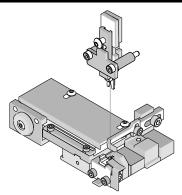


T2 Terminator Tooling Specification Sheet Order No. 63910-6200



FEATURES

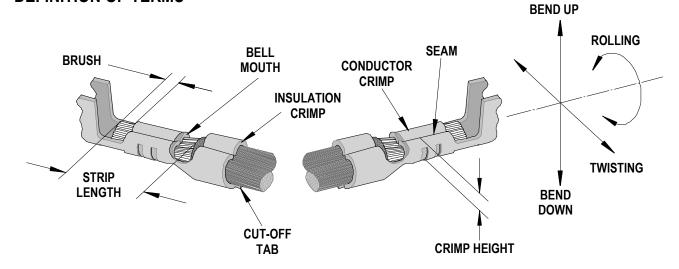
- This terminator can be installed in the TM42 and the TM40 press or Base Unit adapter for 3BF press
- It is ideally suited for mid-volume bench operations
- Quick punch removal with the push of a button for fast and easy tooling change
- Track adjustment capabilities in the T2 Terminators for improved 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: Standard .093" (2.63mm) Pin and Socket Crimp Terminal

Terminal Order No.	Terminal Series No.		Wire Size		Insulation Diameter		Strip Length	
Terminal Order No.			AWG	mm²	mm	ln.	mm	ln.
42477	02-09-1615		14	2.07	2.79-3.56	.110140	3.96-5.33	.156218
42478	02-09-2611	02-09-2612	14	2.07	2.79-3.56	.110140	3.96-5.33	.156218
For 16-18 AWG 2.36mm (.093") -3.20mm (.126") insulation diameter, use 63910-5600 Terminator.								

DEFINITION OF TERMS



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

Release Date: 11-01-07 Revision Date: 04-21-09 **UNCONTROLLED COPY**

CRIMP SPECIFICATION

Terminal Series No.	Bell n	nouth	Cut-off Tab) Maximum	Conductor Brush	
	mm	ln.	mm	ln.	mm	ln.
42477	0.25-0.58	.010023	0.25	.010	0.13-0.55	.005022
42478	0.25-0.58	.010023	0.25	.010	0.13-0.55	.005022

	Bend up Bend down		Twist Roll		Punch Width (Ref)				Seam
Terminal Series No.	Denu up	Conductor			Insulation				
	Degree		Degree		mm	In	mm	In	Seam shall not be open
42477	3	3	4	8	2.30	.090	3.60	.141	and no wire allowed out
42478	3	3	4	8	2.30	.090	3.60	.141	of the crimping area

After crimping, the conductor profile should measure the following.

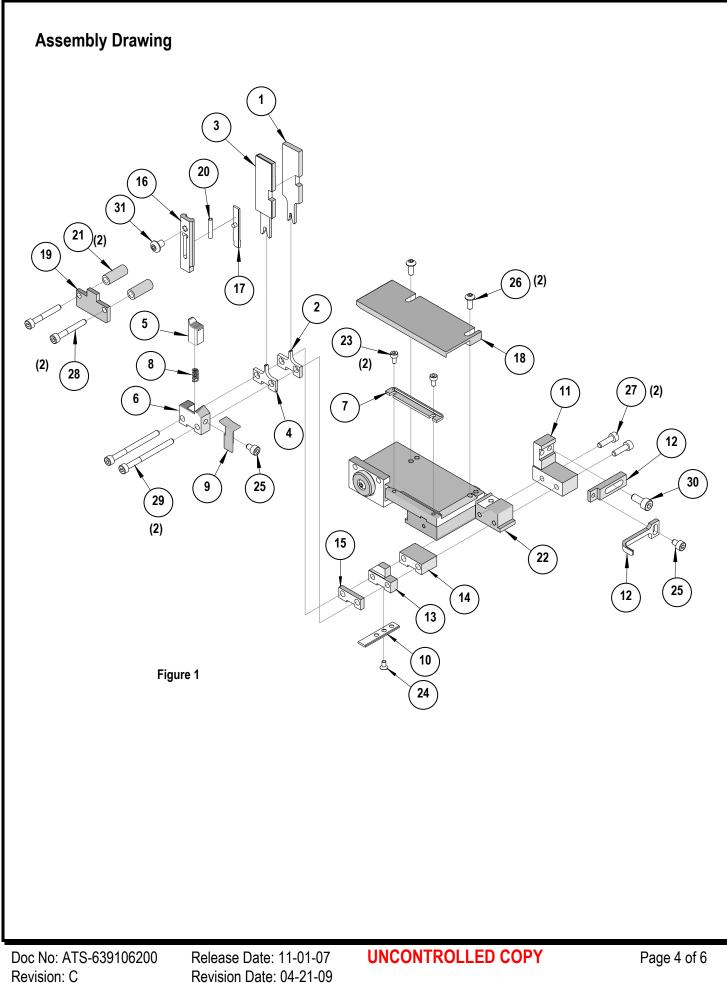
Terminal Series No.	Wire	Size	Conductor C	rimp Height	Pull Force Minimum		
Terminal Series NO.	AWG	mm ²	mm	ln.	Ν	Lb.	
42477	14	2.07	1.91-1.80	.075071	222.4	50.00	
42478	14	2.07	1.91-1.80	.075071	222.4	50.00	

