



T2 Terminator Tooling Specification Sheet Part No. 63855-2000



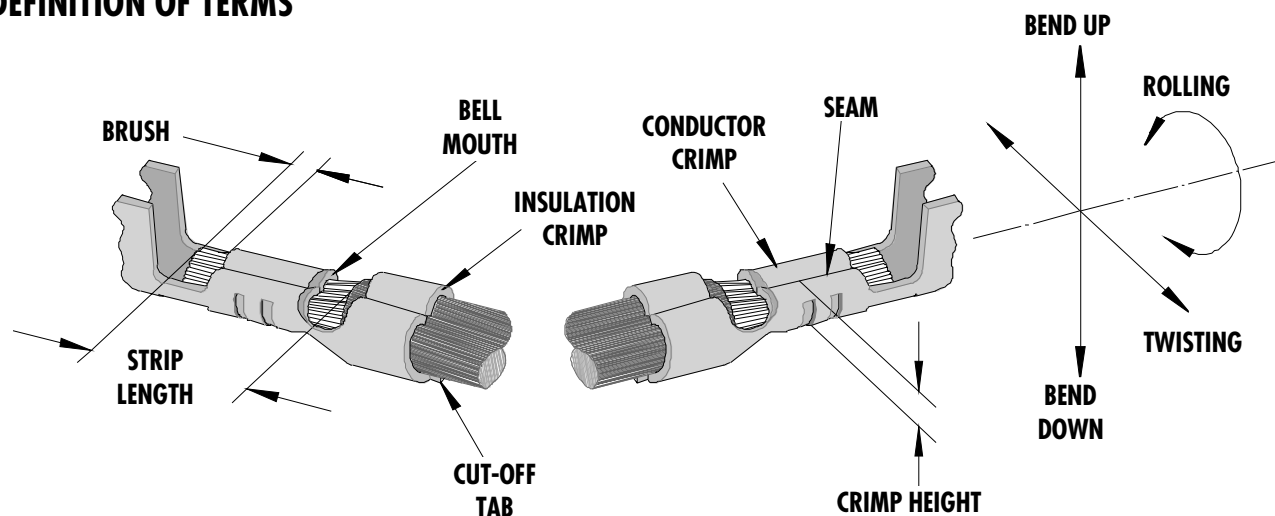
FEATURES

- 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

Terminal Series No.	Wire Size		Insulation Diameter		Strip Length	
	AWG	mm ²	mm	In.	mm	In.
90198-0002	22 - 26	0.35-0.12	1.52 Max	.060 Max	2.00-2.50	.079-.098
Terminal will accommodate the following wire specification: 22 AWG-Solid Wire or Fused Wire 24-26 AWG Solid Wire, Fused Wire or Stranded Wire						

DEFINITION OF TERMS



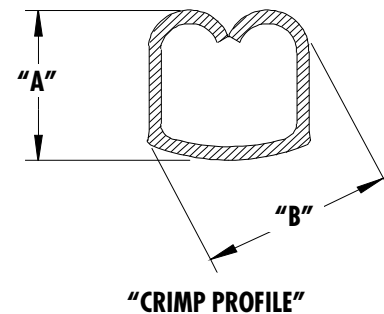
The above terminal drawing is a generic terminal representation. It is not an image of a terminal listed in the scope.

CRIMP SPECIFICATION

Terminal Series No.	Bell mouth		Cut-off Tab Max.		Conductor Brush	
	mm	In.	mm	In.	mm	In.
90198-0002	None	None	0.30	.012	0.00-0.10	.000-.004

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		Insulation		
					mm	In	mm	In	
90198-0002	N/A	N/A	N/A	N/A	1.00	.039	1.80	.070	

After crimping, the conductor profile should measure the following.



Terminal Series No.	Wire Size		"A" Crimp Height		"B" Diagonal Dim.		Pull Force Min.	
	AWG	mm ²	mm	In	mm	In.	N	Lb.
90198-0002	22	0.35	0.89 Ref	.035 Ref	1.19 Max	.047 Max	35.6	8.0
90198-0002	24	0.20	0.79 Ref	.031 Ref	1.14 Max	.045 Max	22.2	5.0
90198-0002	26	0.12	0.74 Ref	.029 Ref	1.14 Max	.045 Max	13.3	3.0

