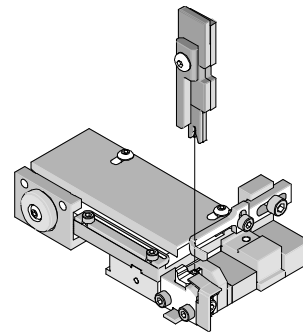




T2 Terminator Tooling Specification Sheet Order No. 63910-6600



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

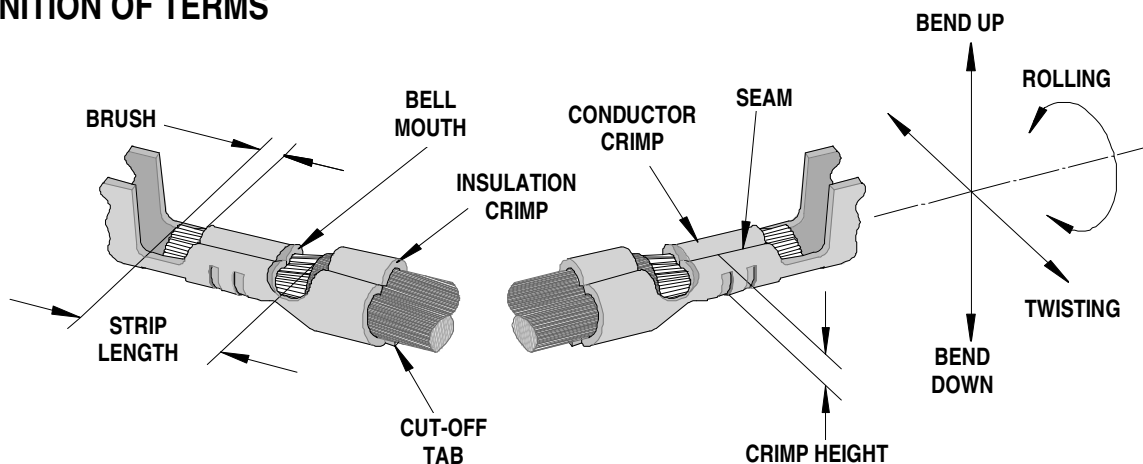
SCOPE

Products: 1.25mm (.049") Pitch Wire-to-Board Connector Dual Plug Terminal, 26-28 AWG.

Terminal Series No.	Terminal Order No.		Wire Size		◆ Insulation Diameter		Strip Length	
			AWG	mm ²	mm	In.	mm	In.
501930	501930-0100	501930-1100	26-28	.136-.079	0.80-1.00	.031-.039	1.50-1.70	.060-.067
502381	502381-0000	502381-0010	26-28	.136-.079	0.80-1.00	.031-.039	1.50-1.70	.060-.067

◆ This Applicator provides optimum A-620 Class 2 crimps with insulation O.D. range of 0.80-0.94 mm.

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.
501930	0.10-0.30	.004-.012	0.10	.004	0.10-0.40	.004-.016
502381	0.10-0.30	.004-.012	0.10	.004	0.10-0.40	.004-.016

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
	Degree				Degree		Conductor		
	mm	In	mm	In	mm	In	mm	In	
501930	3	3	4	6	0.80	.031	0.80	.031	
502381	3	3	4	6	0.80	.031	0.80	.031	

After crimping, the conductor profile should measure the following.

Terminal Series No.	Wire Size		Conductor			
			Crimp Height		Crimp Width (Ref)	
	AWG	mm ²	mm	In.	mm	In.
501930	26	.136	0.56-0.61	.022-.024		
	28	.079	0.53-0.58	.021-.023		
502381	26	.136	0.56-0.61	.022-.024		
	28	.079	0.53-0.58	.021-.023		

Terminal Series No.	Wire Size		Insulation (Ref)				Pull Force Minimum	
			Crimp Height		Crimp Width			
	AWG	mm ²	mm	In.	mm	In.	N	Lb.
501930	26	.136	1.18-1.28	.046-.050			9.8	2.20
	28	.079	1.15-1.25	.045-.049			9.8	2.20
502381	26	.136	1.18-1.28	.046-.050			9.8	2.20
	28	.079	1.15-1.25	.045-.049			9.8	2.20

