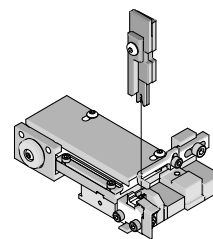


T2 Terminator Tooling

molex

Application Tooling Specification Sheet


Order No. 63911-9600

FEATURES

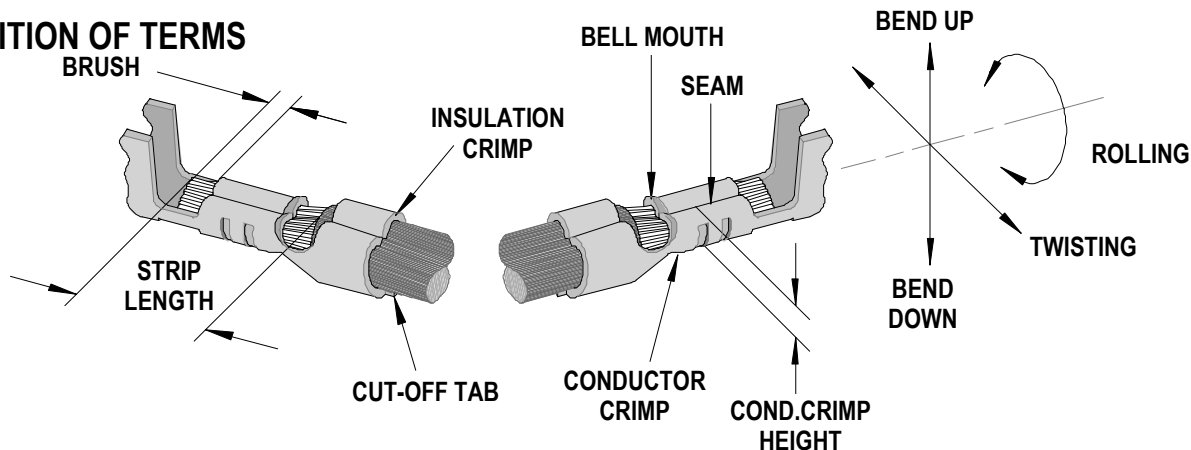
- It is ideally suited for mid-volume bench operations
- This terminator can be installed in the TM42 and the TM40 press or Base Unit adapter for 3BF press
- Quick punch removal with the push of a button for fast and easy tooling change
- Track adjustment capabilities in the T2 Terminators for improved 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: 2.00mm (.079") Pitch Female Crimp Terminal, 22-28 AWG.

UL 1007 (100%) / 100% / 100% / 100% / 100% / 100% / 100% / 100% / 100% / 100%									
Terminal Series No.	Terminal Order No.	Wire Size		Insulation Diameter				Strip Length	
				IPC/WHMA-A60 (1)		Terminal (2)			
		AWG	mm ²	mm	In.	mm	In.	mm	In.
56134	56134-8000	22	0.34	1.60	0.063	1.25-1.70 (4)	.049-.067 (4)	1.60-2.00	.063-.079
		24	0.20	1.45	0.057				
		26	0.13	1.30	0.051				
	56134-9000	22	0.34	1.60	0.063	0.90-1.70 (4)	.035-.067 (4)	1.60-2.00	.063-.079
		24	0.20	1.45	0.057				
		26	0.13	1.30	0.051				
		28 (3)	-	-	-				
	(1) To achieve optimum IPC-A620 Class 2 insulation crimps, use this insulation OD using UL1007 wire.								
(2) Overall insulation OD specification for terminal.									
(3) 28 AWG wire is not recommended for use in this terminal, use 22-26 AWG wire for better crimp quality.									
(4) An insulation diameter larger than 1.60 (0.63") will cause the insulation grips to pierce the insulation on both sides of the insulation crimp. The customer should determine the suitability for their application.									

