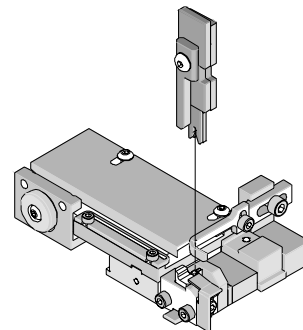




T2 Terminator Tooling Specification Sheet Part No. 63910-1700



FEATURES

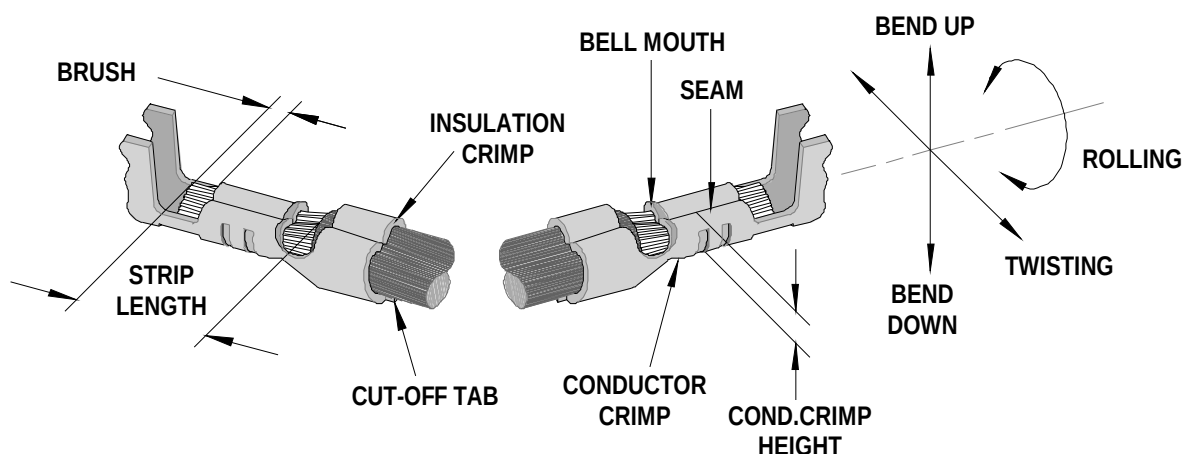
- It is ideally suited for mid-volume bench operations
- This terminator can be installed in the TM42 and the TM40 press or Base Unit adapter for 3BF press
- Quick punch removal with the push of a button for fast and easy tooling change
- Track adjustment capabilities in the T2 Terminators for improved 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: Sealed Mini Fit® H20 Male and Female Crimp Terminals, 18 - 20 AWG.

Terminal Series No.	Terminal Order No.	Wire Size		Insulation Diameter		Strip Length	
		AWG	mm ²	mm	In.	mm	In.
46055	46055-0004	18-20	0.80-0.50	2.52-2.81	.099-.111	2.60-3.10	.102-.122
	46055-0005						
	46055-0006						
46056	46056-0001	18-20	0.80-0.50	2.52-2.81	.099-.111	2.60-3.10	.102-.122
	46056-0002						
	46056-0003						

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.
46055	0.25-1.25	.010-.049	0.50	.020	0.15-0.40	.006-.016
46056	0.25-1.25	.010-.049	0.50	.020	0.15-0.40	.006-.016

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	
46055	3	3	3	3	1.60	.063	2.75	.108	
46056	3	3	3	3	1.60	.063	2.75	.108	

After crimping, the conductor profile should measure the following.

Terminal Series No.	Wire Size		Conductor Crimp Height		Insulation Crimp Height Maximum		Pull Force Minimum	
	AWG	mm ²	mm	In.	mm	In.	N	Lb.
46055	18	0.80	1.05-1.15	.041-.045	3.20	.126	89.0	20.0
	20	0.50	1.00-1.10	.039-.043	3.20	.126	57.8	13.0
46056	18	0.80	1.05-1.15	.041-.045	3.20	.126	89.0	20.0
	20	0.50	1.00-1.10	.039-.043	3.20	.126	57.8	13.0

