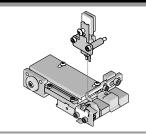
T2 Terminator Tooling



Application Tooling Specification Sheet



Order No. 63911-2300

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 tablength
- T2 Terminator has standardized tooling with the Molex FineAdjust Applicator which will reduce your inventory requirements

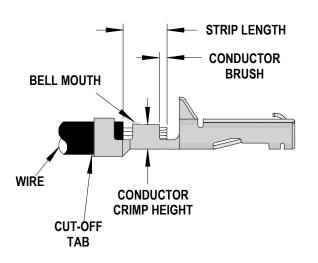
SCOPE

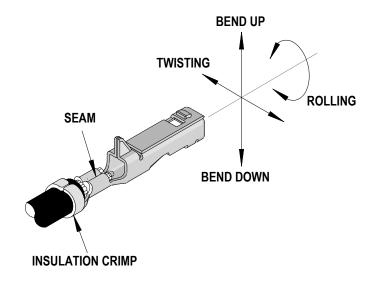
Products: 3.96 (.156") Wire-to-Wire and Wire-to-Board Crimp Terminal, 16-22 AWG.

Tarminal	Terminal Order No.	Wire Size and Type			Insulation	Strip Length			
Terminal Series No.				IPC/WHM	A-A620 (1)	Terminal (2)		Suip Lengui	
Series No.		AWG	Type	mm	ln.	mm	ln.	mm	ln.
50597	50597-8000	16-22	UL 1015	2.40-3.30	.094129	2.40-3.30	.094129	2.70-3.30	.106130
		16-18	UL 1007	2.00-2.50	.079098	2.00-2.50	.079098		
50599	50599-8000	16-22	UL 1015	2.40-3.30	.094129	2.40-3.30	.094129	2.70-3.30	.106130
		16-18	UL 1007	2.00-2.50	.079098	2.00-2.50	.079098		

⁽¹⁾ To achieve optimum IPC-A620 Class 2 insulation crimps, use this insulation OD range

DEFINITION OF TERMS





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⁽²⁾ Overall insulation OD specification for terminal

CRIMP SPECIFICATION

	Terminal Series No.	Bell n	nouth	Cut-off Tab	Maximum	Conductor Brush		
rem	reminal Series No.	mm	ln.	mm	ln.	mm	ln.	
	50597	0.10-0.60	.004024	0.25	.010	0.00-1.00	.000039	
	50599	0.10-0.60	.004024	0.25	.010	0.00-1.00	.000039	

	Dand up [Twist Roll -		Punch Width mm (Ref)				Seam	
Terminal Series No.	Dena up			Conductor		Insulation]	
	Degree			mm	ln	mm	ln	Seam shall not be open	
50597	4	3	3	8	2.00	.078	3.00	.118	and no wire allowed out
50599	4	3	3	8	2.00	.078	3.00	.118	of the crimping area

After crimping, the crimp profiles should measure the following:

Terminal Series No.	Wire Size and Type		Conductor (Crimp Height		rimp Height ef)	Pull Force Minimum	
	AWG	Type	mm	ln.	mm	ln.	N	Lb.
	16 AWG	UL 1015	1.21-1.31	.047052	3.80	.150	127.40	28.6
	18 AWG	UL 1015	1.16-1.26	.045050	3.70	.146	88.20	19.8
50597	20 AWG	UL 1015	1.02-1.12	.040044	3.65	.144	58.80	13.2
50597	22 AWG	UL 1015	0.97-1.02	.038040	3.50	.138	39.20	8.8
	16 AWG	UL 1007	1.21-1.31	.047052	3.70	.146	127.40	28.6
	18 AWG	UL 1007	1.16-1.26	.045050	3.30	.130	88.20	19.8
	16 AWG	UL 1015	1.21-1.31	.047052	3.80	.150	127.40	28.6
	18 AWG	UL 1015	1.16-1.26	.045050	3.70	.146	88.20	19.8
50599	20 AWG	UL 1015	1.02-1.12	.040044	3.65	.144	58.80	13.2
50599	22 AWG	UL 1015	0.97-1.02	.038040	3.50	.138	39.20	8.8
	16 AWG	UL 1007	1.21-1.31	.047052	3.70	.146	127.40	28.6
	18 AWG	UL 1007	1.16-1.26	.045050	3.30	.130	88.20	19.8

Tool Qualification Notes:

