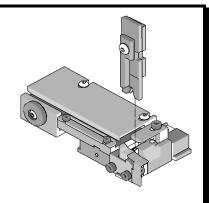


T2 Terminator Tooling Specification Sheet Part No. 63857-1000



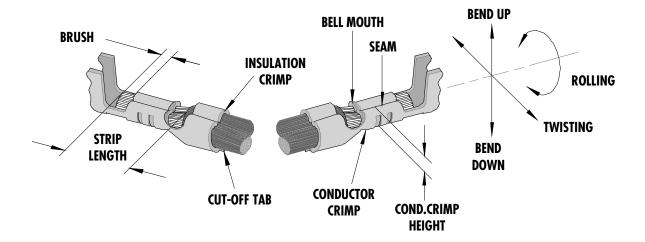
FEATURES

- 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

| Terminal | Wi | re Size | Insulation | Diameter | Strip Length | | |
|------------|-------|-----------|------------|-----------|--------------|---------|--|
| Series No. | AWG | mm² | mm | ln. | mm | ln. | |
| 94539-1000 | 20-24 | 0.50-0.25 | 2.20 Max. | .087 Max. | 4.10-4.60 | .161181 | |

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 | Bell n | nouth | Cut-off 1 | ab Max. | Conductor Brush | | |
|------------|--------|---------|-----------|---------|-----------------|---------|--|
| Series No. | mm | ln. | mm | In. | mm | In. | |
| 94539-1000 | .2030 | .008012 | .30 | .012 | .50 – 1.00 | .020040 | |

| Terminal | Bend up | Bend down | Twist | Roll | Punch Width mm (Ref) | | | | Seam | |
|-------------|---------|-----------|--------|------|----------------------|------|------------|------|----------------------------|--|
| Series No. | Degree | | Degree | | Conductor | | Insulation | | Seam shall not be open | |
| Jeiles III. | , D | eyree | De | gree | mm | In | mm | In | and no wire allowed out of | |
| 94539-1000 | 3 | 3 | 4 | 8 | 1.42 | .056 | 2.40 | .094 | the crimping area | |

After crimping, the conductor profile should measure the following.

| Terminal | | | Conductor | | | | Insulation | | | | Pull Force Min. | |
|-------------|-----|------|--------------|---------|-------------------|-----------|--------------|---------|-------------------|-----------|------------------|-------|
| Series No. | | | Crimp Height | | Crimp Width (Ref) | | Crimp Height | | Crimp Width (Ref) | | ruii rorce miii. | |
| Series ivo. | AWG | mm² | mm | ln. | mm | ln. | mm | ln. | mm | ln. | N | Lb. |
| 94539-1000 | 20 | 0.50 | 0.91-1.01 | .036040 | 1.50 Max. | .059 Max. | 1.70-1.80 | .067071 | 2.45 Max. | .096 Max. | 58.8 | 13.22 |
| 94539-1000 | 22 | 0.35 | 0.90-0.98 | .035039 | 1.50 Max. | .059 Max. | 1.55-1.65 | .061065 | 2.45 Max. | .096 Max. | 39.2 | 8.81 |
| 94539-1000 | 24 | 0.25 | 0.88-0.96 | .035038 | 1.50 Max. | .059 Max. | 1.50-1.60 | .059063 | 2.45 Max. | .096 Max. | 29.4 | 6.61 |

