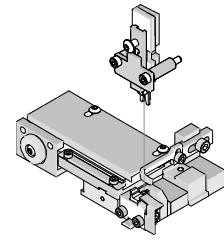




T2 Terminator Tooling

Application Tooling Specification Sheet



Order No. 63912-5900

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

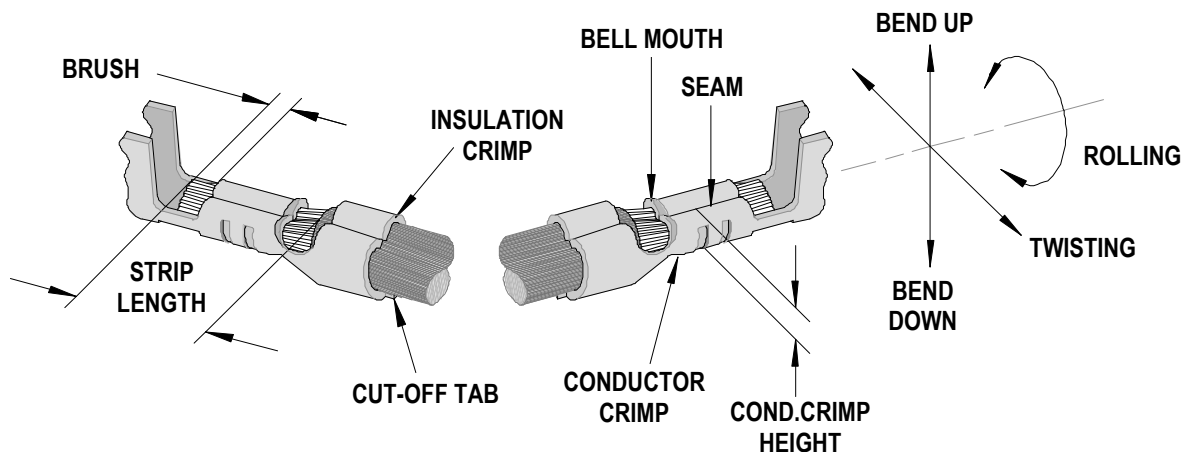
SCOPE

Products: 1.20mm (0.47") Pitch Pico-EZmate™ Wire-to-Board Crimp Terminal, 28-30 AWG.

Terminal Series No.	Terminal Order No.	Wire Size		Insulation Diameter				Strip Length	
		AWG	mm ²	IPC/WHMA-A620 (1)		Terminal (2)		mm	In.
				mm	In.	mm	In.		
✗78172	78172-0410	28-30	0.08-0.05	0.50-0.70	.020-.028	0.50-0.70	.020-.028	0.90-1.30	.035-.051
	78172-0411								

✗ Oiler is required for this applicator due to gold plating on terminal.
 Oiler order number 63801-7240 (See Part Number 63801-7240 on Molex Web)
 (1) To achieve optimum IPC-A620 insulation crimps, use this insulation OD range.
 (2) Overall insulation OD specification for terminal.

DEFINITION OF TERMS



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

CRIMP SPECIFICATION

Terminal Series No.	Bell mouth		Cut-off Tab Maximum		Conductor Brush	
	mm	In.	mm	In.	mm	In.
78172	0.05-0.15	.002-.006	0.05	.002	0.15-0.70	.006-.028

Terminal Series No.	Bend up	Bend down	Twist	Roll	Punch Width mm (Ref)				Seam Seam shall not be open and no wire allowed out of the crimping area
	Degree		Degree		Conductor		Insulation		
					mm	In	mm	In	
78172	3	3	2	3	0.80	.031	0.80	.031	

After crimping, the conductor profile should measure the following.

Terminal Series No.	Wire Size		Conductor Crimp				Pull Force Minimum	
	AWG	mm ²	Crimp Height		Crimp Width (Ref.)		N	Lb.
			mm	In.	mm	In.		
78172	28	0.08	0.44-0.48	.017-.019	0.85	.033	10.0	2.25
	30	0.05	0.40-0.44	.015-.017	0.85	.033	5.0	1.12

Terminal Order No.	Wire Size		Insulation			
	AWG	mm ²	Crimp Height		Crimp Width (Ref.)	
			mm	In.	mm	In.
78172-0410	28	0.08	0.73-0.77	.028-.030	0.85	.033
	30	0.05	0.71-0.75	.027-.029	0.85	.033
78172-0411	28	0.08	0.77-0.81	.030-.032	0.85	.033
	30	0.05	0.75-0.79	.029-.031	0.85	.033

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.