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.
56134	0.05-0.40	.002-.016	0.30	.012	0.10-0.70	.004-.028

Terminal Series No.	Bend up	Bend down	Twist	Roll	Punch Width (Ref)				Seam Seam shall not be open and no wire allowed out of the crimping area
	Degree		Degree		Conductor		Insulation		
					mm	In	mm	In	
56134	3 °	3 °	3 °	6 °	1.20	.047	1.60	.063	

After crimping, the crimp profiles should measure the following:

Terminal Order No.	Wire Size		Conductor				Insulation				Pull Force Minimum	
			Crimp Height		Crimp Width (Ref)		Crimp Height		Crimp Width (Ref)			
	AWG	mm²	mm	In.	mm	In.	mm	In.	mm	In.	N	Lb.
56134-8000	22	0.34	0.70-0.75	.028-.030	1.18-1.28	.046-.050	1.85-1.95	.073-.077	1.55-1.75	.061-.069	44.1	9.9
	24	0.20	0.67-0.72	.026-.028	1.18-1.28	.046-.050	1.80-1.90	.071-.075	1.55-1.75	.061-.069	29.4	6.6
	26	0.13	0.61-0.66	.024-.026	1.18-1.28	.046-.050	1.75-1.85	.069-.073	1.55-1.75	.061-.069	19.6	4.4
56134-9000	22	0.34	0.70-0.75	.028-.030	1.18-1.28	.046-.050	1.85-1.95	.073-.077	1.55-1.75	.061-.069	44.1	9.9
	24	0.20	0.67-0.72	.026-.028	1.18-1.28	.046-.050	1.80-1.90	.071-.075	1.55-1.75	.061-.069	29.4	6.6
	26	0.13	0.61-0.66	.024-.026	1.18-1.28	.046-.050	1.75-1.85	.069-.073	1.55-1.75	.061-.069	19.6	4.4

T Tool Qualification Notes:

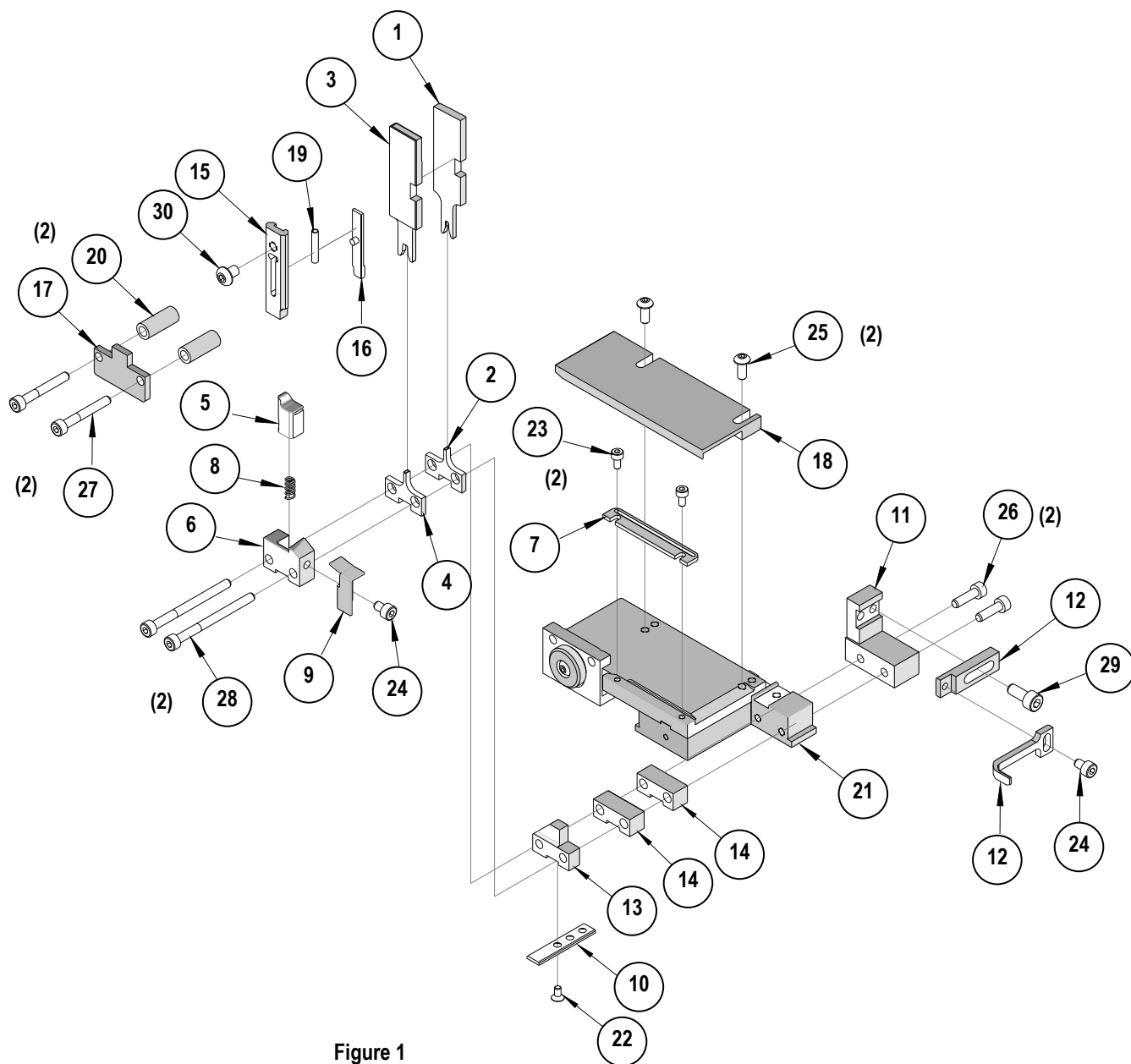
1. This Applicator was qualified to the above specifications with UL1007 wire.
2. Pull Force should be measured with no influence from the insulation crimp.
3. The above specifications are guidelines to an optimum crimp.

