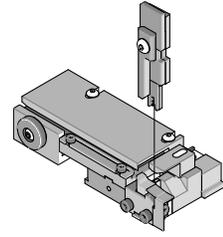




T2 Terminator Tooling

Application Tooling Specification Sheet



Order No. 63856-1000

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

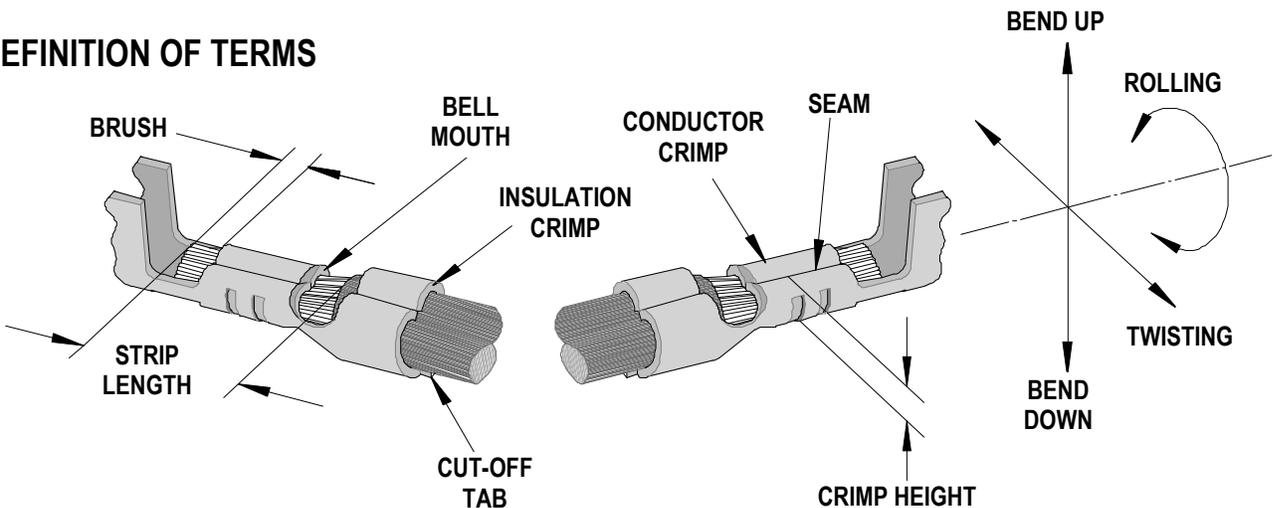
SCOPE

Products: 1.27mm (.050") Pitch SATA Crimp Power Terminal, 18-22 AWG.

Terminal Series No.	Terminal Order No.	Wire Size		Insulation Diameter				Strip Length	
				IPC/WHMA-A620 (1)		Terminal (2)			
		AWG	mm ²	mm	In.	mm	In.	mm	In.
47634	47634-1000	18	0.83	2.00-2.40	.079-.095	2.00-2.40	.079-.095	2.50-3.50	.098-.138
	47634-1001	20	0.52	1.65-1.95	.065-.077	1.55-1.95	.061-.077	2.50-3.50	.098-.138
	47634-1002	22	0.32	1.65-1.80	.065-.071	1.40-1.80	.055-.071	2.50-3.50	.098-.138
67581	67581-0010	18	0.83	2.00-2.40	.079-.095	2.00-2.40	.079-.095	2.50-3.50	.098-.138
	67581-0011	20	0.52	1.65-1.95	.065-.077	1.55-1.95	.061-.077	2.50-3.50	.098-.138
	67581-0012	22	0.32	1.65-1.80	.065-.071	1.40-1.80	.055-.071	2.50-3.50	.098-.138

(1) To achieve optimum IPC-A620 Class 2 insulation crimps. For smaller wire diameter use T2 Terminator order no. 63912-3500.
 (2) Overall insulation OD specification for terminal.

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.
47634	0.20-0.50	.008-.020	0.30	.012	0.00-1.00	.000-.039
67581	0.20-0.50	.008-.020	0.30	.012	0.00-1.00	.000-.039

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	
47634	8	3	4	8	1.60	.063	2.50	.098	
67581	8	3	4	8	1.60	.063	2.50	.098	

After crimping, the conductor profile should measure the following.

Terminal Series No.	Wire Size		Conductor Crimp Height		Insulation Crimp Height		Pull Force Minimum	
	AWG	mm ²	mm	In.	mm	In.	N	Lb.
47634	18	0.83	1.15-1.25	.045-.049	2.25-2.55	.088-.100	88.2	19.82
	20	0.52	1.10-1.20	.043-.047	---	---	58.8	13.21
	22	0.32	1.05-1.15	.041-.045	---	---	39.2	8.80
67581	18	0.83	1.15-1.25	.045-.049	2.25-2.55	.088-.100	88.2	19.82
	20	0.52	1.10-1.20	.043-.047	---	---	58.8	13.21
	22	0.32	1.05-1.15	.041-.045	---	---	39.2	8.80

Tool Qualification Notes:

1. Pull Force should be measured with no influence from the insulation crimp.
2. The above specifications are guidelines to an optimum crimp.

