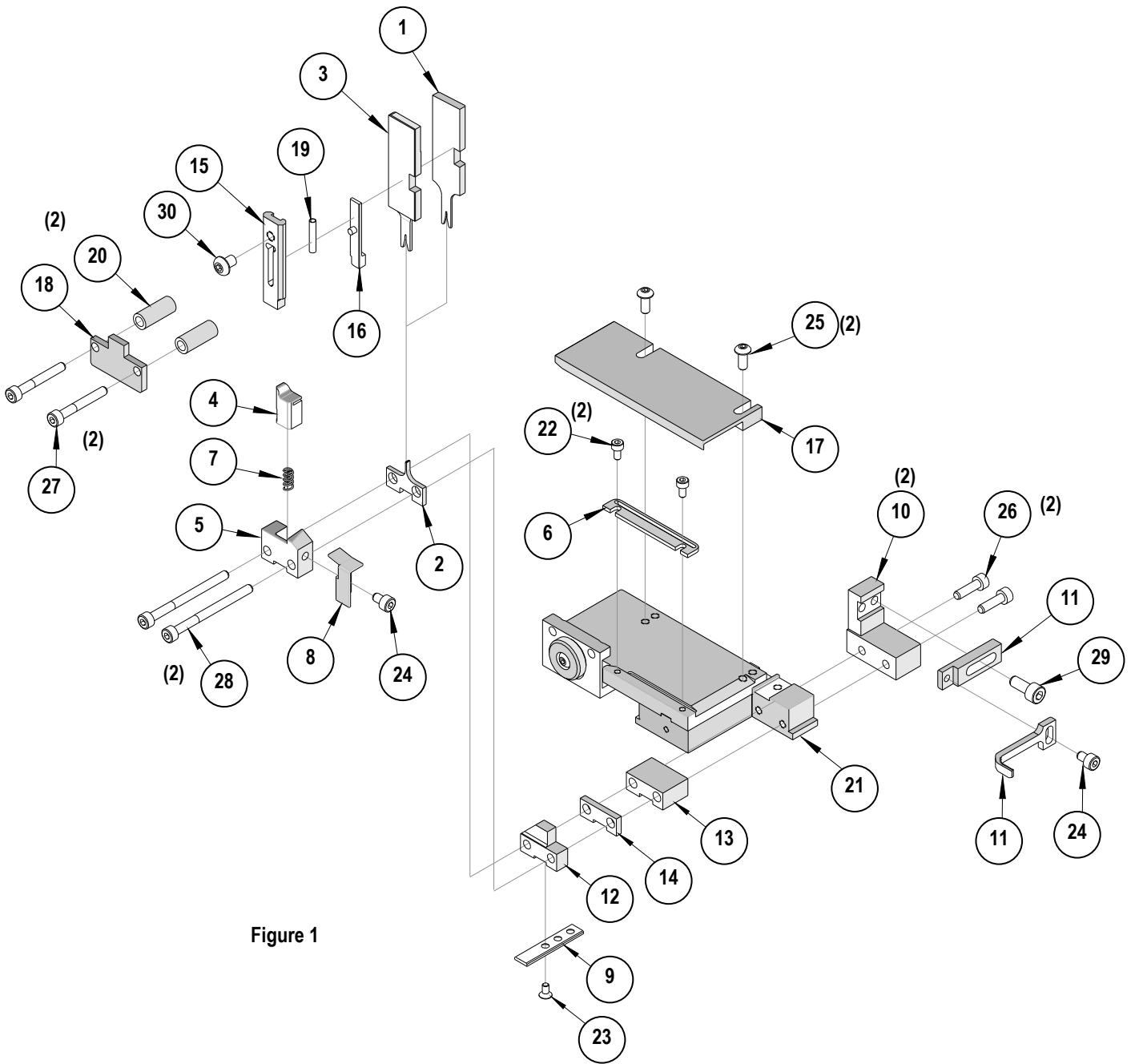
1. Pull Force should be measured with no influence from the insulation crimp.
2. The above specifications are guidelines to an optimum crimp.