PARTS LIST

T2 Terminator 63912-5900				
Item	Order No	Engineering No.	Description	Quantity
Perishable Tooling				
	63912-5970	63912-5970	Tool Kit (All "Y" Items)	REF
1	63457-0046	63457-0046	Conductor Punch	1 Y
2	63455-0059	63455-0059	Conductor Anvil	1 Y
3	63454-0082	63454-0082	Insulation Punch	1 Y
4	63456-0054	63456-0054	Insulation Anvil	1 Y
5	63443-0003	63443-0003	Front Cut-Off Plunger	1 Y
6	63443-0012	63443-0012	Front Plunger Retainer	1 Y
Other Components				
7	11-24-1067	4996-4	Cut-off Plunger Spring	1
8	63443-0009	63443-0009	Scrap Chute	1
9	63443-0025	63443-0025	Key	1
10	63443-0085	63443-0085	Wire Stop L-Bracket	1
11	63443-0090	63443-0090	Wire Stop	1
12	63443-2217	63443-2217	Coarse Spacer (17.00mm)	2
13	63443-2314	63443-2314	Fine Spacer (3.70mm)	1
14	63443-2805	63443-2805	Front Plunger Striker	1
15	63443-2902	63443-2902	Hold Down Plunger	1
16	63443-6017	63443-6017	Rear Cover	1
17	63443-7201	63443-7201	Spring Cover	1
18	63600-0021	63600-0021	Compression Spring	1
19	63600-2972	63600-2972	Collar	2
20	63890-0058	63890-0058	Height Spacer	1
21	63901-1301	63901-1301	Feed Guide	1
Frame				
22	63800-8800	63800-8800	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	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).				