PARTS LIST

T-2 Terminator 63856-1000				
Item	Order No	Engineering No.	Description	Quantity
Perishable Tooling				
	63856-1070	63856-1070	Tool Kit (All "Y" Items)	REF
1	63444-1604	63444-1604	Conductor Punch	1 Y
2	63445-1641	63445-1641	Conductor Anvil	1 Y
3	63446-2502	63446-2502	Insulation Punch	1 Y
4	63445-2511	63445-2511	Insulation Anvil	1 Y
5	63443-0003	63443-0003	Cut-Off Plunger	1 Y
6	63443-0012	63443-0012	Front Plunger Retainer	1 Y
Other Components				
7	11-18-4083	60707-8	Feed Guide	1
8	11-24-1067	4996-4	Cut-off Plunger Spring	1
9	11-40-4039	8302-5	Plunger Striker Front	1
10	63443-0009	63443-0009	Scrap Chute Front	1
11	63443-0021	63443-0021	Lower Tooling Key	1
12	63443-2409	63443-2409	Anvil Mount	1
13	63443-4018	63443-4018	Wire Stop	1
14	63443-6004	63443-6004	Rear Cover	1
Frame				
15	63800-8500	63800-8500	T2 Terminator	1
Hardware				
16	N/A	N/A	M3 by 6 Long SHCS	2**
17	N/A	N/A	M4 by 6 Long SHCS	1**
18	N/A	N/A	M4 by 12 Long BHCS	2**
19	N/A	N/A	M4 by 16 Long BHCS	1**
20	N/A	N/A	M4 by 20 Long SHCS	1**
21	N/A	N/A	M4 by 50 Long SHCS	1**
22	N/A	N/A	3MM by 6 Long Roll Pin	1**
23	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