Pull Force should be measured with no influence from the insulation crimp.

The above specifications are guidelines to an optimum crimp.

PARTS LIST

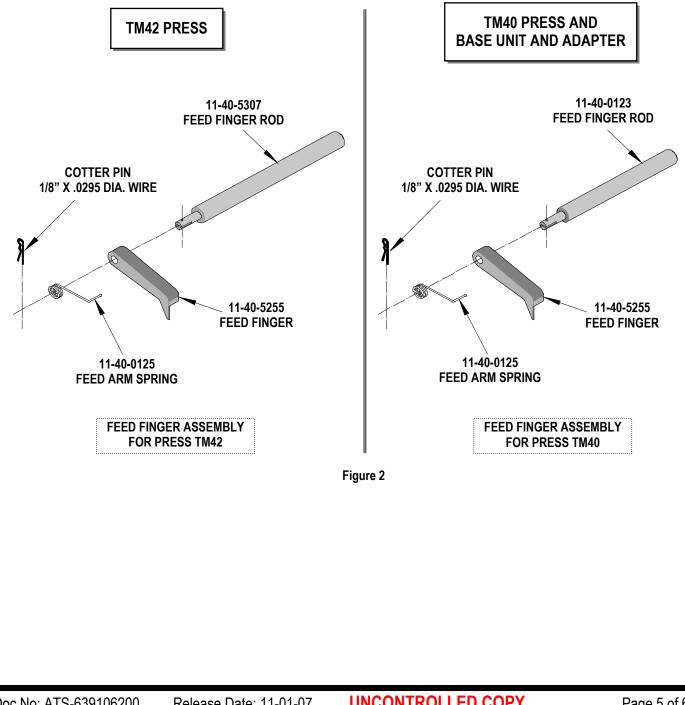
	T2 Terminator 63910-6200								
ltem	Order No	Order No Engineering No. Description							
Item Order No Engineering No. Description Quantity Perishable Tooling									
	63910-6270	63910-6270	Tool Kit (All "Y" Items)	REF					
1	63444-2325	63444-2325	Conductor Punch	1 Y					
2	63445-2348	63445-2348	Conductor Anvil	1 Y					
3	63460-3606	63460-3606	Insulation Punch	1 Y					
4	63445-3614	63445-3614	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 Componen	its (REF 105650)						
7	11-18-4083	60707-8	Feed Guide	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	63443-1719	63443-1719	18.90mm Height Spacer	1					
14	63443-2214	63443-2214	14.00mm Coarse Spacer	1					
15	63443-2308	63443-2308	3.40mm Fine Spacer	1					
16	63443-2801	63443-2801	Front Plunger Striker	1					
17	63443-2913	63443-2913	Wire Hold Down Plunger	1					
18	63443-6011	63443-6011	Rear Cover	1					
19	63443-7201	63443-7201	Spring Cover	1					
20	63600-1057	63600-1057	Compression Spring	1					
21	63600-2972	63600-2972	Collar	2					
	Frame								
22	63800-8500	63800-8500	T2 Terminator	1					
	Hardware								
23	N/A	N/A	M3 by 6 Long SHCS	2**					
24	N/A	N/A	M3 by 6 Long FHCS	1**					
25	N/A	N/A	M4 by 6 Long SHCS	2**					
26	N/A	N/A	M4 by 12 Long BHCS	2**					
27	N/A	N/A	M4 by 14 Long SHCS	2**					
28	N/A	N/A	M4 by 30 Long SHCS	2**					
29	N/A	N/A	M4 by 50 Long SHCS	2**					
30	N/A	N/A	M5 by 12 Long SHCS	1**					
31									
** Ava	** Available from an industrial supply company such as MSC (1-800-645-7270).								



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).



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.

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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