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

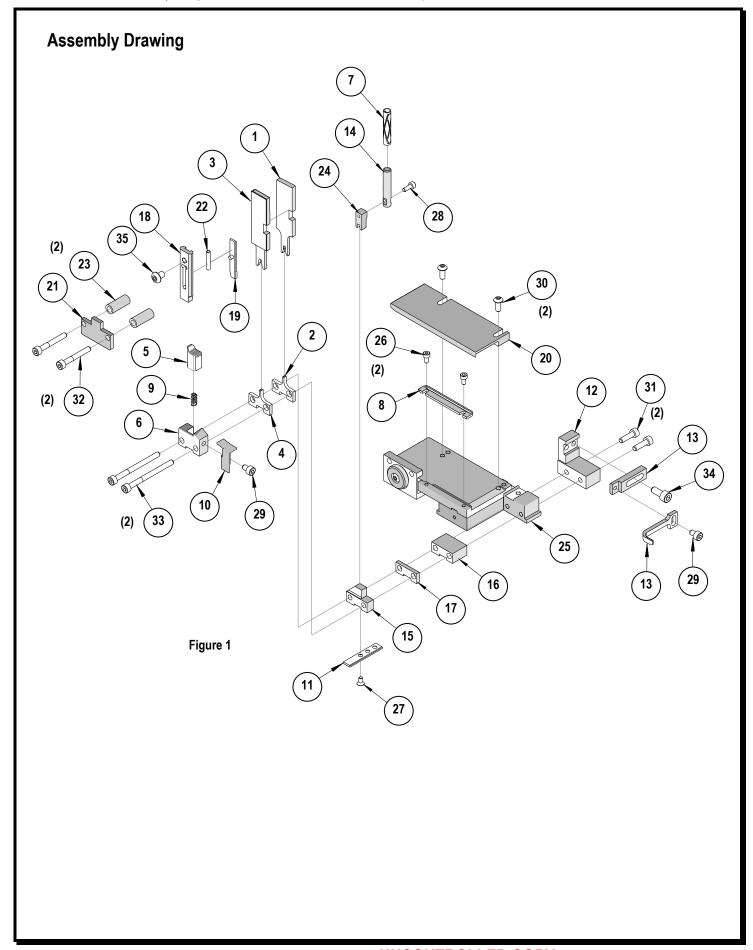
2. The above specifications are guidelines to an optimum crimp.

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PARTS LIST

Terminator 63911-2300										
Item	Order No Engineering No. Description									
Perishable Tooling										
	63911-2370	63911-2370	Tool Kit (All "Y" Items)	REF						
1	63444-2005	63444-2005	Conductor Punch	1 Y						
2	63445-2019	63445-2019	Conductor Anvil	1 Y						
3	63446-3018	63446-3018	Insulation Punch	1 Y						
4	63445-3033	63445-3033	Insulation Anvil	1 Y						
5	63443-0005	63443-0005	Cut-Off Plunger	1 Y						
6	63443-0012	63443-0012	Front Plunger Retainer	1 Y						
	Other Components									
7	11-17-0022	1739-21	Hold Down Spring	1						
8	11-18-4083	60707-8	Feed Guide	1						
9	11-24-1067	4996-4	Cut-off Plunger Spring	1						
10	63443-0009	63443-0009	Front Scrape Chute	1						
11	63443-0024	63443-0024	Key	1						
12	63443-0085	63443-0085	Wire Stop L-Bracket	1						
13	63443-0090	63443-0090	Wire Stop	1						
14	63443-0093	63443-0093	Shank	1						
15	63443-1719	63443-1719	Height Spacer	1						
16	63443-2216	63443-2216	Coarse Spacer (16.00mm)	1						
17	63443-2301	63443-2301	Fine Spacer (3.05mm)	1						
18	63443-2802	63443-2802	Front Plunger Striker	1						
19	63443-2910	63443-2910	Wire Hold Down Plunger	1						
20	63443-6007	63443-6007	Rear Cover	1						
21	63443-7201	63443-7201	Spring Cover	1						
22	63600-1057	63600-1057	Compression Spring	1						
23	63600-2972	63600-2972	Collar	2						
24	63901-9802	63901-9802	Terminal Hold Down	1						
		Fra	me							
25	63800-8500	63800-8500	T2 Terminator	1						
		Hard	ware							
26	N/A	N/A	M3 by 6 Long SHCS	2**						
27	N/A	N/A	M3 by 6 Long FHCS	1**						
28	N/A	N/A	M3 by 8 Long SHCS	1**						
29	N/A	N/A	M4 by 6 Long SHCS	2**						
30	N/A	N/A	M4 by 12 Long BHCS	2**						
31	N/A	N/A	M4 by 14 Long SHCS	2**						
32	N/A	N/A	M4 by 30 Long SHCS	2**						
33	N/A	N/A	M4 by 50 Long SHCS	2**						
34	N/A	N/A	M5 by 12 Long SHCS	1**						
35	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).										

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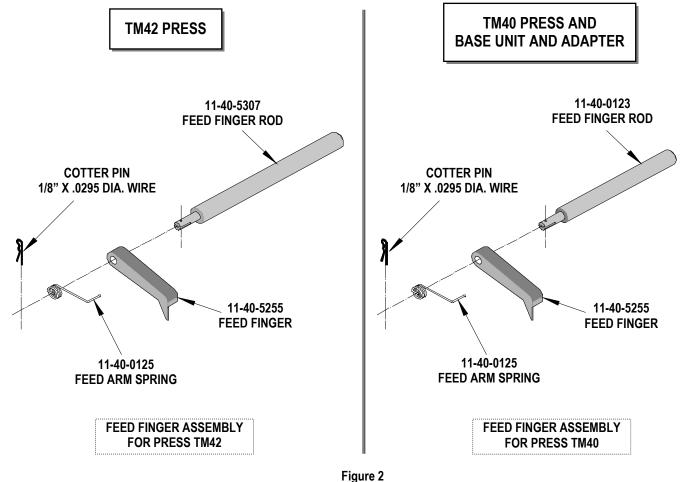


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NOTES

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).



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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, terminator s and tooling.

http://www.molex.com

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