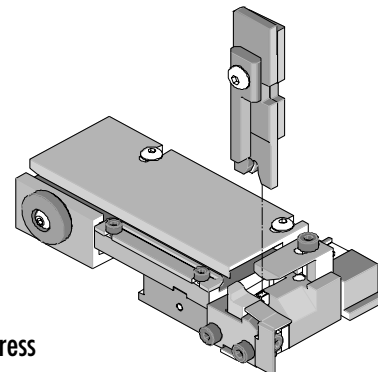




T2 Terminator Tooling Application Tooling Specification Sheet Order No. 63858-4000



FEATURES

- This terminator can be installed in the TM42 and the TM40 press or Base Unit adapter for 3BF press
- It is ideally suited for mid-volume bench operations
- 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

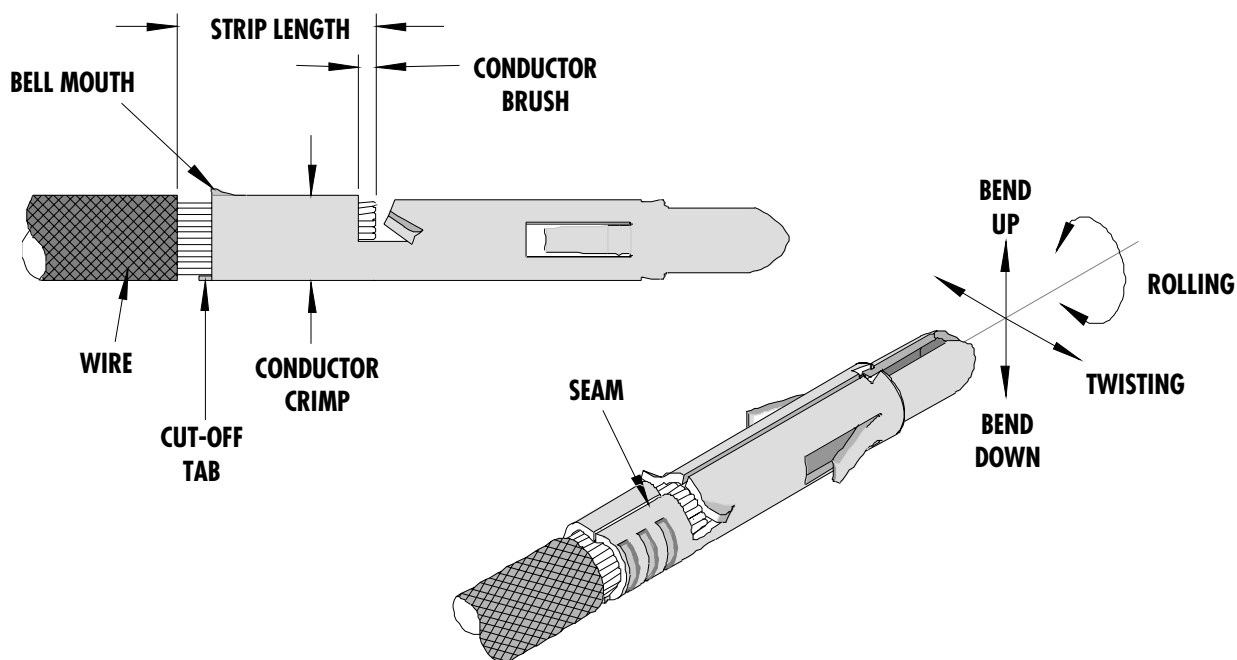
SCOPE

Products: MLX Double Crimp Terminals, 10-12 AWG.

The following is a partial list of the product part numbers and their specifications that this tool is designed to run. We will be adding to this list and an up to date copy is available on www.molex.com.

Terminal Series No.	Terminal Order No.	Wire Size		Insulation Diameter		Strip Length	
		AWG	mm ²	mm	In.	mm	In.
36663	36663-0001	10-12	5.00-3.30	5.08	.200	6.40-7.14	.252-.281
36664	36664-0001	10-12	5.00-3.30	5.08	.200	6.40-7.14	.252-.281

DEFINITION OF TERMS



CRIMP SPECIFICATIONS

Terminal Series No.	Bell mouth		Cut-off Tab Max.		Conductor Brush	
	mm	In.	mm	In.	mm	In.
36663	0.30-0.60	.012-.024	0.50	.020	0.30-0.80	.012-.031
36664	0.30-0.60	.012-.024	0.50	.020	0.30-0.80	.012-.031

Terminal Series No.	Bend up	Bend down	Twist	Roll	Punch Width (Ref)				Seam Seam to be closed, and no wire allowed out of the crimping area.
	Degree	Degree	mm	In	Conductor		Insulation		
					mm	In	mm	In	
36663	3	3	3	5	3.45	.136	N/A	N/A	
36664	3	3	3	5	3.45	.136	N/A	N/A	

CONDITIONS:

After crimping, the conductor profiles should measure the following (See notes on page 6).

