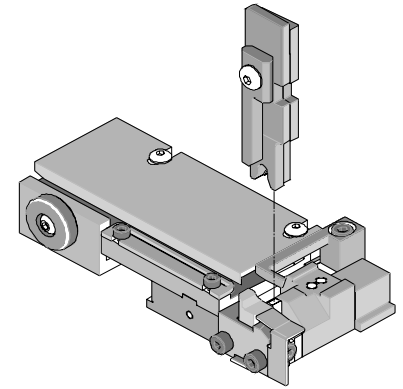




## T2 Terminator Tooling Specification Sheet Part No. 63857-6000



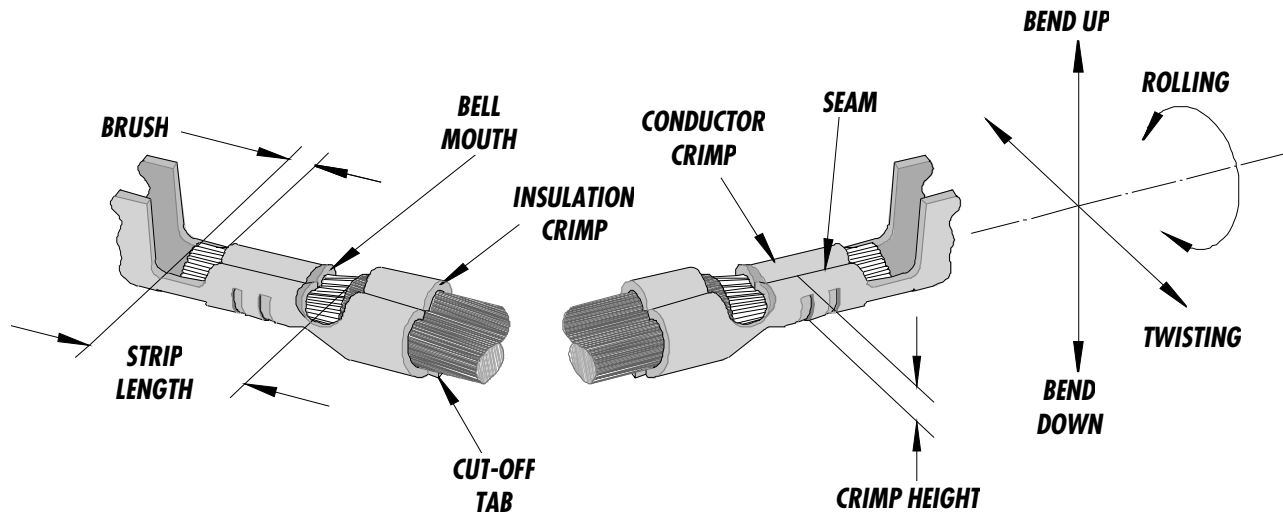
### FEATURES

- *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

Terminal Series No.	Wire Size		Insulation Diameter		Strip Length	
	AWG	mm <sup>2</sup>	mm	In.	mm	In.
35452-9802	16-18	1.31-0.82	3.60 Max	.142 Max	4.80-5.20	.189-.205
35453-9802	16-18	1.31-0.82	3.60 Max	.142 Max	4.80-5.20	.189-.205

### DEFINITION OF TERMS



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

**CRIMP SPECIFICATION**

Terminal Series No.	Bell mouth		Cut-off Tab Max.		Conductor Brush	
	mm	In.	mm	In.	mm	In.
35452-9802	0.30-0.60	.012-.024	0.50	.020	0.30-0.80	.012-.032
35453-9802	0.30-0.60	.012-.024	0.50	.020	0.30-0.80	.012-.032

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
					Conductor		Insulation		
					mm	In	mm	In	
35452-9802	3°	3°	3°	5°	2.7 0	.10 6	4.0 0	.15 7	
35453-9802	3°	3°	3°	5°	2.7 0	.10 6	4.0 0	.15 7	