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 63910-1700				
Item	Order No	Engineering No.	Description	Quantity
Perishable Tooling				
	63910-1770	63910-1770	Tool Kit (All "Y" Items)	REF
1	63444-1613	63444-1613	Conductor Punch	1 Y
2	63455-0047	63455-0047	Conductor Anvil	1 Y
3	63454-0064	63454-0064	Insulation Punch	1 Y
4	63456-0043	63456-0043	Insulation Anvil	1 Y
5	63443-0037	63443-0037	Front Cut-Off Plunger	1 Y
6	63443-0038	63443-0038	Front Plunger Retainer	1 Y
Other Components (REF 101750)				
7	11-18-4083	60707-8	Feed Guide	1
8	11-40-4039	8302-5	Plunger Striker	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	63443-1719	63443-1719	18.90mm Height Spacer	1
14	63443-2216	63443-2216	16.00mm Coarse Spacer	1
15	63443-2301	63443-2301	3.05mm Fine Spacer	1
16	63443-6011	63443-6011	Rear Cover	1
17	63700-0539	63700-0539	Cut-Off Plunger Spring	1
Frame				
18	63800-8500	63800-8500	T2 Terminator	1
Hardware				
19	N/A	N/A	M3 by 6 Long SHCS	2**
20	N/A	N/A	M3 by 6 Long FHCS	1**
21	N/A	N/A	M4 by 6 Long SHCS	2**
22	N/A	N/A	M4 by 12 Long BHCS	2**
23	N/A	N/A	M4 by 14 Long SHCS	2**
24	N/A	N/A	M4 by 50 Long SHCS	2**
25	N/A	N/A	M5 by 12 Long SHCS	1**
26	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

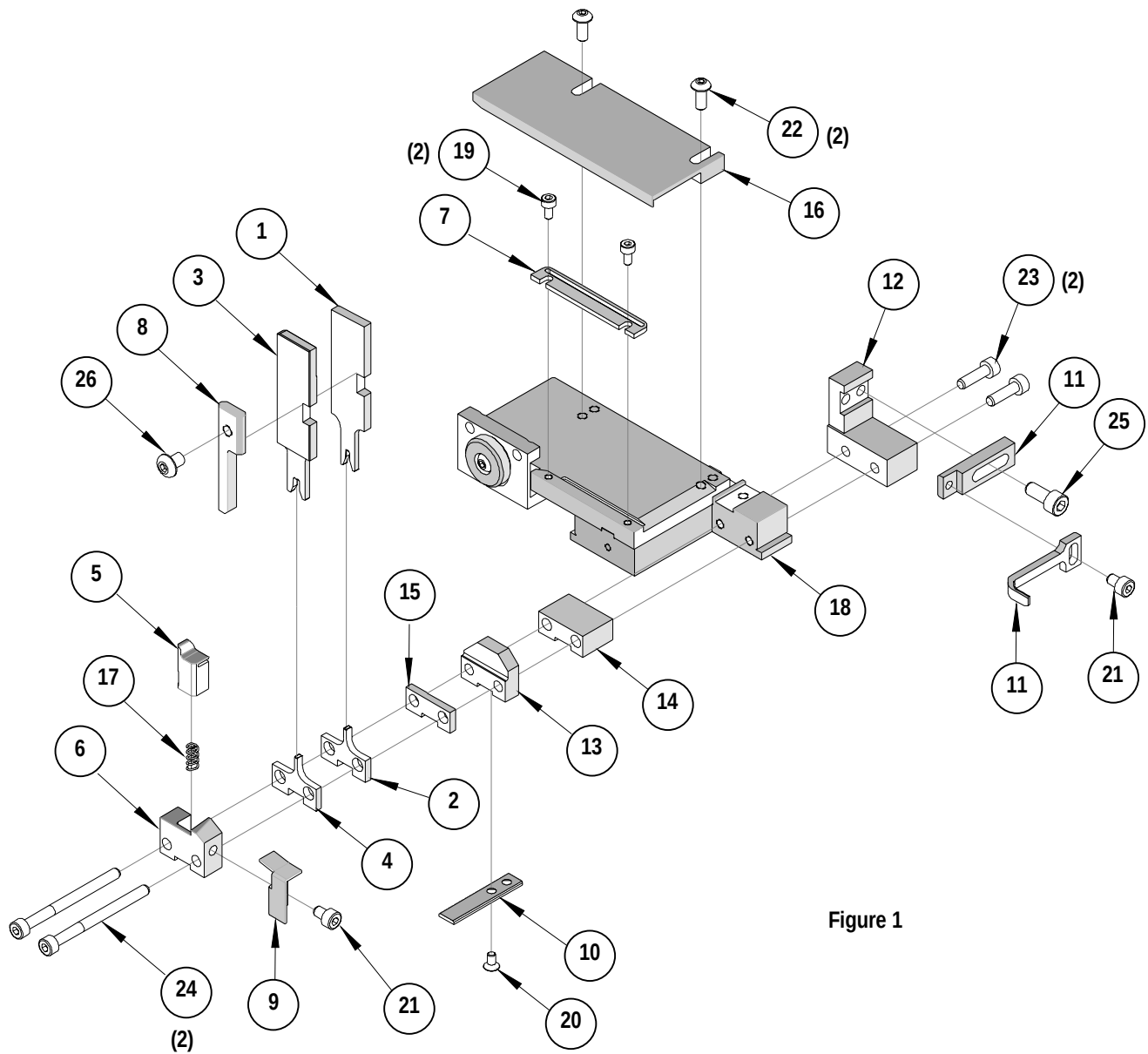


Figure 1

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).