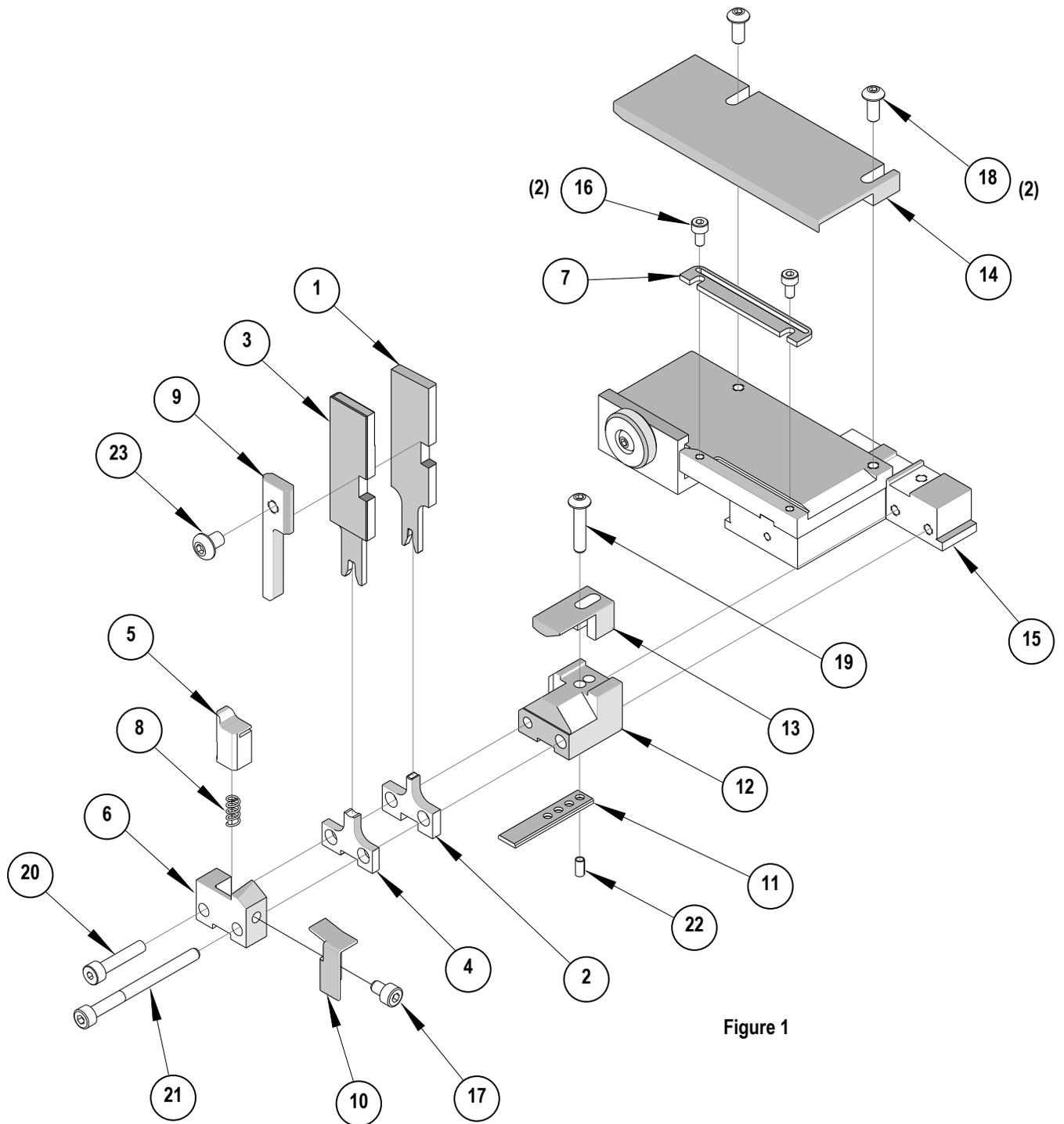


Figure 1

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).

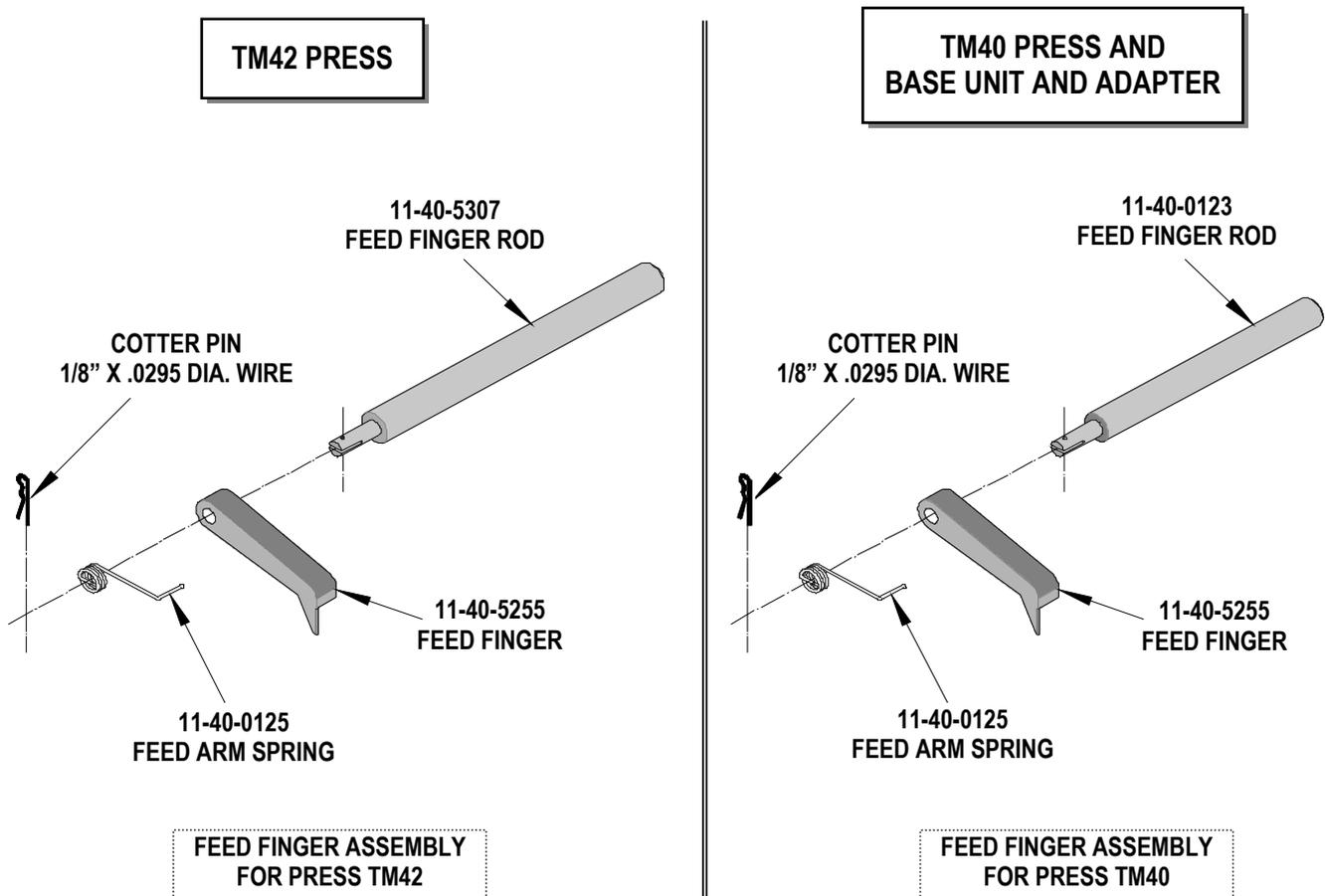


Figure 2

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, terminators and tooling.

<http://www.molex.com>