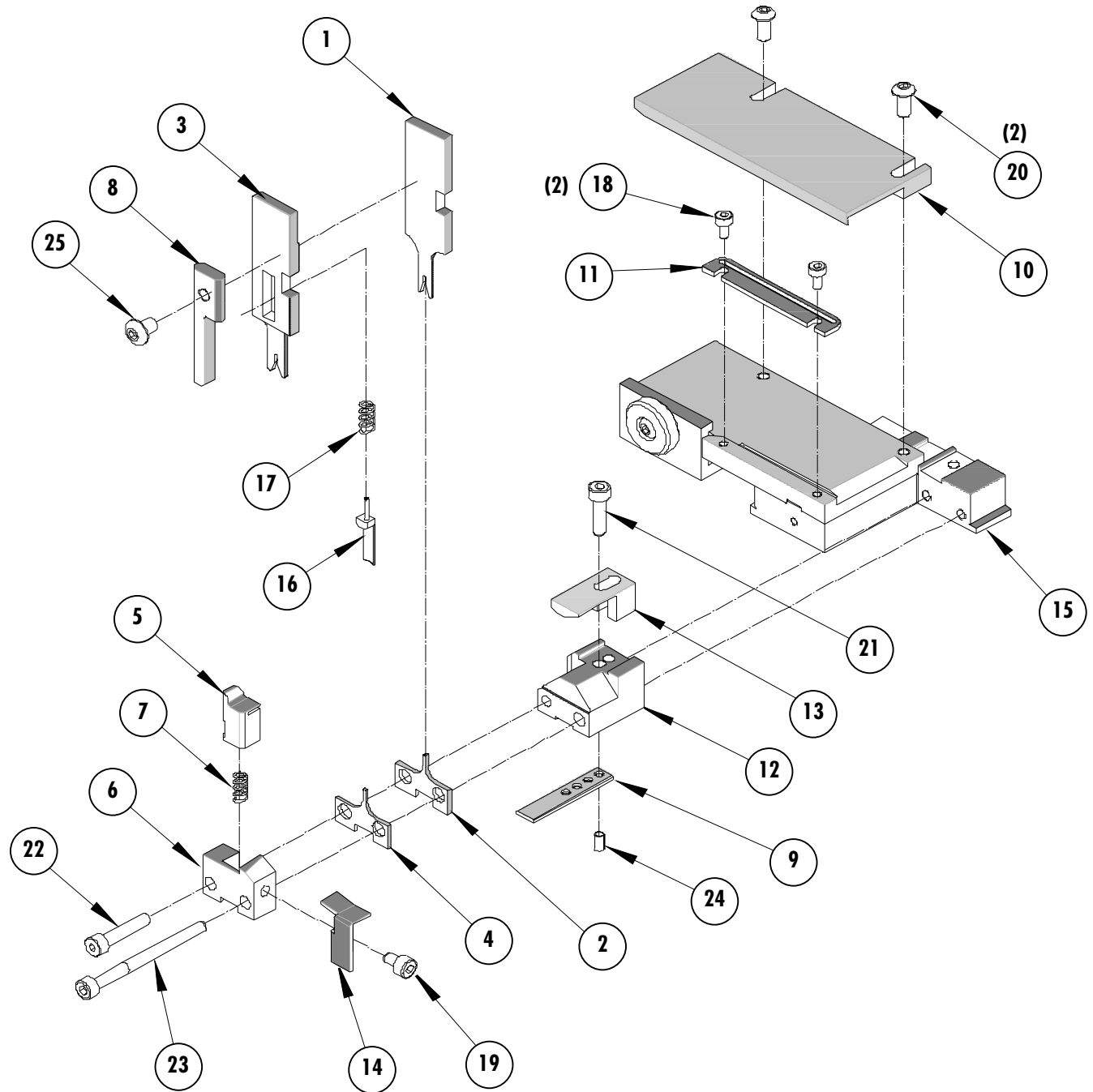
Pull Force should be measured with no influence from the insulation crimp.

The above specifications are guidelines to an optimum crimp.

PARTS LIST

Item	Order No	Engineering No.	Description	Quantity
	63855-2000	63855-2000	T2 Terminator (Fig. 1)	REF
1	63457-0013	63457-0013	Conductor Punch	1 Y
2	63445-1019	63445-1019	Conductor Anvil	1 Y
3	63454-0021	63454-0021	Insulation Punch	1 Y
4	63445-1834	63445-1834	Insulation Anvil	1 Y
5	63443-0003	63443-0003	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	63443-3160	63443-3160	Front Plunger Striker	1
9	63443-0021	63443-0021	Lower Tooling Key	1
10	63443-6003	63443-6003	Rear Cover	1
11	11-18-4083	60707-8	Front Cover	1
12	63443-2405	63443-2405	Anvil Mount	1
13	63865-2005	63865-2005	Wire Stop	1
14	63443-0009	63443-0009	Scrape Chute	1
15	63800-8500	63800-8500	T2 Terminator Frame	1
16	63443-0058	63443-0058	Ejector Blade Assembly	1
17	63700-0223	63700-0223	Ejector Blade Spring	1
18	N/A	N/A	M3 by 6Lg. SHCS	2**
19	N/A	N/A	M4 by 6Lg. SHCS	1**
20	N/A	N/A	M4 by 12Lg. BHCS	2**
21	N/A	N/A	M4 by 16Lg SHCS	1**
22	N/A	N/A	M4 by 20Lg. SHCS	1**
23	N/A	N/A	M4 by 50Lg. SHCS	1**
24	N/A	N/A	3MM by 6Lg. Roll Pin	1**
25	N/A	N/A	#10-32 by 3/8"Lg. BHCS	1**
	63855-2070	63855-2070	Tool Kit (All Y Items)	REF