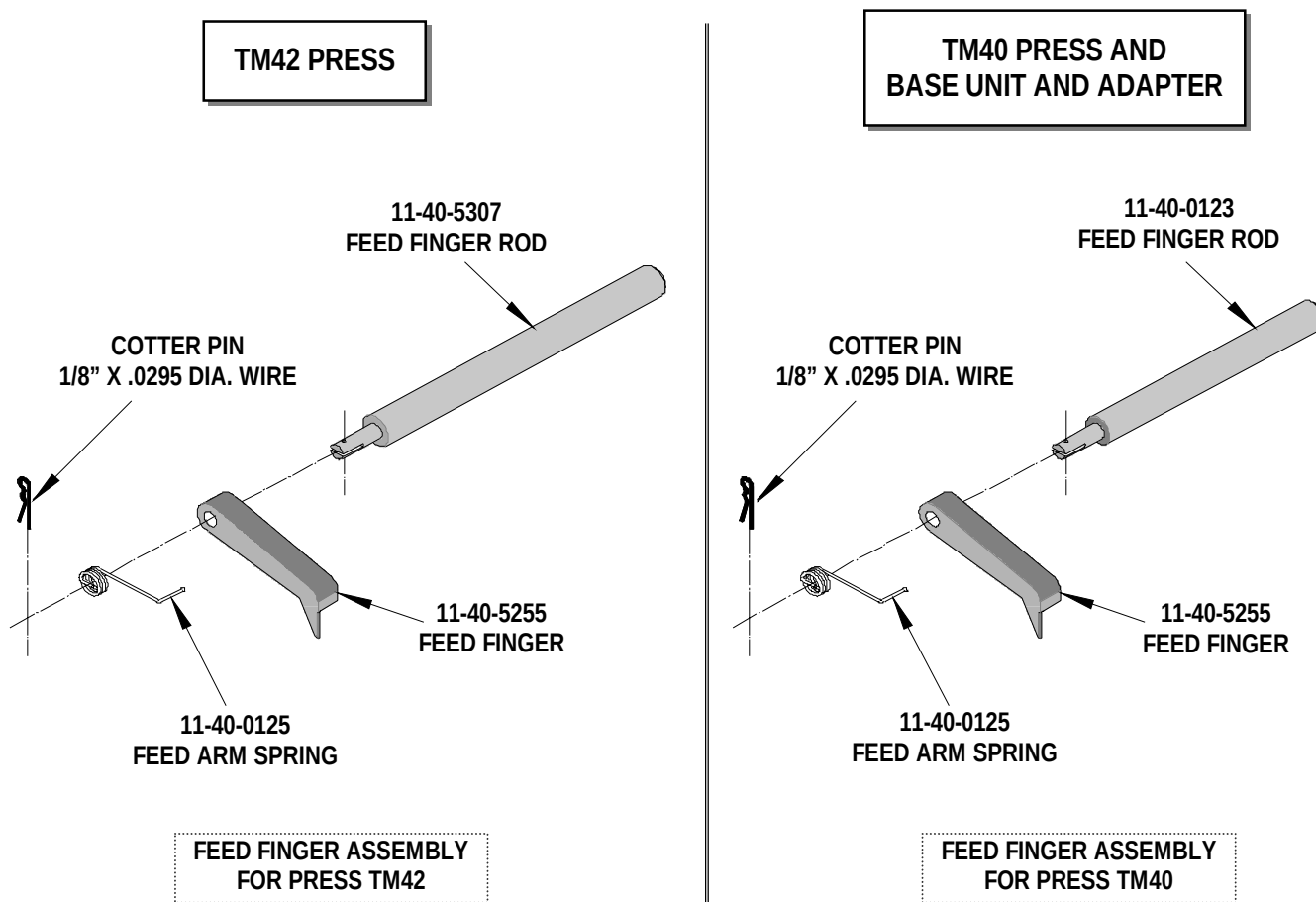


Figure 2

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.

Americas Headquarters
Lisle, Illinois 60532 U.S.A.
1-800-78MOLEX
amerinfo@molex.com

Far East North Headquarters
Yamato, Kanagawa, Japan
81-462-65-2324
feninfo@molex.com

Far East South Headquarters
Jurong, Singapore
65-6-268-6868
fesinfo@molex.com

European Headquarters
Munich, Germany
49-89-413092-0
eurinfo@molex.com

Corporate Headquarters
2222 Wellington Ct.
Lisle, IL 60532 U.S.A.
630-969-4550
Fax: 630-969-1352

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

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Тел: +7 (812) 336 43 04 (многоканальный)

Email: org@lifeelectronics.ru

www.lifeelectronics.ru