PARTS LIST

T2 Terminator 63912-7900				
Item	Order No	Engineering No.	Description	Quantity
Perishable Tooling				
	63912-7970	63912-7970	Tool Kit (All "Y" Items)	REF
1	63444-0802	63444-0802	Conductor Punch	1 Y
2	63445-0821	63445-0821	Anvil	1 Y
3	63446-0808	63446-0808	Insulation Punch	1 Y
4	63443-0005	63443-0005	Cut-Off Plunger	1 Y
5	63443-0012	63443-0012	Front Plunger Retainer	1 Y
Other Components				
6	11-18-4083	60707-8	Feed Guide	1
7	11-24-1067	4996-4	Cut-Off Plunger Spring	1
8	63443-0009	63443-0009	Front Scrap Chute	1
9	63443-0024	63443-0024	Key	1
10	63443-0085	63443-0085	Wire Stop L-Bracket	1
11	63443-0090	63443-0090	Wire Stop	1
12	63443-1719	63443-1719	Height Spacer (18.90mm)	1
13	63443-2217	63443-2217	Coarse Spacer (17.00mm)	1
14	63443-2310	63443-2310	Fine Spacer (3.50mm)	1
15	63443-2806	63443-2806	Front Plunger Striker	1
16	63443-2904	63443-2904	Wire Hold Down Plunger	1
17	63443-6001	63443-6001	Rear Cover	1
18	63443-7201	63443-7201	Spring Cover	1
19	63600-0021	63600-0021	Compression Spring	1
20	63600-2972	63600-2972	Collar	2
Frame				
21	63800-8500	63800-8500	T2 Terminator	1
Hardware				
22	N/A	N/A	M3 by 6 Long SHCS	2**
23	N/A	N/A	M3 by 6 Long FHCS	1**
24	N/A	N/A	M4 by 6 Long SHCS	2**
25	N/A	N/A	M4 by 12 Long BHCS	2**
26	N/A	N/A	M4 by 14 Long SHCS	2**
27	N/A	N/A	M4 by 30 Long SHCS	2**
28	N/A	N/A	M4 by 45 Long SHCS	2**
29	N/A	N/A	M5 by 12 Long SHCS	1**
30	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



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).

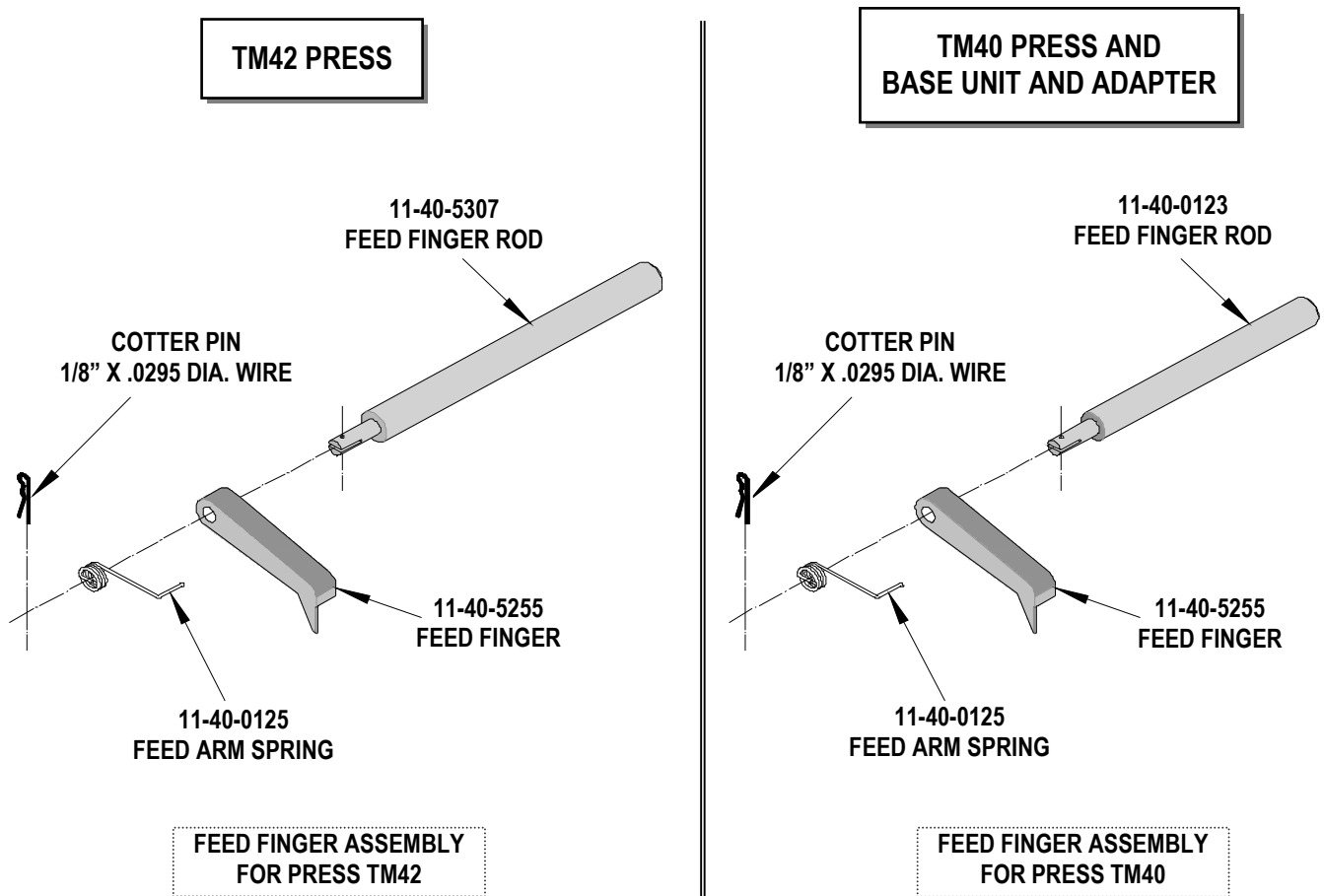


Figure 2

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.

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