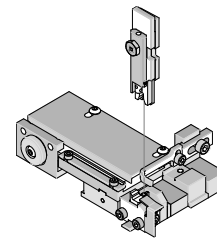


## T2 Terminator Tooling

# molex

## Application Tooling Specification Sheet


**Order No. 63911-3100**

## FEATURES

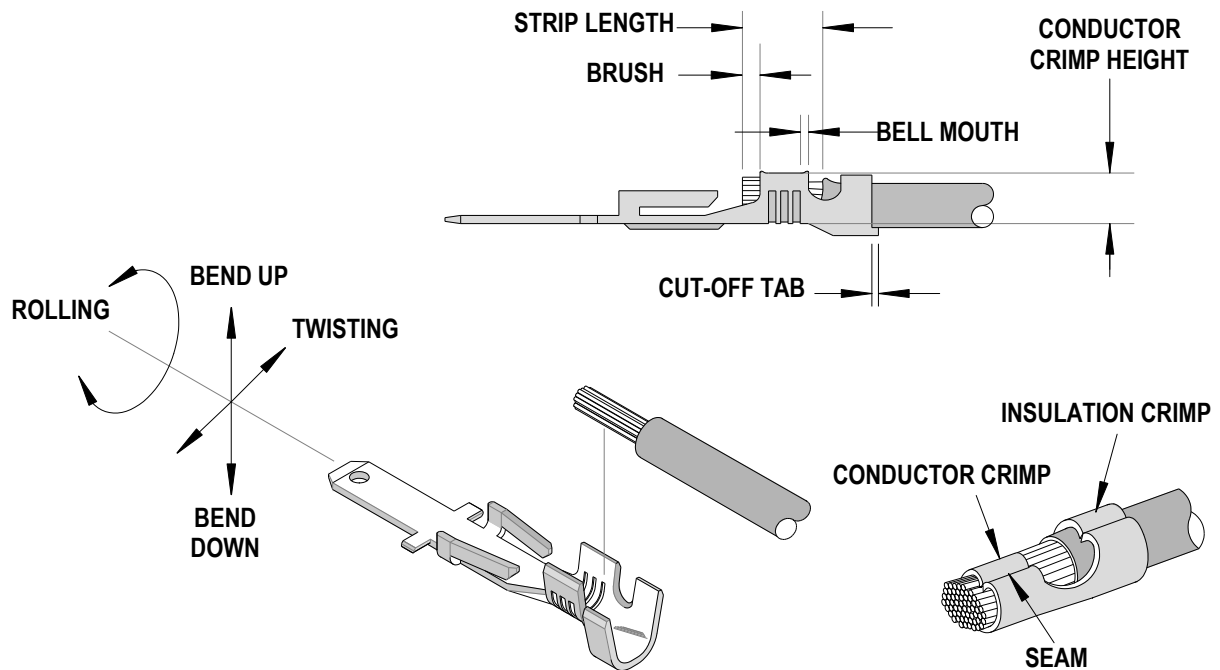
- It is ideally suited for mid-volume bench operations
- This terminator can be installed in the TM42 and the TM40 press or Base Unit adapter for 3BF press
- Quick punch removal with the push of a button for fast and easy tooling change
- Track adjustment capabilities in the T2 Terminators for improved 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: Sabre™ Male Flat Blade Crimp Terminal, (2) 18 AWG (UL1015), and (2) 20 AWG (UL1015) wire stacked vertically.

