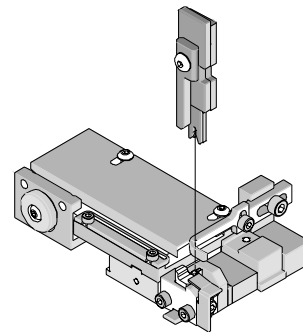




T2 Terminator Tooling Specification Sheet Part No. 63910-6100



FEATURES

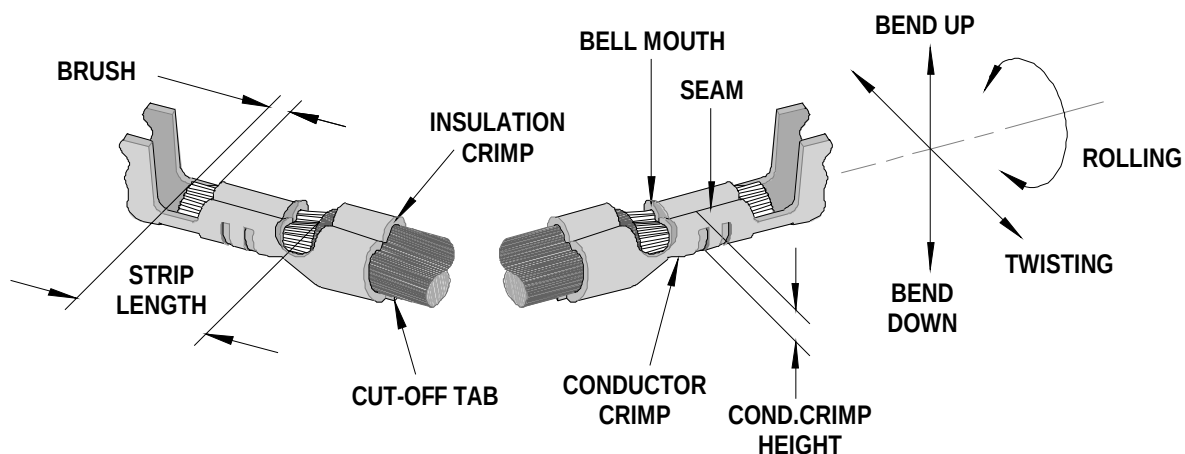
- It is ideally suited for mid-volume bench operations
- This terminator can be installed in the TM42 and the TM40 press or Base Unit adapter for 3BF press
- Quick punch removal with the push of a button for fast and easy tooling change
- Track adjustment capabilities in the T2 Terminators for improved 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: KK 156 Crimp Terminal-Humpback with Anti-Fish hook-18 AWG.

Terminal Series No.	Terminal Order No.	Wire Size		Insulation Diameter Maximum		Strip Length	
		AWG	mm ²	mm	In.	mm	In.
45606	45606-0004	18	0.80	2.79	.110	2.90-3.70	.114-.146
Note: Terminal will accommodate the UL1015 and UL1120 wires. Insulation crimp to meet IPC/WHMA-A-620 Class 2 compliance.							

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.
45606	0.20-0.50	.008-.020	0.50	.020	0.10-0.60	.004-.024

Terminal Series No.	Bend up Bend down		Twist Roll		Punch Width (Ref)				Seam
					Conductor		Insulation		
	Degree (Max)		Degree (Max)		mm	In	mm	In	Seam shall not be open and no wire allowed out of the crimping area
45606	3	3	4	8	1.90	.075	3.00	.118	

After crimping, the conductor profile should measure the following.

Terminal Series No.	Wire Size		Conductor Crimp Height		Insulation Crimp Height (Ref.)		Pull Force Minimum	
	AWG	mm ²	mm	In.	mm	In.	N	Lb.
45606	18	0.80	1.07-1.12	.042-.044	3.00	.118	89.0	20.00