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 63910-6600				
Item	Order No	Engineering No.	Description	Quantity
Perishable Tooling				
	63910-6670	63910-6670	Tool Kit (All "Y" Items)	REF
1	63444-0804	63444-0804	Conductor Punch	1 Y
2	63445-0821	63445-0821	Anvil	1 Y
3	63446-0808	63446-0808	Insulation Punch	1 Y
4	63443-0002	63443-0002	Front Cut-Off Plunger	1 Y
5	63443-0012	63443-0012	Front Plunger Retainer	1 Y
Other Components (REF 106650)				
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	63443-0025	63443-0025	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	18.90mm Height Spacer	1
13	63443-2201	63443-2201	1.00mm Fine Spacer	1
14	63443-2216	63443-2216	16.00mm Coarse Spacer	1
15	63443-2310	63443-2310	3.50mm Fine Spacer	1
16	63443-2802	63443-2802	Front Plunger Striker	1
17	63443-2904	63443-2904	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
Frame				
22	63800-8500	63800-8500	T2 Terminator	1
Hardware				
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 Flat Point SSS	1**
32	N/A	N/A	#10-32 Hex Jam Nut	1**
** Available from an industrial supply company such as MSC (1-800-645-7270).				

Assembly Drawing

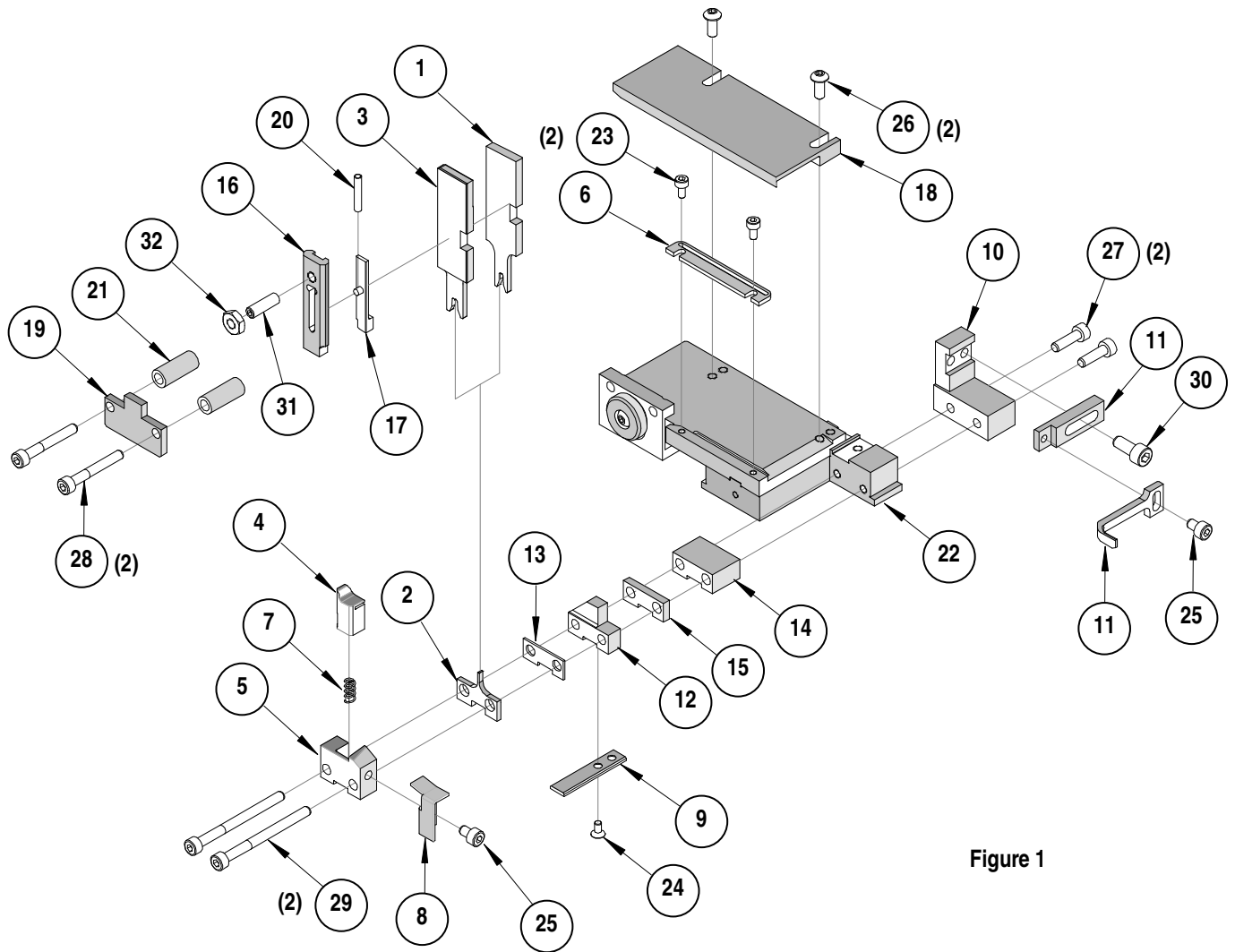


Figure 1

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).

