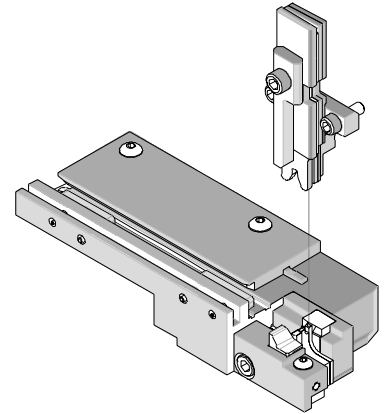




T Style Terminator Tooling Specification Sheet

Order No. 11-40-2042
Eng. No. T8324A



FEATURES

- It is ideally suited for mid-volume bench operations
- This terminator can be installed in the TM42, TM40, and Base Unit adapter for 3BF press
- Quick punch removal with the push of a button for fast and easy tooling change
- Flexible and inexpensive

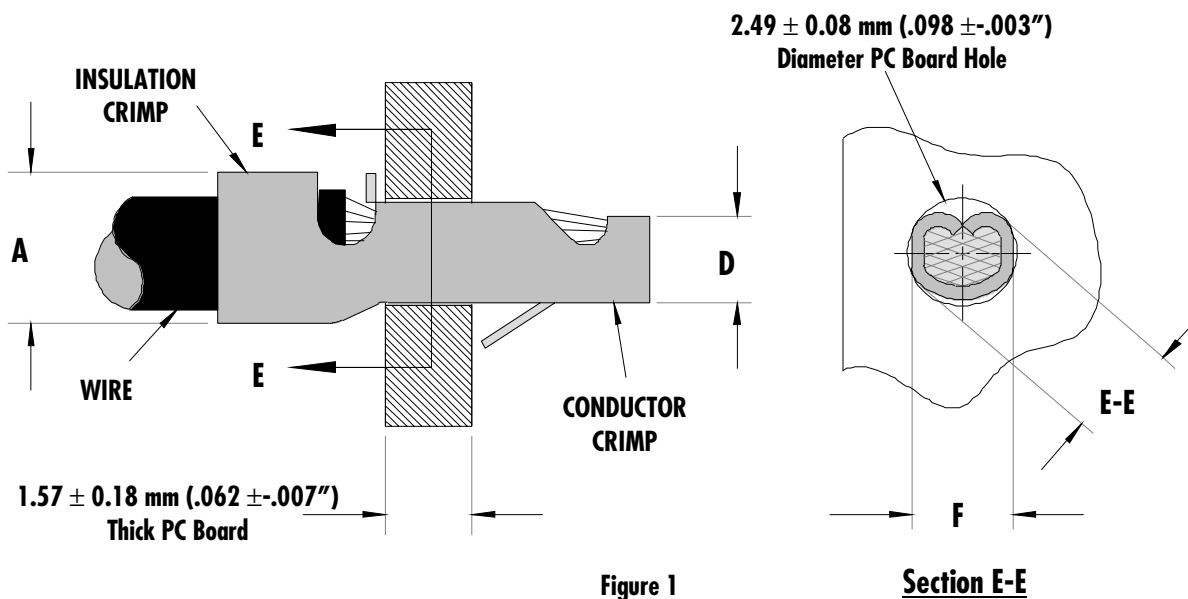
SCOPE

Terminal Series No	Terminal Order No.	Wire Size		Insulation Diameter		Strip Length	
		AWG	mm ²	mm	In.	mm	In.
4706	02-09-2105	16-18	1.30-0.80	2.92 Max.	* .120 Max.	5.97-6.35	.235-.250

* This Tool is for 16-18 AWG wires with .120" Insulation Diameter Max.
For smaller Insulation Diameters to .090" Max. use tool 11-40-2044 (T 8324C).

Terminal Series No.	* Wire Size Non-Standard Applications		Insulation Diameter		Strip Length	
	AWG	mm ²	mm	In.	mm	In.
4706	20-24	0.50-0.20	3.00 Max.	.120 Max.	5.97-6.35	.235-.250

CRIMPED TERMINAL



CRIMP SPECIFICATIONS

After crimping, the conductor profiles should measure the following (See Figure 1).