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 63910-6100				
Item	Order No	Engineering No.	Description	Quantity
Perishable Tooling				
	63910-6170	63910-6170	Tool Kit (All "Y" Items)	REF
1	63444-1913	63444-1913	Conductor Punch	1 Y
2	63445-1949	63445-1949	Conductor Anvil	1 Y
3	63446-3026	63446-3026	Insulation Punch	1 Y
4	63445-3045	63445-3045	Insulation Anvil	1 Y
5	63443-0035	63443-0035	Front Cut-Off Plunger	1 Y
6	63443-0036	63443-0036	Front Plunger Retainer	1 Y
Other Components (REF 106150)				
7	11-18-4083	60707-8	Feed Guide	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	63443-1717	63443-1717	18.70mm Height Spacer	1
13	63443-2202	63443-2202	2.00mm Coarse Spacer	1
14	63443-2213	63443-2213	13.00mm Coarse Spacer	1
15	63443-2317	63443-2317	3.85mm Fine Spacer	1
16	63443-3160	63443-3160	Plunger Striker	1
17	63443-6013	63443-6013	Rear Cover	1
18	63700-0539	63700-0539	Cut-Off Plunger Spring	1
Frame				
19	63800-8500	63800-8500	T2 Terminator	1
Hardware				
20	N/A	N/A	M3 by 6 Long SHCS	2**
21	N/A	N/A	M3 by 6 Long FHCS	1**
22	N/A	N/A	M4 by 6 Long SHCS	2**
23	N/A	N/A	M4 by 12 Long BHCS	2**
24	N/A	N/A	M4 by 14 Long SHCS	2**
25	N/A	N/A	M4 by 50 Long SHCS	2**
26	N/A	N/A	M5 by 12 Long SHCS	1**
27	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

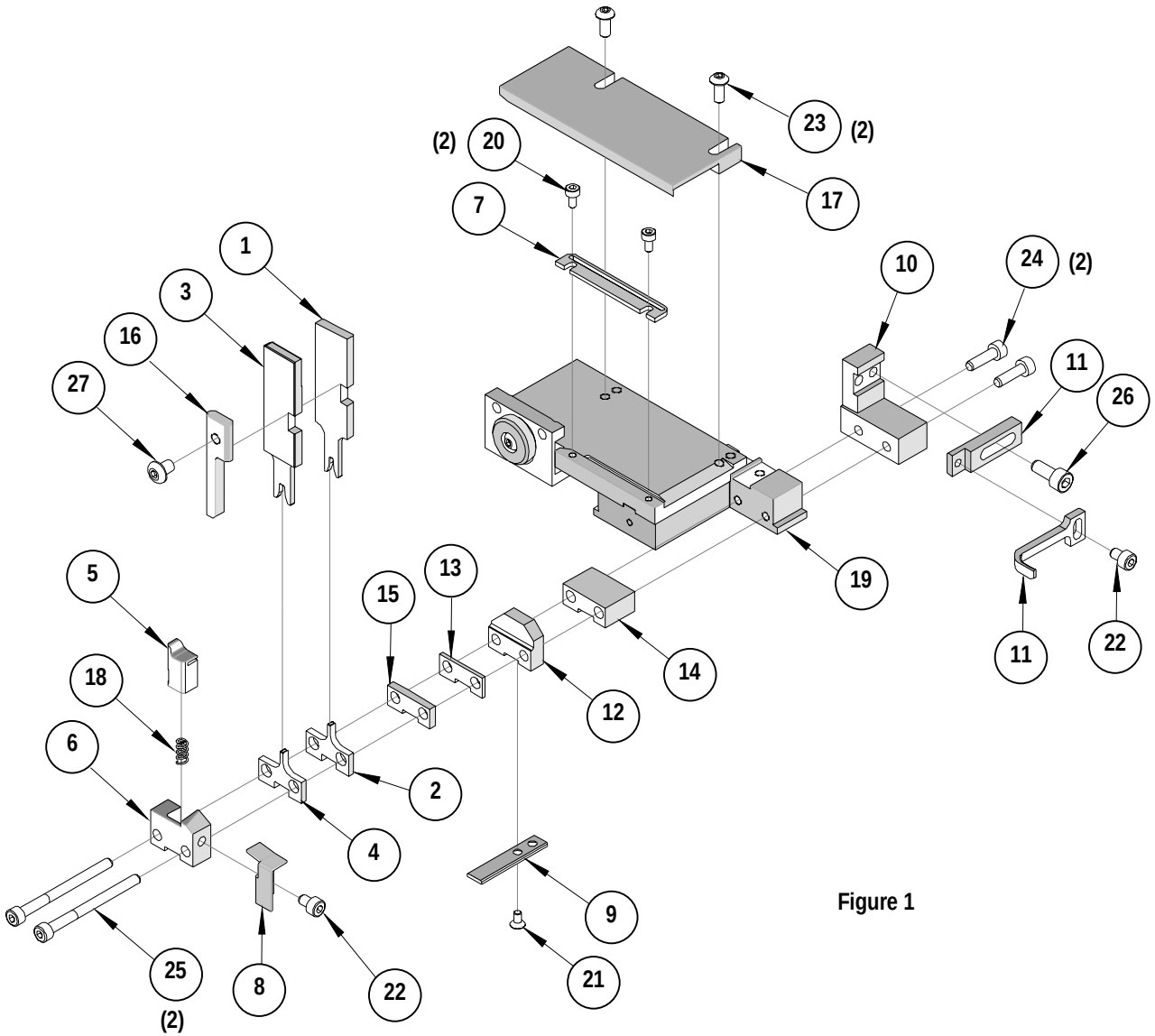


Figure 1

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).