**After crimping, the crimp profiles should measure the following:**

Terminal Series No.	Wire Size		Conductor				Insulation				Pull Force Min.	
	AWG	mm <sup>2</sup>	Crimp Height		Crimp Width		Crimp Height Max.		Crimp Width		N	Lb.
			mm	In.	mm	In.	mm	In.	mm	In.		
35452-9802	16	1.31	1.60-1.80	.063-.071	2.69-2.91	.106-.115	4.40	.173	4.00	.157	176.4	39.7
35452-9802	18	0.82	1.30-1.50	.051-.059	2.69-2.91	.106-.115	4.40	.173	4.00	.157	122.6	27.6
35453-9802	16	1.31	1.60-1.80	.063-.071	2.69-2.91	.106-.115	4.40	.173	4.00	.157	176.4	39.7
35453-9802	18	0.82	1.30-1.50	.051-.059	2.69-2.91	.106-.115	4.40	.173	4.00	.157	122.6	27.6

\* **Tool Qualification Notes:**

1. This Terminator was qualified to the above specifications with UL1015 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**

<b>Item</b>	<b>Order No</b>	<b>Engineering No.</b>	<b>Description</b>	<b>Quantity</b>
	<b>63857-6000</b>	<b>63857-6000</b>	<b>T2 Terminator (Fig. 1)</b>	<b>REF</b>
<b>1</b>	<b>63444-2725</b>	<b>63444-2725</b>	<b>Conductor Punch</b>	<b>1 Y</b>
<b>2</b>	<b>63445-2778</b>	<b>63445-2778</b>	<b>Conductor Anvil</b>	<b>1 Y</b>
<b>3</b>	<b>63446-4025</b>	<b>63446-4025</b>	<b>Insulation Punch</b>	<b>1 Y</b>
<b>4</b>	<b>63445-4048</b>	<b>63445-4048</b>	<b>Insulation Anvil</b>	<b>1 Y</b>
<b>5</b>	<b>63443-0035</b>	<b>63443-0035</b>	<b>Cut-Off Plunger Front</b>	<b>1 Y</b>
<b>6</b>	<b>63443-0036</b>	<b>63443-0036</b>	<b>Plunger Retainer Front</b>	<b>1 Y</b>
<b>7</b>	<b>63700-0539</b>	<b>63700-0539</b>	<b>Cut-off Plunger Spring</b>	<b>1</b>
<b>8</b>	<b>63443-3160</b>	<b>63443-3160</b>	<b>Plunger Striker Front</b>	<b>1</b>
<b>9</b>	<b>63443-0021</b>	<b>63443-0021</b>	<b>Lower Tooling Key</b>	<b>1</b>
<b>10</b>	<b>63443-6013</b>	<b>63443-6013</b>	<b>Rear Cover</b>	<b>1</b>
<b>11</b>	<b>11-18-4083</b>	<b>60707-8</b>	<b>Front Cover</b>	<b>1</b>
<b>12</b>	<b>63443-2506</b>	<b>63443-2506</b>	<b>Anvil Mount</b>	<b>1</b>
<b>13</b>	<b>63800-8504</b>	<b>63800-8504</b>	<b>Wire Stop</b>	<b>1</b>
<b>14</b>	<b>63443-0009</b>	<b>63443-0009</b>	<b>Scrap Chute Front</b>	<b>1</b>
<b>15</b>	<b>63800-8800</b>	<b>63800-8800</b>	<b>Wide Track T2 Terminator</b>	<b>1</b>
<b>16</b>	<b>N/A</b>	<b>N/A</b>	<b>M3 by 6Lq. SHCS</b>	<b>2**</b>
<b>17</b>	<b>N/A</b>	<b>N/A</b>	<b>M4 by 6Lq. SHCS</b>	<b>1**</b>
<b>18</b>	<b>N/A</b>	<b>N/A</b>	<b>M4 by 12Lq. BHCS</b>	<b>2**</b>
<b>19</b>	<b>N/A</b>	<b>N/A</b>	<b>M4 by 50Lq. SHCS</b>	<b>2**</b>
<b>20</b>	<b>N/A</b>	<b>N/A</b>	<b>M4 by 12Lq. SHCS</b>	<b>1**</b>
<b>21</b>	<b>N/A</b>	<b>N/A</b>	<b>3MM by 6Lq. Roll Pin</b>	<b>1**</b>
<b>22</b>	<b>N/A</b>	<b>N/A</b>	<b>#10-32 by 3/8"Lq. BHCS</b>	<b>1**</b>
	<b>63857-6070</b>	<b>63857-6070</b>	<b>Tool Kit (All Y Items)</b>	<b>REF</b>