Terminal Series No.	Wire Size		Dimensions (Figure 1)								Pull Force Min.	
			A-Insulation		D-Conductor (See note below)		F (Ref.)		E-E			
	AWG	mm ²	mm	In.	mm	In.	mm	In.	mm	In.	N	Lb.
4706	16	1.30	2.41-3.18	.095-.125	1.04-1.14	.041-.045	1.96	.077	2.27-2.39	.090-.094	13.30	3.0
4706	18	0.80	2.41-3.18	.095-.125	0.97-1.02	.038-.040	1.96	.077	2.27-2.39	.090-.094	13.30	3.0

Terminal Series No.	Wire Size		* NON-STANDARD APPLICATION Dimensions (Figure 1)								Pull Force Min.	
			A-Insulation		D-Conductor (See note below)		F (Ref.)		E-E			
	AWG	mm ²	mm	In.	mm	In.	mm	In.	mm	In.	N	Lb.
4706	20	0.50	2.41-3.18	.095-.125	0.97-1.02	.038-.040	1.96	.077	2.27-2.39	.090-.094	13.30	3.0
4706	22	0.35	2.41-3.18	.095-.125	0.97-1.02	.038-.040	1.96	.077	2.27-2.39	.090-.094	13.30	3.0
4706	24	0.20	2.41-3.18	.095-.125	0.97-1.02	.038-.040	1.96	.077	2.27-2.39	.090-.094	13.30	3.0

* **For Non-standard applications:** Including but not limited to any combination of conductor material, conductor outside diameter, insulation durometer/material, insulation outside diameter, retention forces, crimp specifications and/or electrical/mechanical specification, and insertion forces. Molex will provide theoretical dimensions and data, which can be used as a guide for our customers' evaluation. However, Molex makes no claims or warranties as to the products used, the Theoretical dimensions and/or data or their suitability or fitness for non-standard applications.

! The crimp on this terminal is not an electrical crimp; the final soldering operation is the electrical connection. This minimum force is what should be expected when pulling the terminal with both insulation and conductor crimped.

Notes:

1. The Conductor crimp (D dimension on Figure 1) should be set at the maximum height to contain all wire strands, meet minimum pull, and fit into the PCB Hole. Shimming may be required of the conductor punch to optimize this for different wire types.

PARTS LIST

Item	Order No	Engineering No.	Description	Quantity
	11-40-2042	T8324A	Terminator (Fig. 2)	REF
1	11-40-4201	8324-11	Conductor Punch	1 Y
2	11-24-1564	7144-24	Conductor Anvil	1 Y
3	11-40-4128	8324-6	Insulation Punch	1 Y
4	11-24-1558	7144-18	Insulation Anvil	1 Y
5	11-40-4126	8324-4	Punch-Barrel Form (Front)	1 Y
6	11-40-4125	8324-3	Punch-Barrel Form (Rear)	1 Y
7	11-24-1562	7144-22	Barrel Form Anvil	1 Y
8	11-24-1041	4996-3	Cut-Off Plunger	1 Y
9	11-40-4124	8324-2	Wire Stop	1 Y
10	11-40-4131	8324-9	Punch Spacer	1
11	11-24-1673	7196-14	Front Plunger Retainer	1
12	11-40-4115	8310-8	Rear Plunger Retainer	1
13	11-24-1067	4996-4	Cut-off Plunger Spring	2
14	11-40-4039	8302-5	Front Plunger Striker	1
15	11-24-1079	4996-11	Front Cut-Off Spring Plate	1
16	11-40-4130	8324-8	Rear Cover	1
17	11-40-4067	8302-101	Stop Finger	1
18	11-40-4068	8302-102	Drag Finger	1
19	11-40-4069	8302-103	Pivot Pin	2
20	11-40-4144	8302-110	Torsion Spring	1
21	11-40-4145	8302-111	Torsion Spring (Stop Finger)	1
22	11-40-4123	8324-1	Terminator Base and track	1
23	N/A	N/A	#4-40 .25 Lg. Fhsc	1**
24	N/A	N/A	#6-32 by .50 Lg. BHCS	1**
25	N/A	N/A	#8-32 by .25 Lg. BHCS	1**
26	N/A	N/A	#8-32 by .38 Lg. BHCS	1**
27	N/A	N/A	#8-32 by .50 Lg. SHCS	2**
28	N/A	N/A	#10-32 by .38 Lg. SHCS	1**
29	N/A	N/A	#10-32 by 1.25 Lg. SHCS	1**
30	N/A	N/A	3/32 Dia. by 1/4 Lg. Roll Pin	1**
31	N/A	N/A	3/64 Dia. by 7/16 Lg. Spirol Pin	2**
	11-40-3042	K8324A	Tool Kit (All Y Items)	REF

