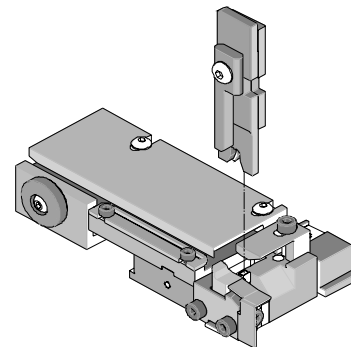




T2 Terminator Tooling Specification Sheet Part No. 63850-7000



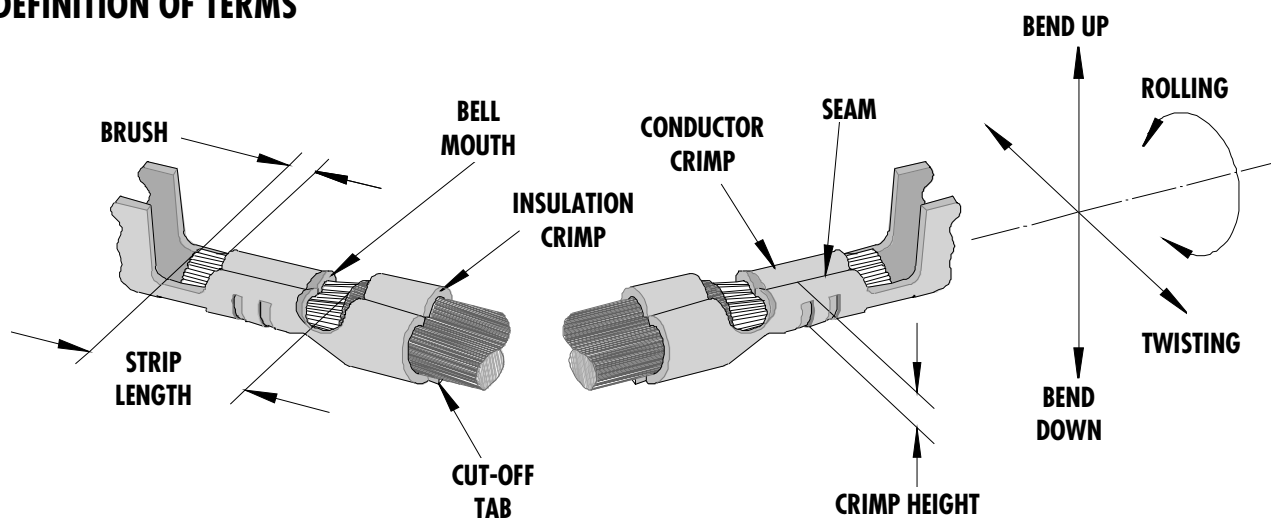
FEATURES

- 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 Series No.	Wire Size		Insulation Diameter		Strip Length	
	AWG	mm ²	mm	In.	mm	In.
50058-8000	28-32	0.08-0.03	0.50-1.00	.020-.039	1.40-1.90	.055-.075
50079-8000	26-28	0.12-0.08	0.50-1.00	.020-.039	1.40-1.90	.055-.075

DEFINITION OF TERMS



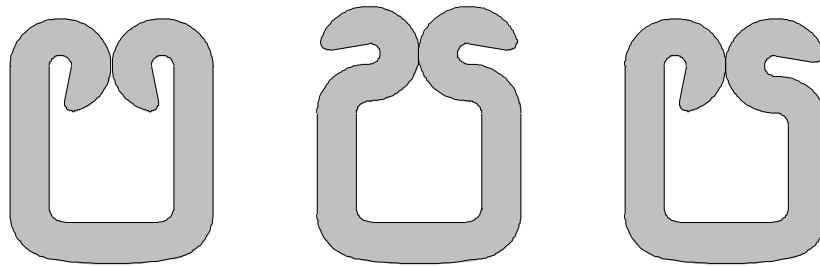
The above terminal drawing is a generic terminal representation. It is not an image of a terminal listed in the scope.

INSULATION CRIMP FORM

This crimp terminal is designed for miniaturization; therefore each dimension of insulation crimp portion appears small as compared to the terminal material thickness. In order to avoid insulation piercing the crimp forms by the insulation barrel, coining is provided inside of the insulation barrel. For this reason, various crimp forms will occur at the tip of the insulation crimp barrel shown in the figure below.

These crimp forms maybe changed completely by a small change in the wire, insulation punch or terminal.

These crimp forms are satisfactory for original function of the insulation crimp portion and it is confirmed that all of these forms below are acceptable insulation crimps.



CRIMP SPECIFICATION

Terminal Series No.	Bell mouth		Cut-off Tab Max.		Conductor Brush	
	mm	In.	mm	In.	mm	In.
50058-8000	0.00	.000	0.15	.006	0.00-0.70	.000-.028
50079-8000	0.00	.000	0.15	.006	0.00-0.70	.000-.028

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	
50058-8000	5	4	6	8	0.80	.031	0.85	.033	
50079-8000	5	4	6	8	0.80	.031	0.85	.033	

After crimping, the conductor profile should measure the following.