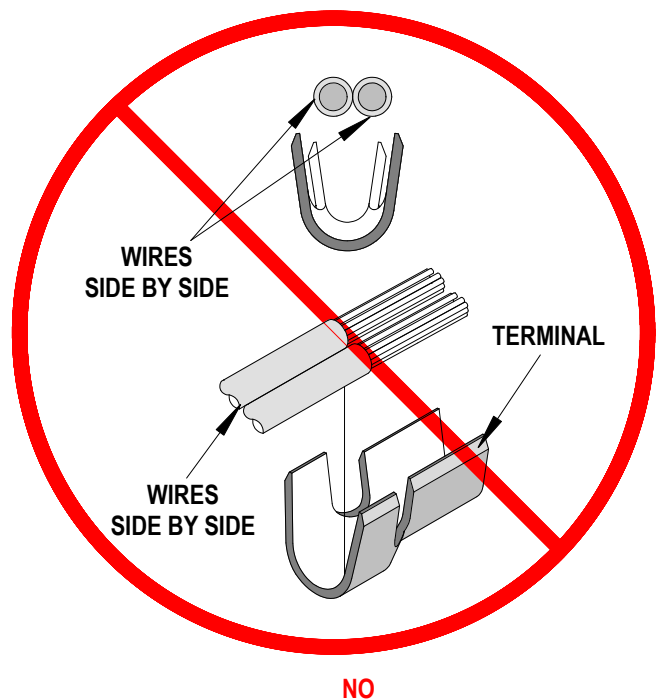
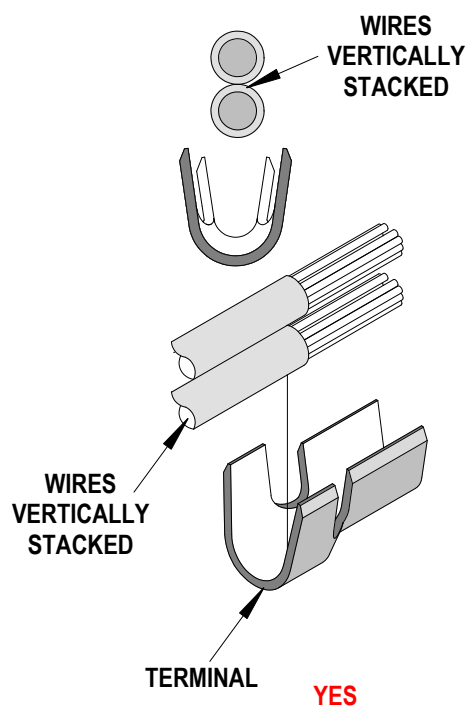
Terminal Series No.	Terminal Order No.	Wire Size and Type			Insulation Diameter				Strip Length	
					IPC/WHMA-A620 ♦		Terminal ♦ ♦			
		AWG	mm²	Type	mm	In.	mm	In.	mm	In.
43178	43178-2001	(2) 18	(2) 0.80	UL1015	2.85	.112	2.85	.112	3.96-5.54	.156-.218
	43178-2002									
	43178-6001	(2) 20	(2) 0.50	UL1015	2.54	.100	2.54	.100		
	43178-6002									
♦ To achieve optimum IPC-A620 insulation crimps, use this insulation OD range. ♦ ♦ Overall insulation OD specification for terminal.										

## DEFINITION OF TERMS



## Wire Feeding Orientation

This Applicator and crimp was developed for (2) 20 AWG UL1015 wires in a **vertically stacked** orientation. See the following illustrations below.



**CRIMP SPECIFICATION**

Terminal Series No.	Bell mouth		Cut-off Tab Maximum		Conductor Brush	
	mm	In.	mm	In.	mm	In.
43178	0.25-1.00	.010-.039	0.50	.019	1.50	.059

Terminal Series No.	Bend up   Bend down		Twist   Roll		Punch Width (Ref)				Seam
					Conductor		Insulation		
	Degree		Degree		mm	In	mm	In	
43178	3	3	4	8	3.40	.133	3.60	.142	Seam shall not be open and no wire allowed out of the crimping area

After crimping, the conductor profile should measure the following.

Terminal Series No.	Wire Size		Crimp Height		Pull Force Minimum	
	AWG	mm <sup>2</sup>	mm	In.	N	Lb.
43178	18 (2)	0.80 (2)	1.75-1.85	.069-.073	88.9	20.0
	20 (2)	0.50 (2)	1.65-1.75	.065-.069	57.9	13.0

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

The above specifications are guidelines to an optimum crimp.