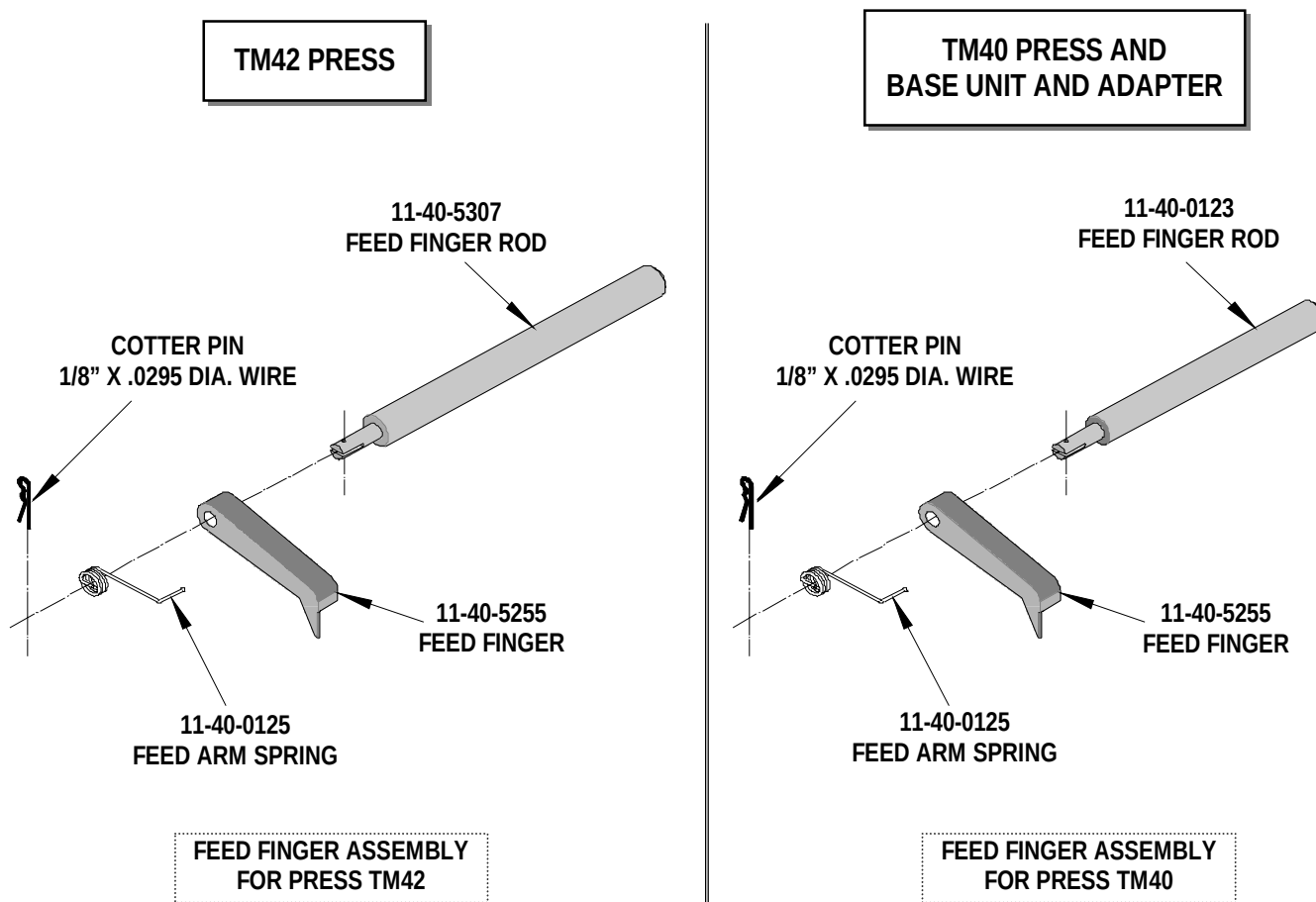


Figure 2

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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