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

Assembly Drawing

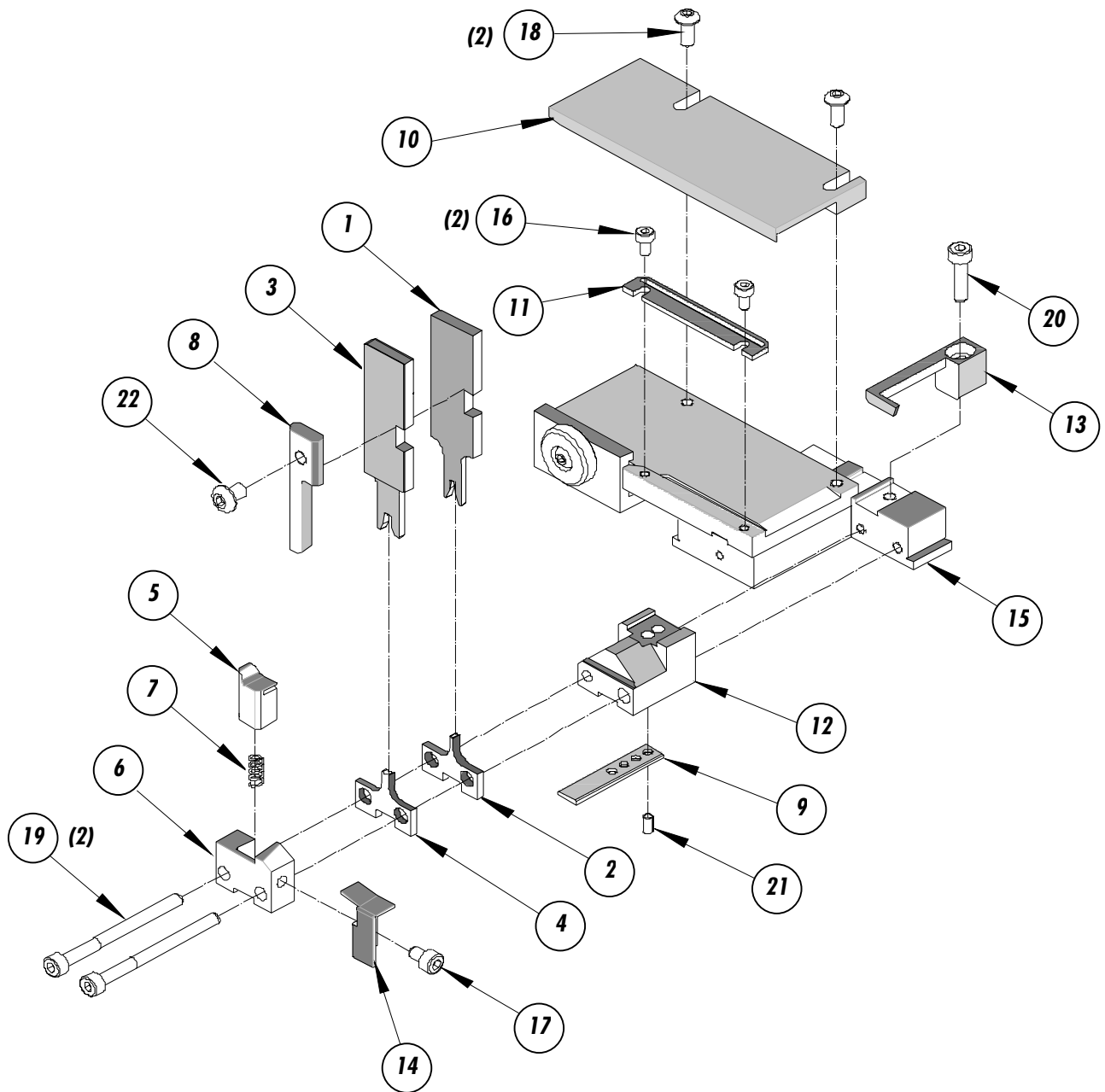


Figure 1

**NOTES**

Depending on the press vintage a feed finger assembly is supplied with the T2 Terminator.