PARTS LIST

T2 Terminator 63911-9600				
Item	Order No	Engineering No.	Description	Quantity
Perishable Tooling				
	63911-9670	63911-9670	Tool Kit (All "Y" Items)	REF
1	63444-1207	63444-1207	Conductor Punch	1 Y
2	63445-1213	63445-1213	Conductor Anvil	1 Y
3	63446-1614	63446-1614	Insulation Punch	1 Y
4	63445-1624	63445-1624	Insulation Anvil	1 Y
5	63443-0002	63443-0002	Front Cut-Off Plunger	1 Y
6	63443-0012	63443-0012	Front Plunger Retainer	1 Y
Other Components				
7	11-18-4083	60707-8	Front Cover	1
8	11-24-1067	4996-4	Cut-off Plunger Spring	1
9	63443-0009	63443-0009	Front Scrap Chute	1
10	63443-0024	63443-0024	Key	1
11	63443-0085	63443-0085	Wire Stop L-Bracket	1
12	63443-0090	63443-0090	Wire Stop	1
13	63443-1703	63443-1703	17.30mm Height Spacer	1
14	63443-2210	63443-2210	10.0mm Coarse Spacer	2
15	63443-2801	63443-2801	Plunger Striker Front	1
16	63443-2913	63443-2913	Wire Hold Down Plunger	1
17	63443-7201	63443-7201	Spring Cover	1
18	63443-6003	63443-6003	Rear Cover	1
19	63600-0021	63600-0021	Cut-Off Plunger Spring	1
20	63600-2972	63600-2972	Collar	2
Frame				
21	63800-8500	63800-8500	T2 Terminator	1
Hardware				
22	N/A	N/A	M3 by 6 Long FHCS	1**
23	N/A	N/A	M3 by 6 Long SHCS	2**
24	N/A	N/A	M4 by 6 Long SHCS	2**
25	N/A	N/A	M4 by 12 Long BHCS	2**
26	N/A	N/A	M4 by 14 Long SHCS	2**
27	N/A	N/A	M4 by 30 Long SHCS	2**
28	N/A	N/A	M4 by 45 Long SHCS	2**
29	N/A	N/A	M5 by 12 Long SHCS	1**
30	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



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).