**PARTS LIST**

<b>T2 Terminator 63911-3100</b>				
<b>Item</b>	<b>Order No</b>	<b>Engineering No.</b>	<b>Description</b>	<b>Quantity</b>
<b>Perishable Tooling</b>				
	63911-3170	63911-3170	Tool Kit (All "Y" Items)	REF
1	63457-3401	63457-3401	Conductor Punch	1 Y
2	63445-3443	63445-3443	Conductor Anvil	1 Y
3	63446-3623	63446-3623	Insulation Punch	1 Y
4	63445-3622	63445-3622	Insulation Anvil	1 Y
5	63443-0037	63443-0037	Front Cut-Off Plunger	1 Y
6	63443-0038	63443-0038	Front Plunger Retainer	1 Y
<b>Other Components</b>				
7	11-18-4083	60707-8	Feed Guide	1
8	63443-0009	63443-0009	Scrap Chute	1
9	63443-0024	63443-0024	Key	1
10	63443-0082	63443-0082	Striker	1
11	63443-0083	63443-0083	Striker Screw	1
12	63443-0085	63443-0085	Wire Stop L-Bracket	1
13	63443-0090	63443-0090	Wire Stop	1
14	63443-1712	63443-1712	18.20mm Spacer	1
15	63443-2215	63443-2215	15.00mm Spacer	1
16	63443-2301	63443-2301	3.05mm Spacer	1
17	63443-6013	63443-6013	Rear Cover	1
18	63700-0539	63700-0539	Cut-Off Plunger Spring	1
<b>Frame</b>				
19	63800-8500	63800-8500	T2 Terminator	1
<b>Hardware</b>				
20	N/A	N/A	M3 by 4 Long Set Screw	1**
21	N/A	N/A	M3 by 6 Long SHCS	2**
22	N/A	N/A	M3 by 6 Long FHCS	1**
23	N/A	N/A	M4 by 6 Long SHCS	2**
24	N/A	N/A	M4 by 12 Long BHCS	2**
25	N/A	N/A	M4 by 14 Long SHCS	2**
26	N/A	N/A	M4 by 50 Long SHCS	2**
27	N/A	N/A	M5 by 12 Long SHCS	1**
28	N/A	N/A	#10-32 by 3/8" Long BHCS	1**
29	N/A	N/A	#10-32 Hex Jam Nut	1**
** Available from an industrial supply company such as MSC (1-800-645-7270).				