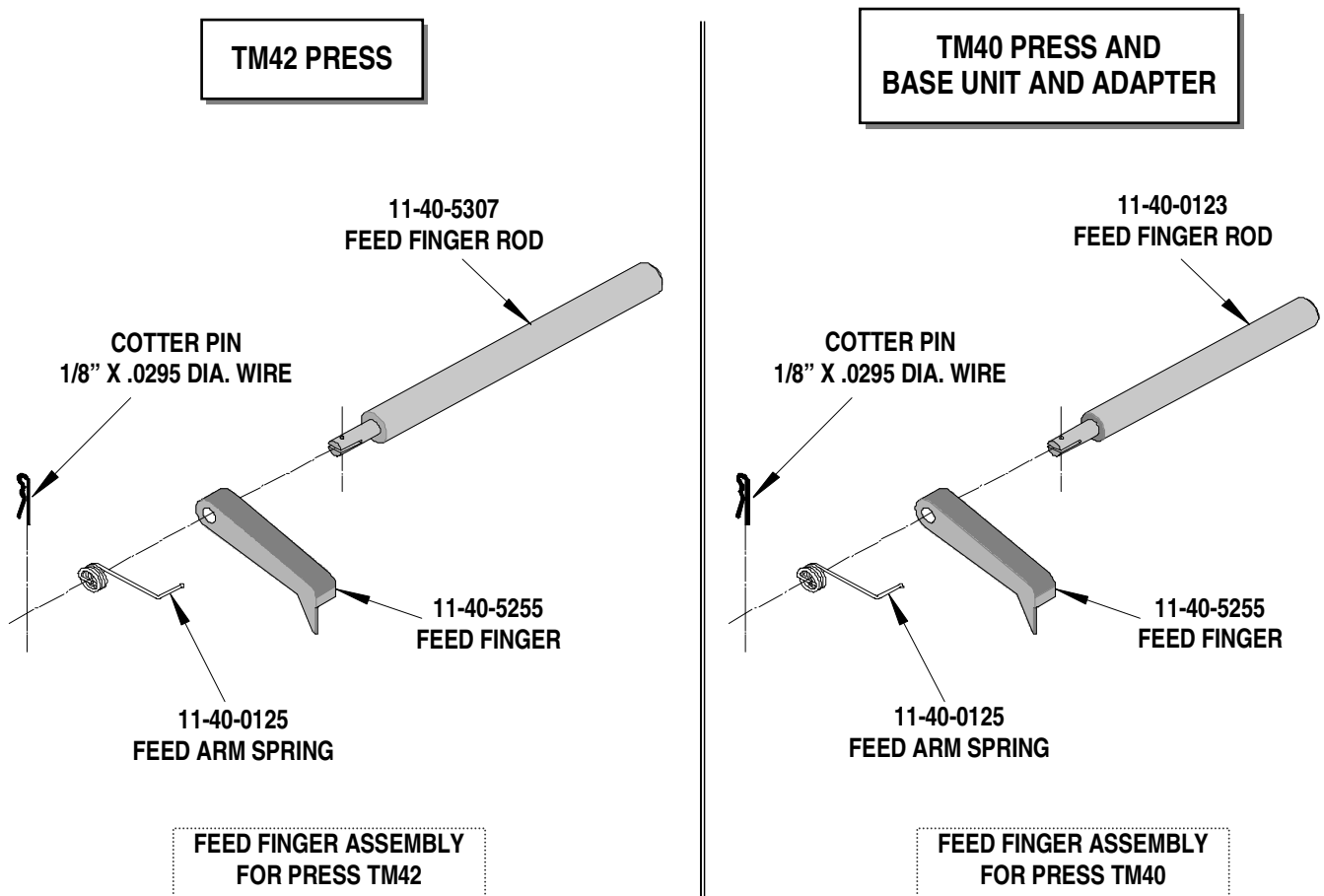


Figure 2

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 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.

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