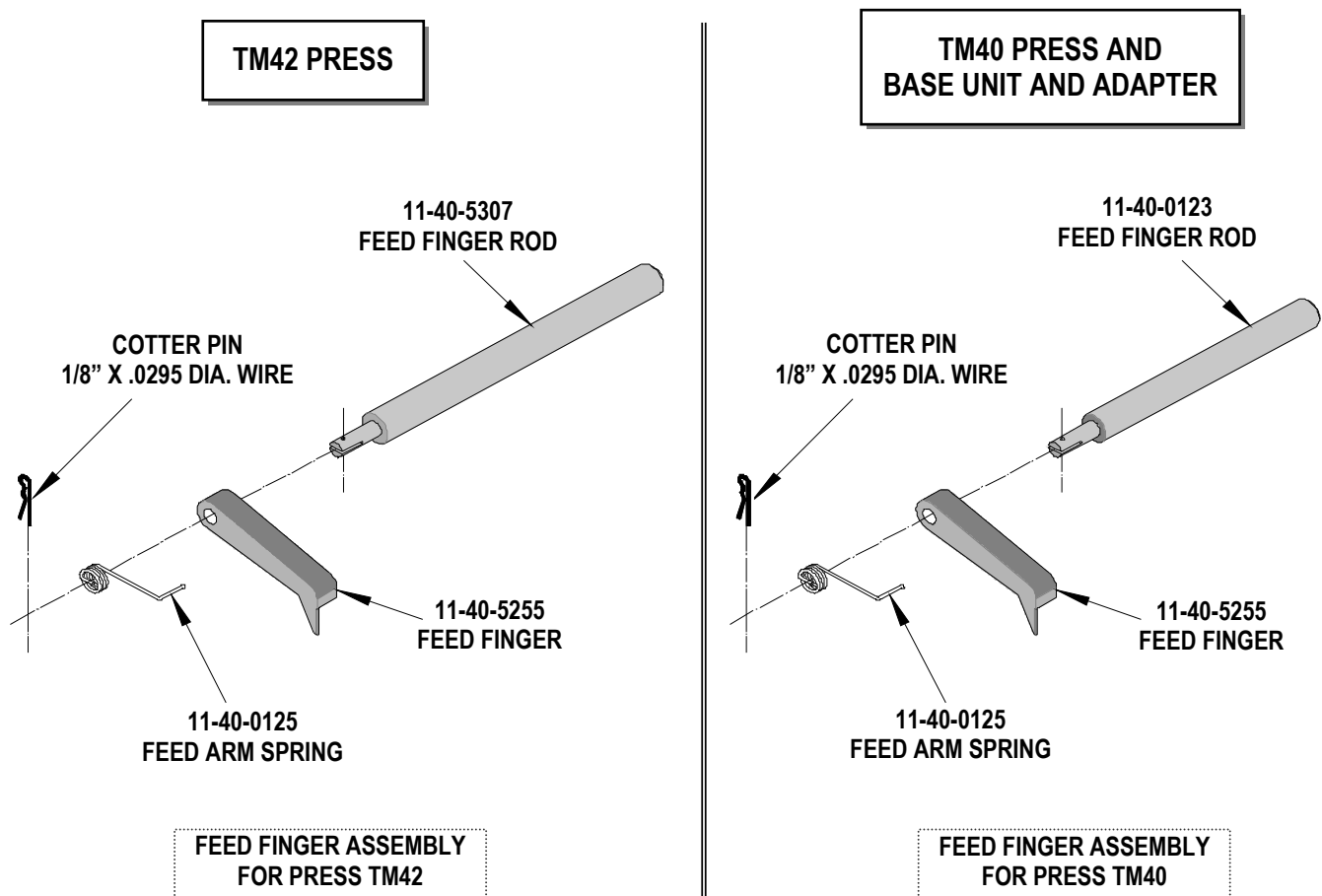


Figure 2

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 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.

<http://www.molex.com>

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