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

| Item | Order No | Engineering No. | Description | Quantity |
|------|------------|--------------------------------------|------------------------|----------|
| | 63857-1000 | 63857-1000 | T2 Terminator (Fig. 1) | REF |
| 1 | 63457-0024 | 63457-0024 | Conductor Punch | 1 Y |
| 2 | 63455-0026 | 63455-0026 | Conductor Anvil | 1 Y |
| 3 | 63454-0036 | 63454-0036 | Insulation Punch | 1 Y |
| 4 | 63456-0032 | 63456-0032 | Insulation Anvil | 1 Y |
| 5 | 63443-0002 | 63443-0002 | Cut-Off Plunger | 1 Y |
| 6 | 63443-0012 | 63443-0012 | Front Plunger Retainer | 1 Y |
| 7 | 11-24-1067 | 4996-4 | Cut-Off Plunger Spring | 1 |
| 8 | 11-40-4039 | 8302-5 | Front Plunger Striker | 1 |
| 9 | 63443-0021 | 63443-0021 | Lower Tooling Key | 1 |
| 10 | 63443-6005 | 63443-6005 | Rear Cover | 1 |
| 11 | 11-18-4083 | 60707-8 | Front Cover | 1 |
| 12 | 63443-2515 | 63443-2515 | Anvil Mount | 1 |
| 13 | 63443-4025 | 63443-4025 | Wire Stop | 1 |
| 14 | 63443-0009 | 63443-0009 | Scrap Chute | 1 |
| 15 | 63800-8500 | 63800-8500 | T2 Terminator | 1 |
| 16 | N/A | N/A | M3 by 6Lg. SHCS | 2** |
| 17 | N/A | N/A | M4 by 6Lg. SHCS |]** |
| 18 | N/A | N/A | M4 by 12Lg. BHCS | 2** |
| 19 | N/A | N/A | M4 by 16Lg. SHCS |]** |
| 20 | N/A | N/A | M4 by 50Lg. SHCS | 2** |
| 21 | N/A | N/A | 3MM by 6Lg. Roll Pin |]** |
| 22 | N/A | N/A | #10-32 by 3/8"Lg. BHCS |]** |
| | 63857-1070 | 70 63857-1070 Tool Kit (All Y Items) | | REF |

^{**} The following purchased parts are available from an Industrial supply company such as MSC (1-800-645-7270).

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Assembly Drawing

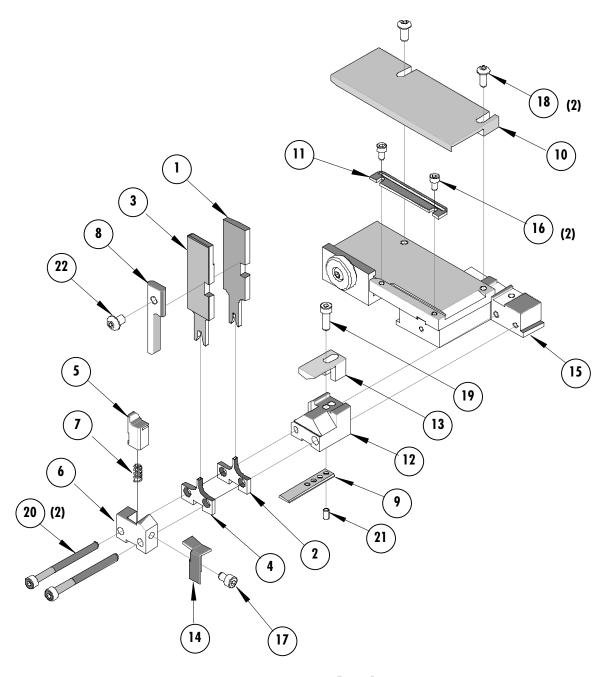


Figure 1

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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 \times 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).

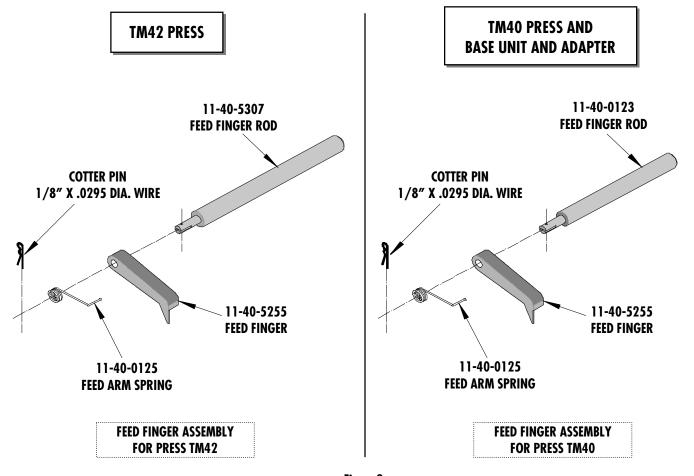


Figure 2

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NOTES

- Molex recommends an extra perishable tooling kit be maintained at your facility.
- Verify tooling alignment by manually cycling the press before crimping under power. Check that all screws are tight.
- Slugs, Terminals, Dirt and Oil should be kept clear of work area.
- 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.

Molex Application Tooling Group

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

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