** The following purchased parts are available from an Industrial supply company such as MSC (1-800-645-7270).

Assembly Drawing

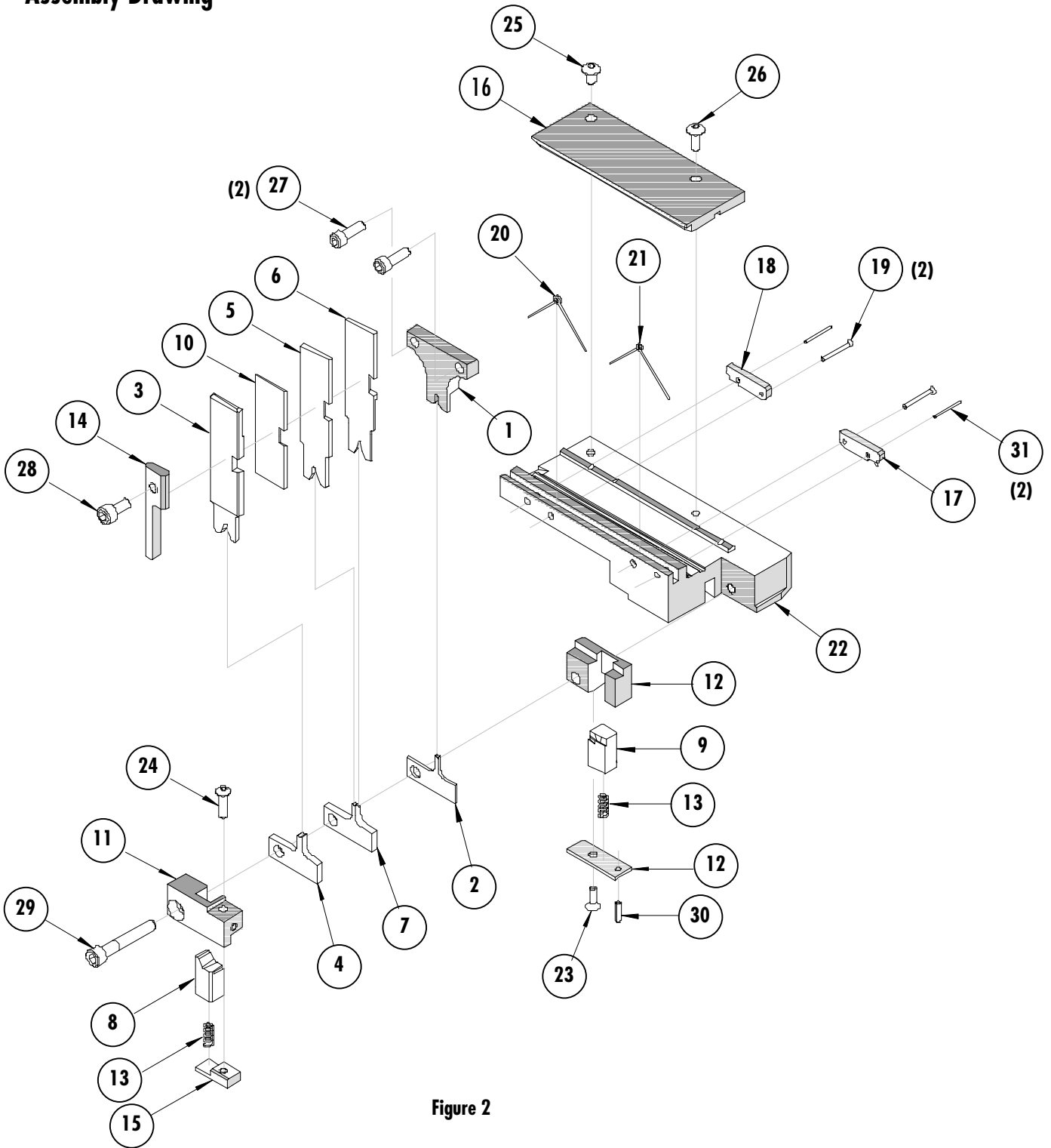


Figure 2

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 only be 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 instruction manual.

CAUTION: Molex crimp specifications are valid only when used with Molex terminals, applicators and tooling.

Molex Application Tooling Group

1150 E. Diehl Road
Naperville, IL 60563
Tel: (630) 969-4550
Fax: (630) 505-0049

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