## Assembly Drawing

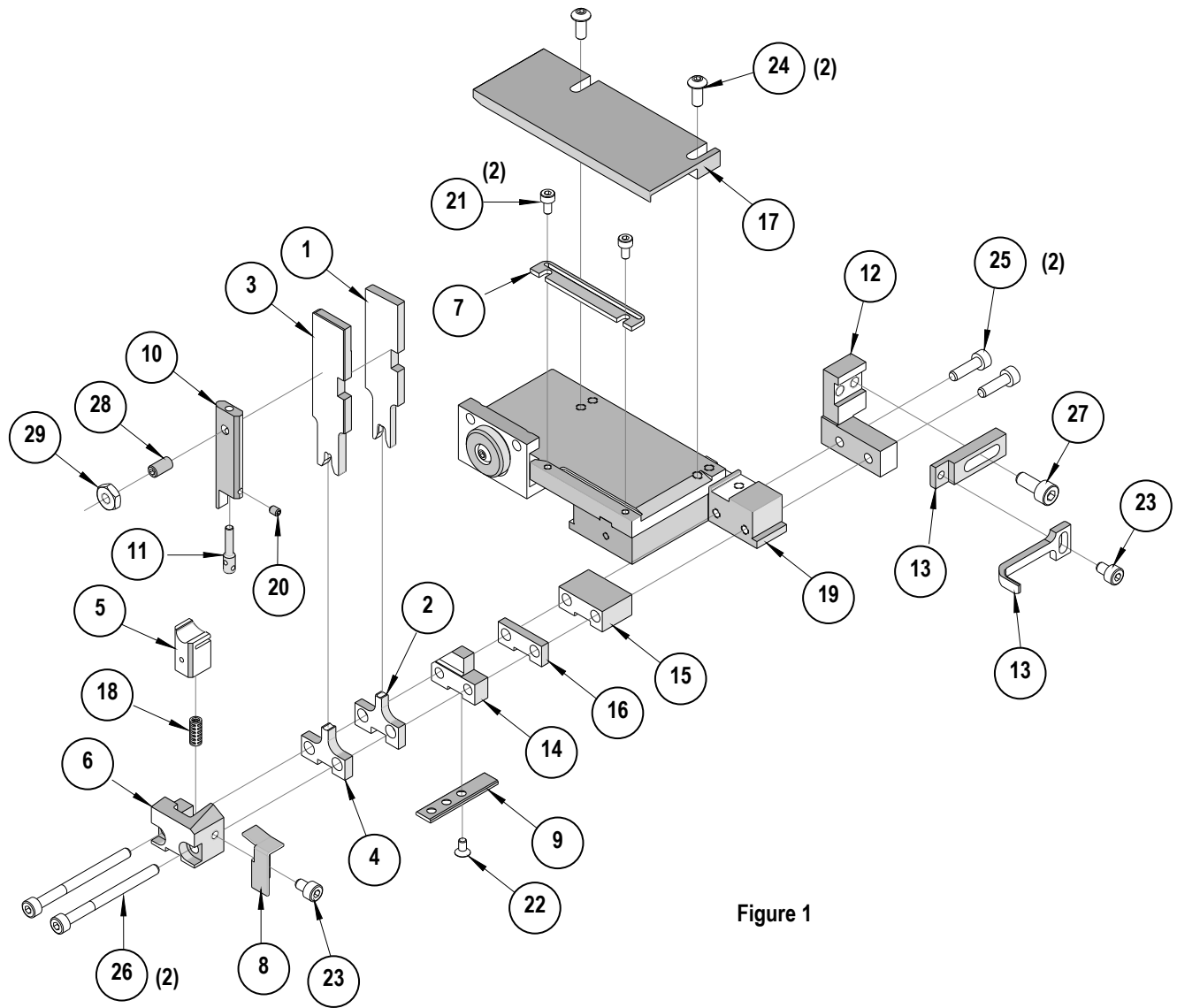


Figure 1

## 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).

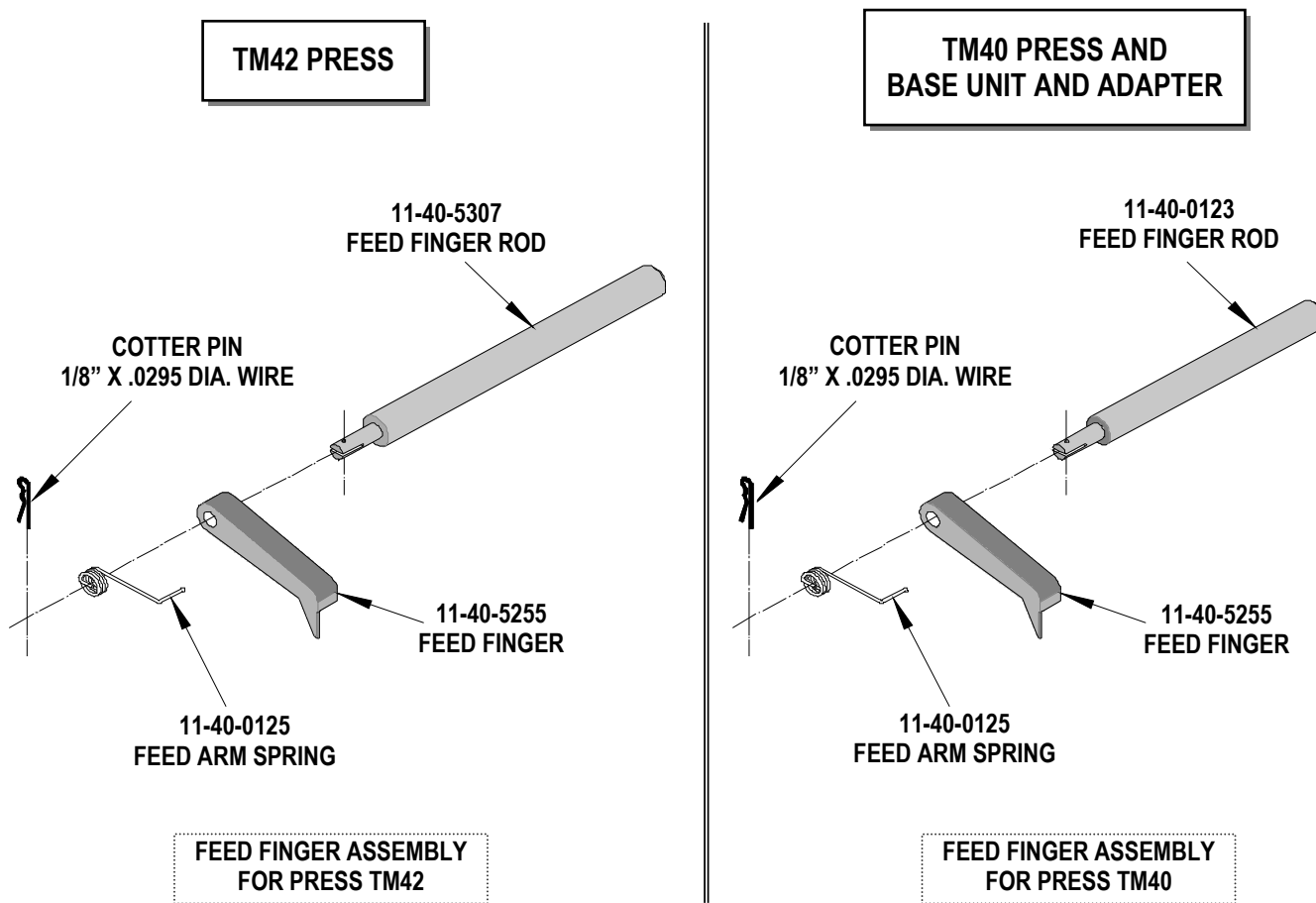


Figure 2

## 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.

<http://www.molex.com>