** The following purchased parts are 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).

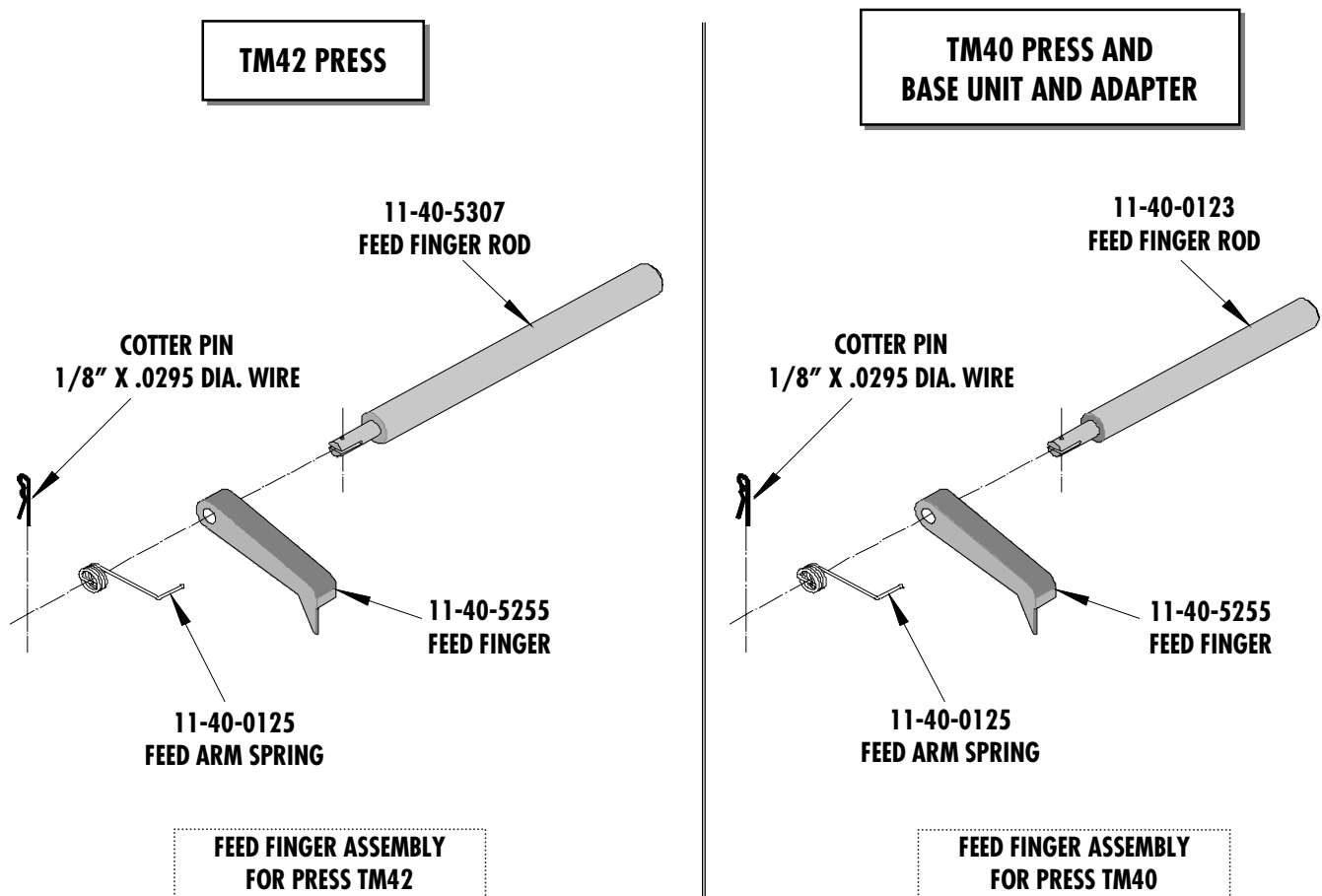


Figure 2

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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