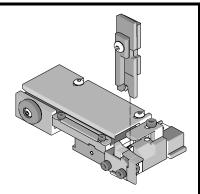
T2 Terminator Tooling Specification Sheet Part No. 63857-2000



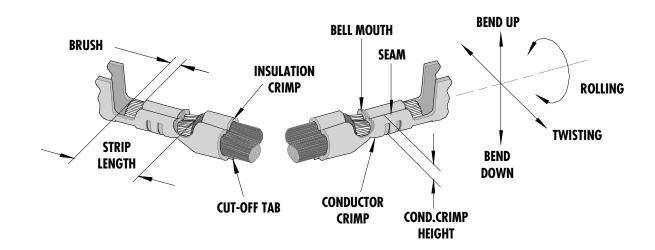
FEATURES

- 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	Wire Size		Insulation	Diameter	Strip Length	
Series No.	AWG	mm ²	mm	ln.	mm	In.
5194	18-24	0.80-0.20	1.30-3.00	.051118	3.00-3.50	.118138

DEFINITION OF TERMS



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

Release Date: 10-15-04 Revision Date: 10-15-04

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CRIMP SPECIFICATION

Terminal	Bell r	nouth	Cut-off 1	ab Max.	Conductor Brush	
Series No.	mm	ln.	mm	ln.	mm	In.
5194	0.20-0.70	.008028	0.40	.016	0.00-1.00	.000039

Terminal	Bend up Bend down		Twist	Roll	Punch Width mm (Ref)		(Ref)	Seam		
Series No.	Degree		Degree		Conductor		Insulation		Seam shall not be open	
Jelles NO.					mm	In	mm	In	and no wire allowed out of	
5194	6	0	3	8	1.60	.063	2.80	.110	the crimping area	

After crimping, the conductor profile should measure the following.

Terminal	Wire Size		Cond	uctor	Pull Force Min.	
Series No.	wite	JIZE	Crimp	Height	i un i uice Min.	
	AWG	mm ²	mm	In.	Ν	Lb.
5194	18	0.80	1.10-1.20	.043047	88.1	19.80
5194	20	0.50	1.07-1.17	.042046	58.7	13.20
5194	22	0.35	0.96-1.06	.038042	39.1	8.80
5194	24	0.20	0.90-1.00	.035039	29.4	6.60

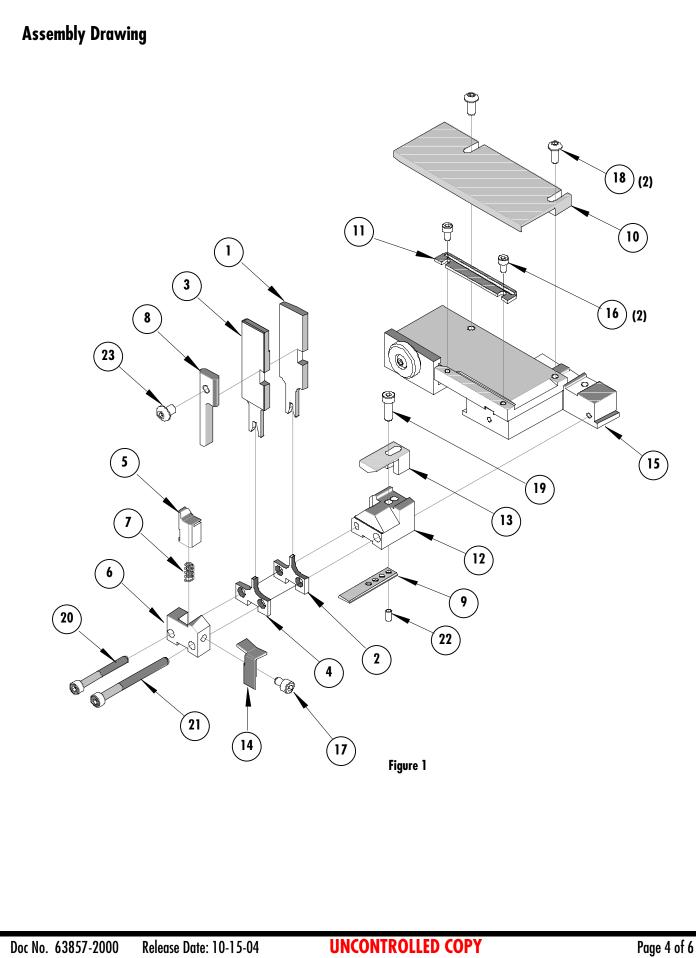
Pull Force should be measured with no influence from the insulation crimp.

The above specifications are guidelines to an optimum crimp.

PARTS LIST

ltem	Order No	Engineering No. Description		Quantity
	63857-2000	63857-2000	T2 Terminator (Fig. 1)	REF
1	63444-1605	63444-1605	Conductor Punch	1 Y
2	63445-1641	63445-1641	Conductor Anvil	1 Y
3	63446-2827	63446-2827	Insulation Punch	1 Y
4	63445-2835	63445-2835	Insulation Anvil	1 Y
5	63443-0002	63443-0002	Cut-Off Plunger	1 Y
6	63443-0012	63443-0012	Front Plunger Retainer	1 Y
7	11-24-1067	4996-4	Cut-Off Plunger Spring	1
8	11-40-4039	8302-5	Front Plunger Striker	1
9	63443-0021	63443-0021	Lower Tooling Key	1
10	63443-6003	63443-6003	Rear Cover	1
11	11-18-4083	60707-8	Front Cover	1
12	63443-2425	63443-2425	Anvil Mount	1
13	63443-4005	63443-4005	Wire Stop	1
14	63443-0009	63443-0009	Scrap Chute	1
15	63800-8500	63800-8500	T2 Terminator	1
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 3/8"Lg. BHCS	**
	63857-2070	63857-2070	Tool Kit (All Y Items)	REF

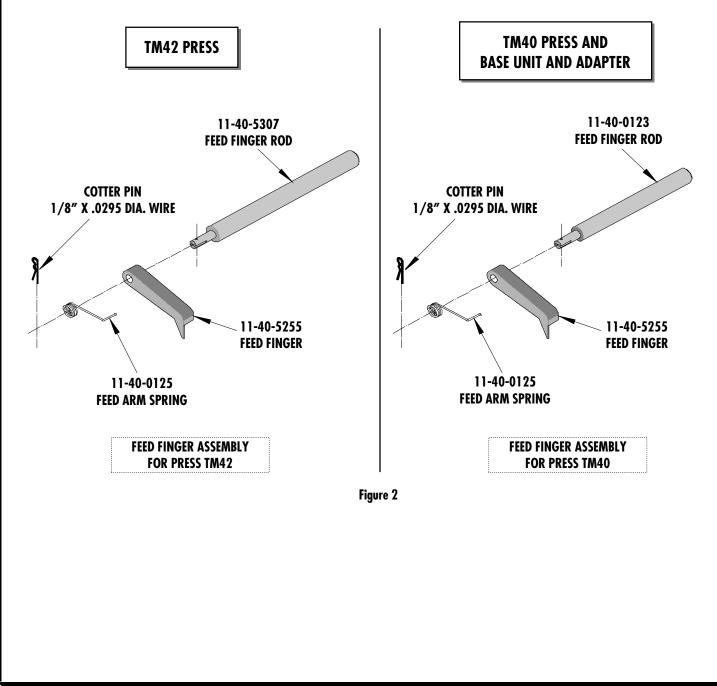
** The following purchased parts are available from an Industrial supply company such as MSC (1-800-645-7270).



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).



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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