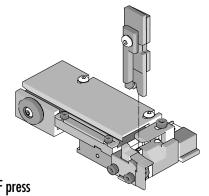


T2 Terminator Tooling Specification Sheet Part No. 63854-4000



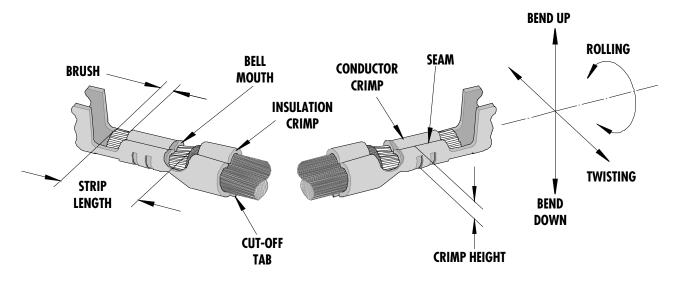
FEATURES

- 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
- Also available: 63854-4100 with full radius insulation punch recommended for large and max. insulation diameter, (See Scope)

SCOPE

Terminal Series No.	Terminal Order No.	Wire Size		Insulation	Diameter	Strip Length	
	reminiai Oraei No.	AWG	mm²	mm	ln.	mm	ln.
42477	02-09-1615	14-18	0.81-2.07	2.36-3.56	.093140	3.96-5.33	.156218
42478	02-09-2611	14-18	0.81-2.07	2.36-3.56	.093140	3.96-5.33	.156218
424/0	02-09-2612						

DEFINITION OF TERMS



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

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CRIMP SPECIFICATION

Terminal Series No.	Bell n	nouth	Cut-off 1	Tab Max.	Conductor Brush		
Terminur Series No.	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 E	Bend down	Twist Ro		Punch Width mm (Ref)			Ref)			
Terminal Series No.	Degree		Degree		Conductor		Insulation		Seam Seam shall not be open and		
					mm	ln	mm	In	no wire allowed out		
42477	3	3	4	8	2.30	.090	3.60	.141	of the crimping area		
42478	3	3	4	8	2.30	.090	3.60	.141	or me crimping area		

After crimping, the conductor profile should measure the following.

Terminal Series No.	Wire Size		Crimp	Height	Pull Force Min.	
Terminur Series No.	AWG	mm²	mm	ln.	N	Lb.
42477	14	2.07	1.91-1.80	.075071	222.4	50.00
42477	16	1.31	1.70-1.60	.067063	177.9	40.00
42477	18	0.81	1.55-1.47	.061058	115.6	26.00
42478	14	2.07	1.91-1.80	.075071	222.4	50.00
42478	16	1.31	1.70-1.60	.067063	177.9	40.00
42478	18	0.81	1.55-1.47	.061058	115.6	26.00

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

The above specifications are guidelines to an optimum crimp.

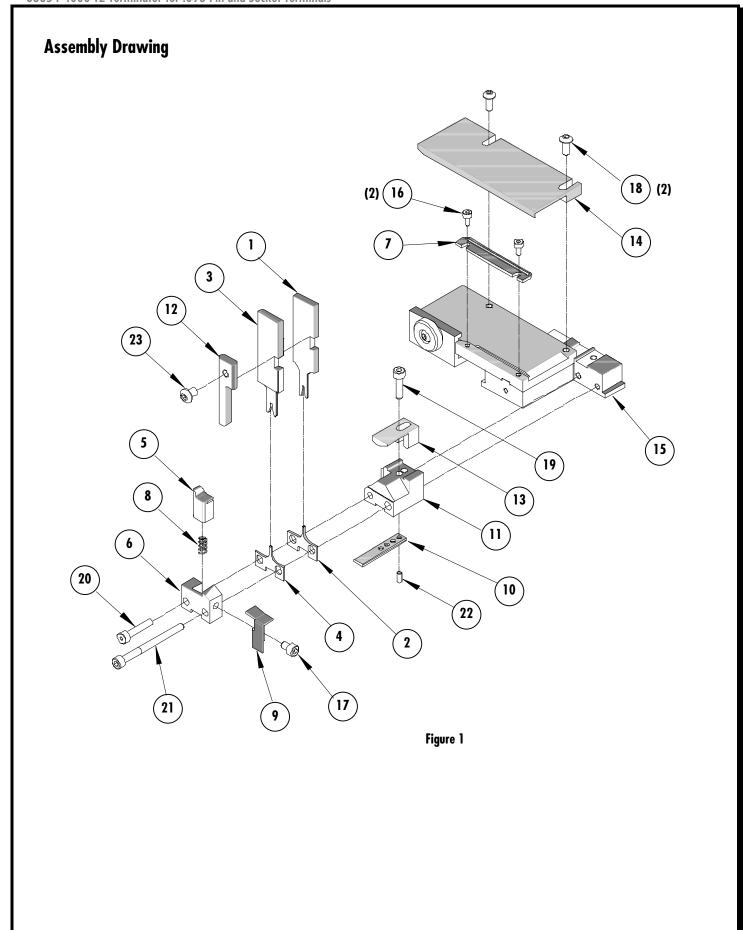
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PARTS LIST