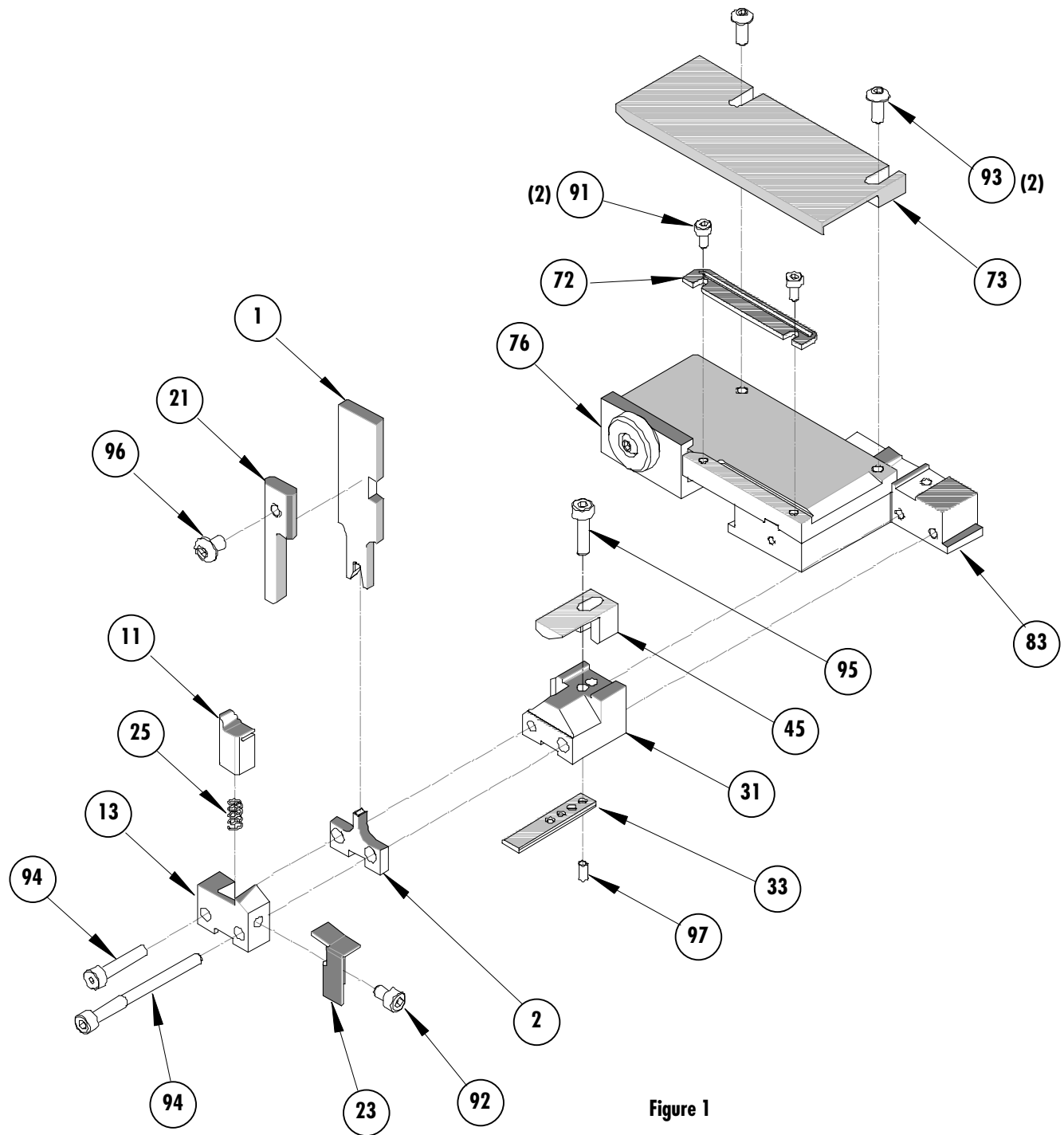
Terminal Series No.	Wire Size		Crimp Height				Crimp Width				Pull Force Min.	
	Conductor		Insulation		Conductor		Insulation		Pull Force Min.		N	Lb.
	AWG	mm ²	mm	In.	mm	In.	mm	In.	mm	In.		
36663	10	5.0	2.35-2.45	.093-.095	N/A	N/A	3.50-3.60	.138-.142	N/A	N/A	355.9	80.0
36663	12	3.3	1.90-2.00	.075-.078	N/A	N/A	3.50-3.60	.138-.142	N/A	N/A	311.4	70.0
36664	10	5.0	2.35-2.45	.093-.095	N/A	N/A	3.50-3.60	.138-.142	N/A	N/A	355.9	80.0
36664	12	3.3	1.90-2.00	.075-.078	N/A	N/A	3.50-3.60	.138-.142	N/A	N/A	311.4	70.0