Assembly Drawing

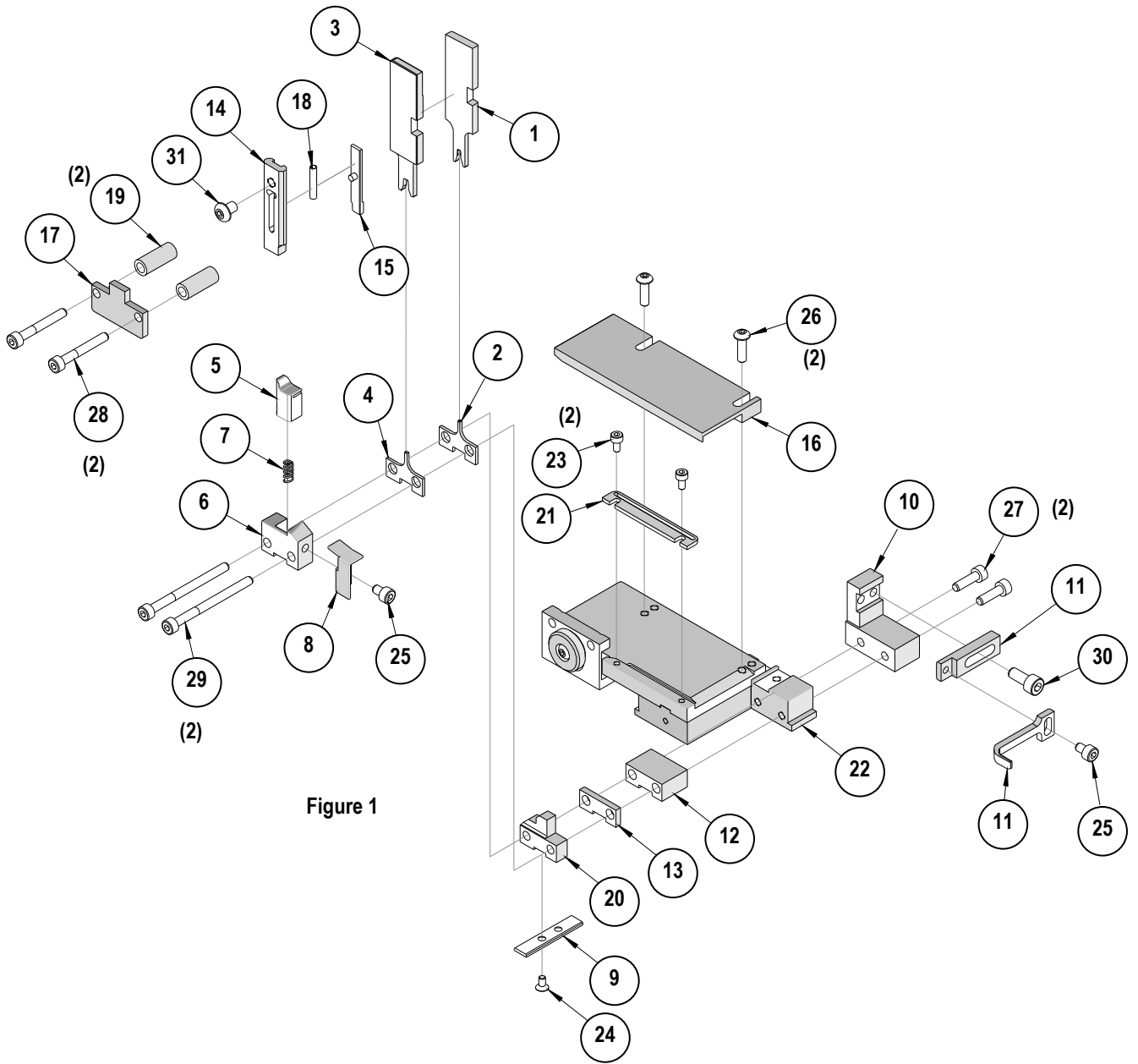


Figure 1

NOTES

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

1. To remove the existing feed finger assembly 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).

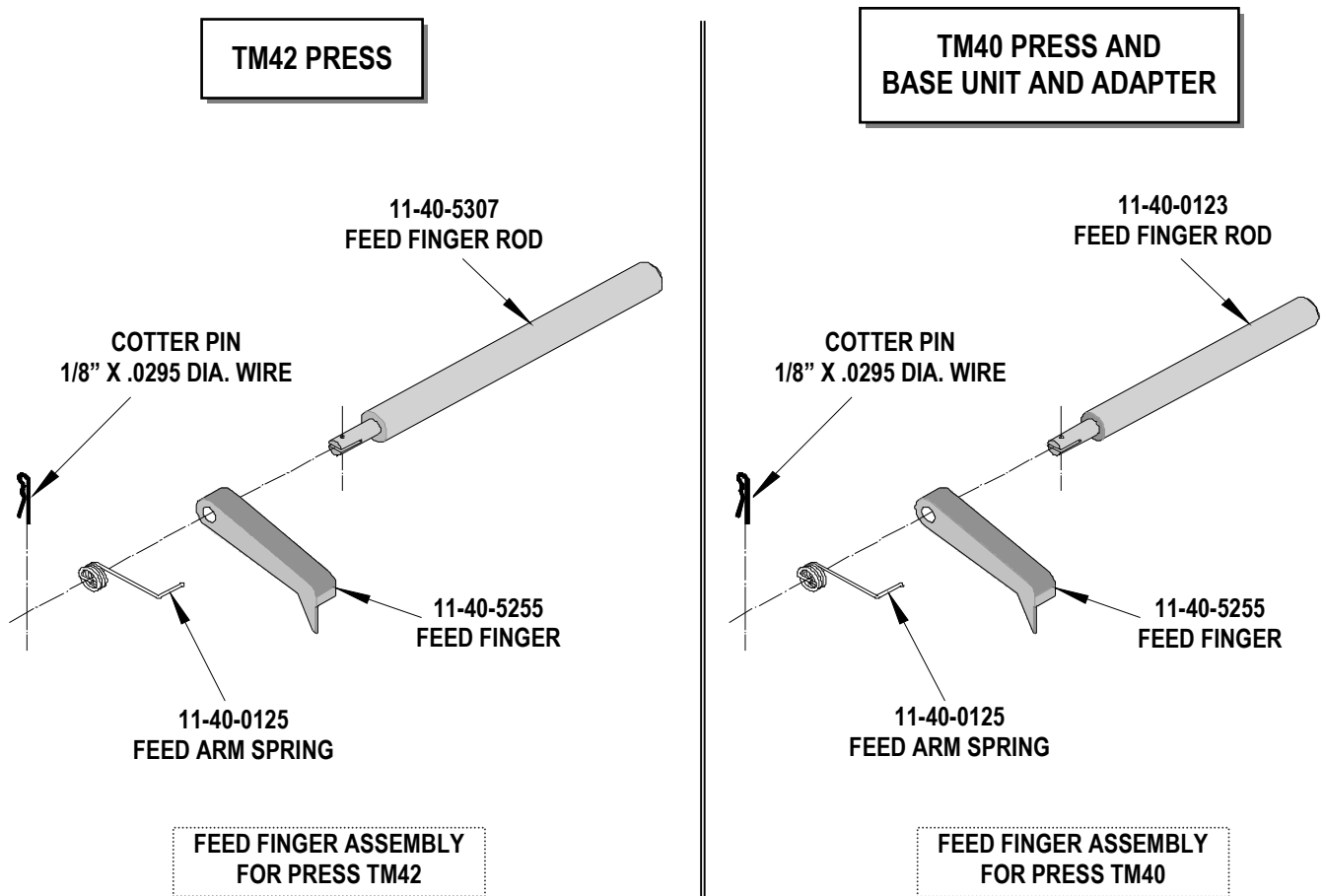


Figure 2

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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