1. To remove the existing feed finger assembly loosen 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).

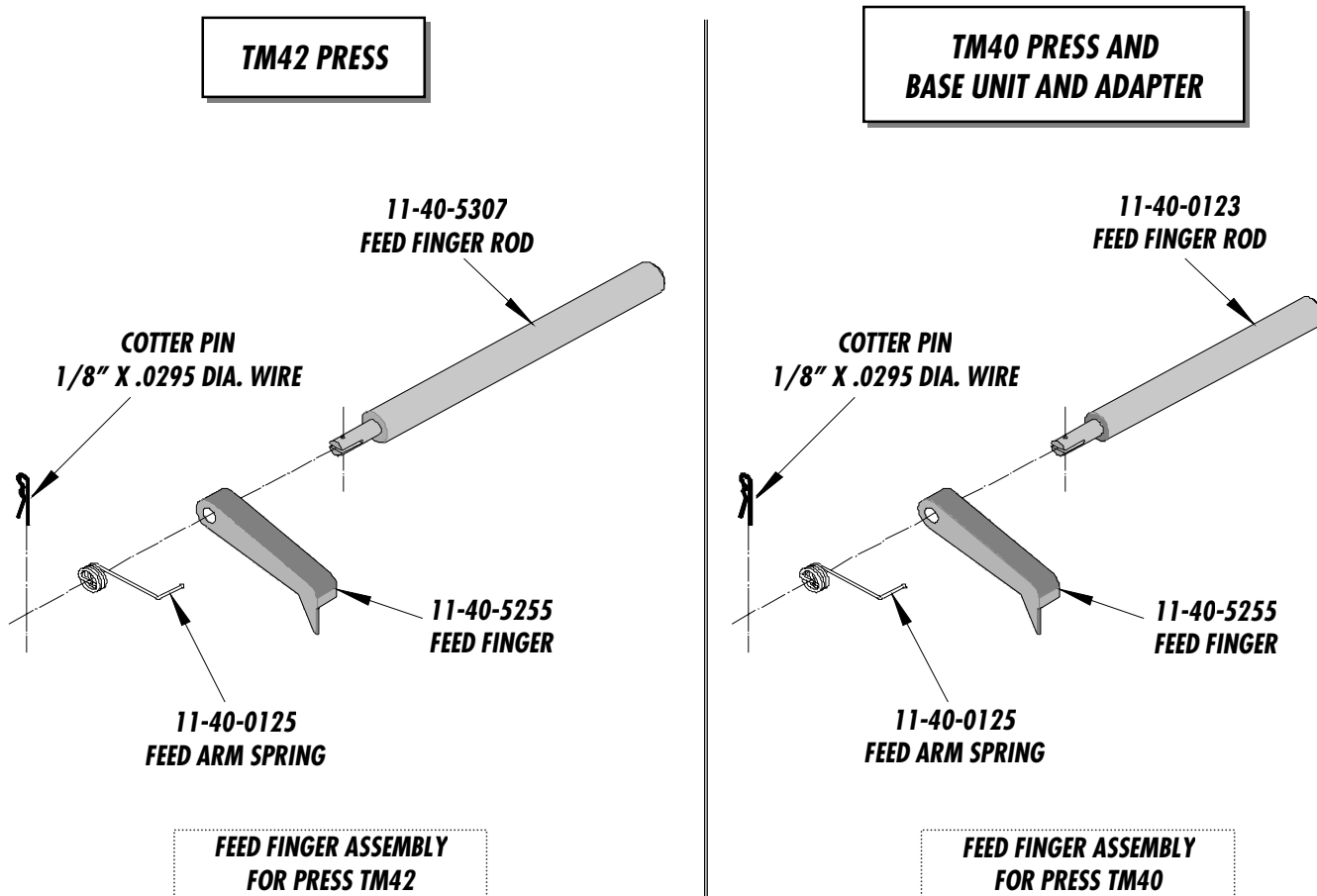


Figure 2

## 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.**

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