	T2 Terminator 63854-4000								
Item	Order No	Quantity							
	Perishable Tooling								
	63854-4070	63854-4070	Tool Kit (All "Y" Items)	REF					
1	63444-2323	63444-2323	Conductor Punch	1 Y					
2	63445-2348	63445-2348	Conductor Anvil	1 Y					
3	63446-3607	63446-3607	Insulation Punch	1 Y					
4	63445-3613	63445-3613	Insulation Anvil	1 Y					
5	63443-0002	63443-0002	Cut-Off Plunger	1 Y					
6	63443-0012	63443-0012	Front Plunger Retainer	1 Y					
		Other Com	ponents						
7	11-18-4083	60707-8	Front Cover]					
8	11-24-1067	4996-4	Cut-off Plunger Spring]					
9	63443-0009	63443-0009	Scrape Chute]					
10	63443-0021	63443-0021	Lower Tooling Key	1					
11	63443-2417	63443-2417	Anvil Mount]					
12	63443-3160	63443-3160	Front Plunger Striker	1					
13	63443-4006	63443-4006	Wire Stop]					
14	63443-6011	63443-6011	Rear Cover]					
	Frame								
15	63800-8500	63800-8500	T2 Terminator Frame	1					
	Hardware								
16	N/A	N/A	M3 by 6Lg. SHCS	2**					
17	N/A	N/A	M4 by 6Lg. SHCS]**					
18	N/A	N/A	M4 by 12Lg. BHCS	2**					
19	N/A	N/A	M4 by 16Lg SHCS]**					
20	N/A	N/A	M4 by 20Lg. SHCS]**					
21	N/A	N/A	M4 by 50Lg. SHCS]**					
22	N/A	N/A	3MM by 6Lg. Roll Pin]**					
23	N/A	N/A	#10-32 by 1/4"Lg. BHCS]**					
**	** Available from an industrial supply company such as MSC (1-800-645-7270).								

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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).

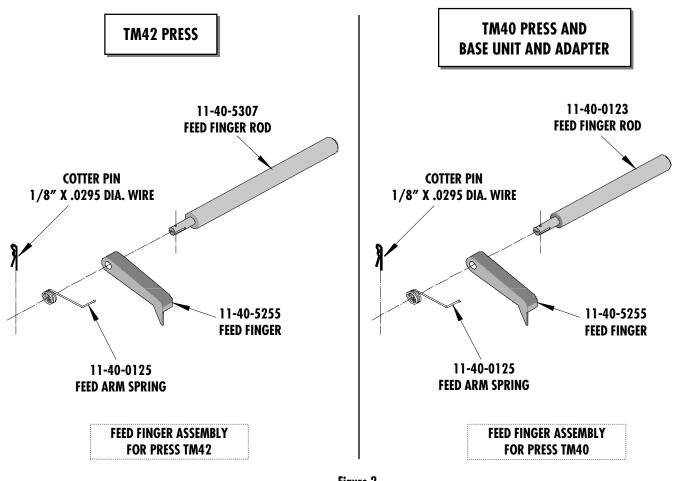


Figure 2

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NOTES

- Molex recommends an extra perishable tooling kit be maintained at your facility.
- Verify tooling alignment by manually cycling the press before crimping under power. Check that all screws are tight.
- Slugs, Terminals, Dirt and Oil should be kept clear of work area.
- 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.

Molex Application Tooling Group

2200 Wellington Court Lisle, IL 60532 Tel: (630) 969-4550 Fax: (630) 505-0049

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

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