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

PARTS LIST

T-2 Terminator 63858-4000				
Item	Order No	Engineering No.	Description	Quantity
Perishable Tooling				
	63858-4070	63858-4070	Tool Kit (All "Y" Items)	REF
1	63841-6173	63841-6173	Conductor Punch	1 Y
2	63801-5972	63801-5972	Conductor Anvil	1 Y
11	63443-0037	63443-0037	Front Cut-Off Plunger	1 Y
13	63443-0038	63443-0038	Front Cut-off Plunger Retainer	1 Y
Other Components				
21	11-40-4039	8302-5	Front Plunger Striker	1
23	63443-0009	63443-0009	Front Scrape Chute	1
25	63700-0539	63700-0539	Cut-Off Plunger Spring	1
31	63443-2503	63443-2503	Spacer (Anvil Mount)	1
33	63443-0021	63443-0021	Lower Tooling Key	1
45	63443-4006	63443-4006	Wire Stop	1
72	11-18-4083	60707-8	Front Cover	1
73	63443-6130	63443-6130	Rear Cover	1
Frame				
83	63800-8500	63800-8500	T2 Terminator	1
Hardware				
91	N/A	N/A	M3 by 6Lg. SHCS	2**
92	N/A	N/A	M4 by 6Lg. SHCS	1**
93	N/A	N/A	M4 by 10Lg. BHCS	2**
94	N/A	N/A	M4 by 50Lg. SHCS	2**
95	N/A	N/A	M4 by 16Lg. SHCS	1**
96	N/A	N/A	#10-32 by 1/4"Lg. BHCS	1**
97	N/A	N/A	3MM by 6Lg. Roll Pin	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).

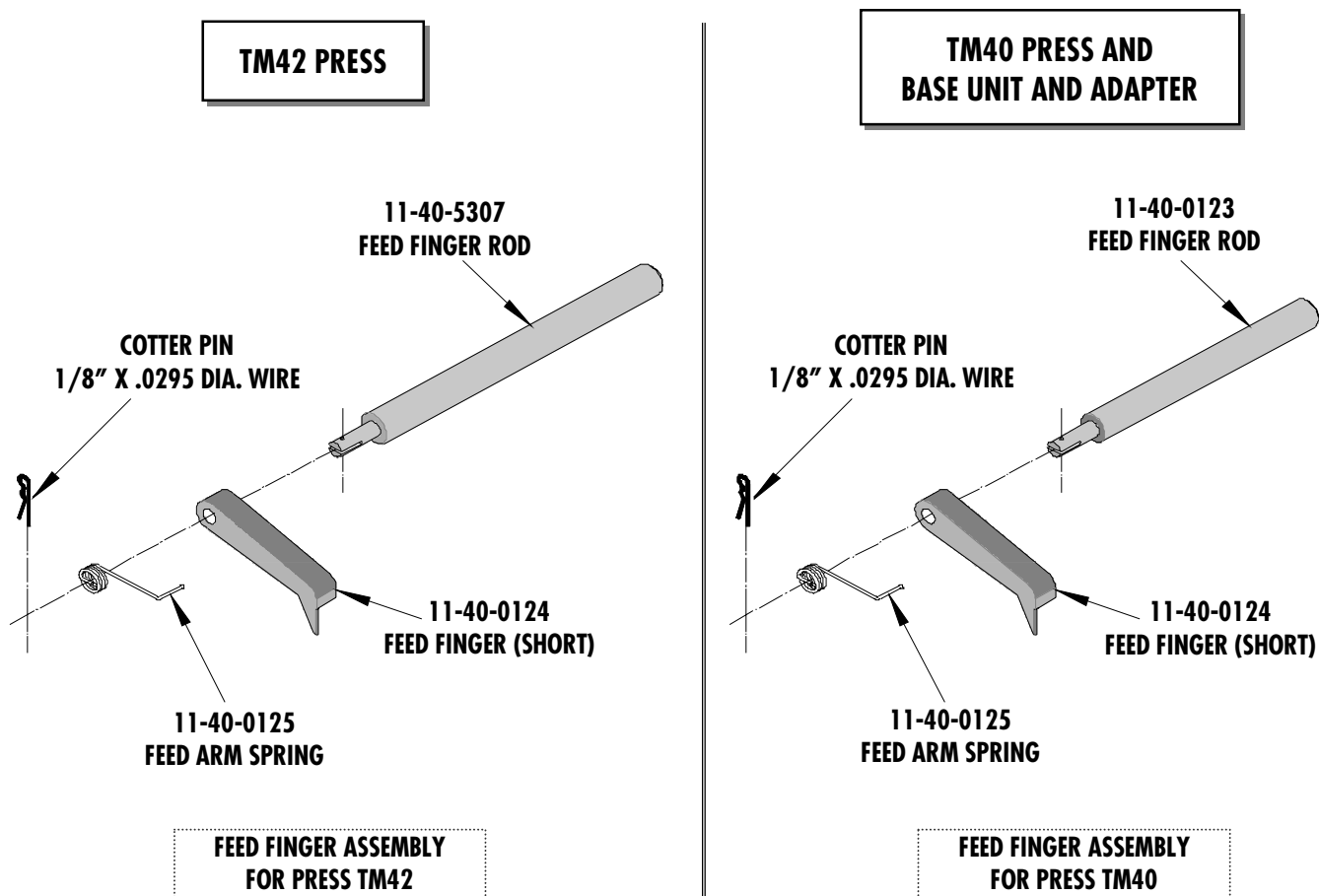


Figure 2

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.

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