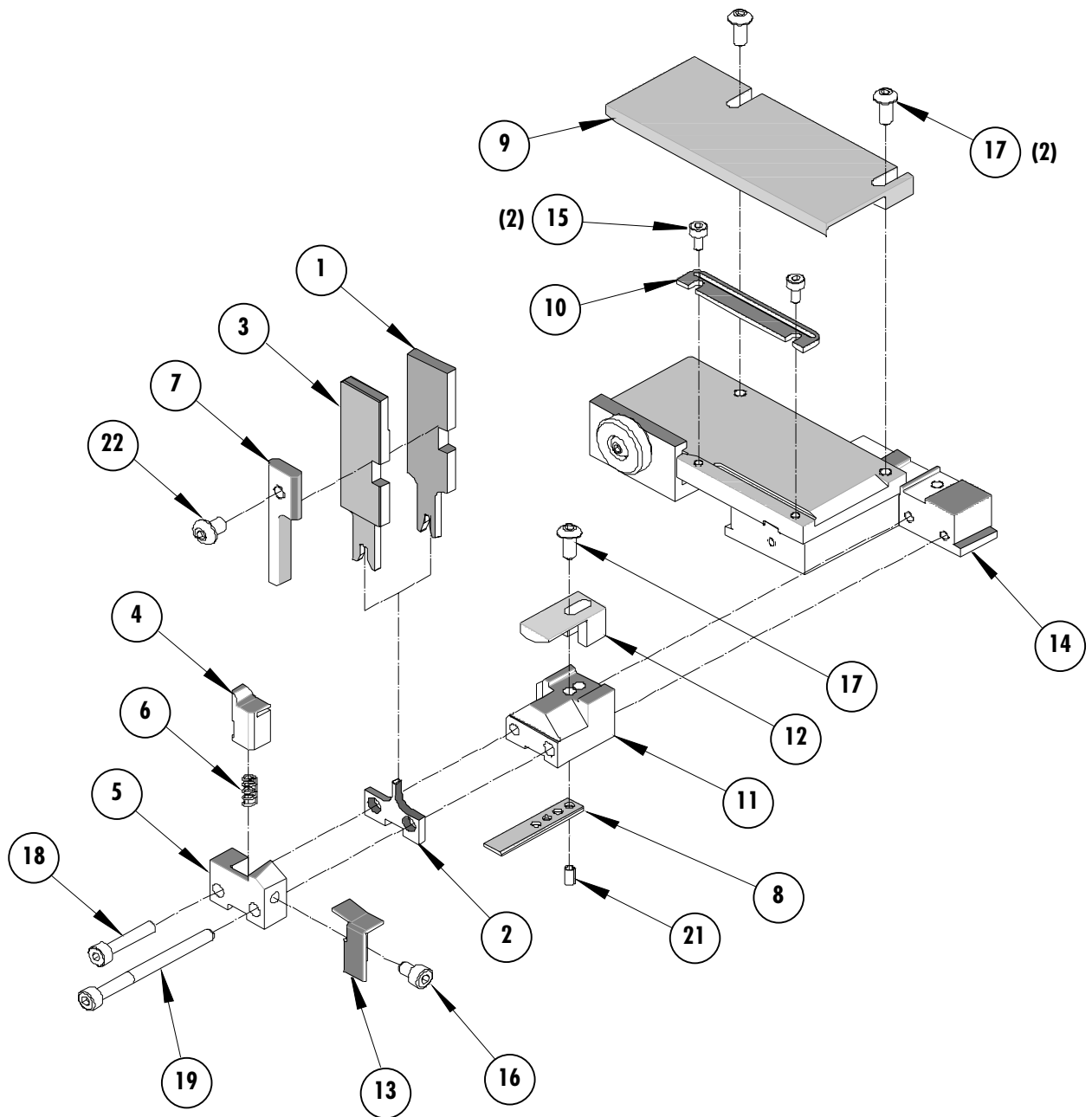
Terminal Series No.	Wire Size		Crimp Height		Pull Force Min.	
	AWG	mm ²	mm	In.	N	Lb.
50058-8000	28	0.80	0.51-0.56	.020-.022	9.8	2.2
50058-8000	30	0.05	0.48-0.53	.019-.021	4.9	1.1
50058-8000	32	0.03	0.46-0.51	.018-.020	2.9	0.7
50079-8000	26	0.12	0.60-0.65	.023-.025	9.8	2.2
50079-8000	28	0.08	0.56-0.61	.022-.024	9.8	2.2

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
	63850-7000	63850-7000	T2 Terminator (Fig. 1)	REF
1	63444-0805	63444-0805	Conductor Punch	1 Y
2	63445-0821	63445-0821	Combination Anvil	1 Y
3	63454-0031	63454-0031	Insulation Punch	1 Y
4	63443-0003	63443-0003	Cut-Off Plunger	1 Y
5	63443-0012	63443-0012	Front Plunger Retainer	1 Y
6	11-24-1067	4996-4	Cut-off Plunger Spring	1
7	11-40-4039	8302-5	Front Plunger Striker	1
8	63443-0021	63443-0021	Lower Tooling Key	1
9	63443-6003	63443-6003	Rear Cover	1
10	11-18-4083	60707-8	Front Cover	1
11	63443-2402	63443-2402	Anvil Mount	1
12	63443-4025	63443-4025	Wire Stop	1
13	63443-0009	63443-0009	Scrape Chute	1
14	63800-8500	63800-8500	T2 Terminator	1
15	N/A	N/A	M3 by 6Lg. SHCS	2**
16	N/A	N/A	M4 by 6Lg. SHCS	1**
17	N/A	N/A	M4 by 10Lg. BHCS	3**
18	N/A	N/A	M4 by 20Lg. SHCS	1**
19	N/A	N/A	M4 by 50Lg. SHCS	1**
20	N/A	N/A	M4 by 16Lg. SHCS	1**
21	N/A	N/A	3MM by 6Lg. Roll Pin	1**
22	N/A	N/A	#10-32 by 3/8"Lg. BHCS	1**
23	63850-7070	63850-7070	Tool Kit (All Y Items)	1

** 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).

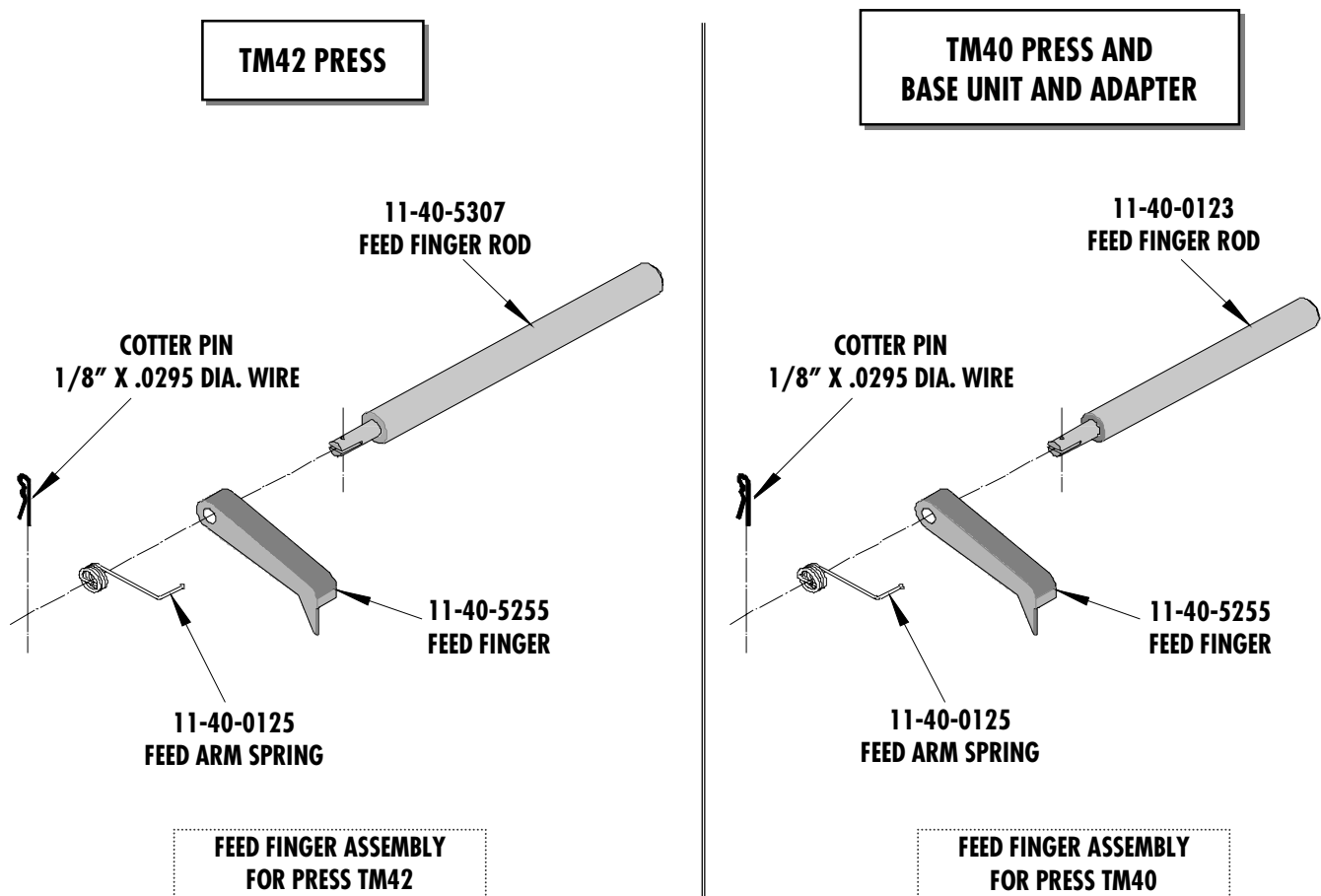


Figure 2

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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