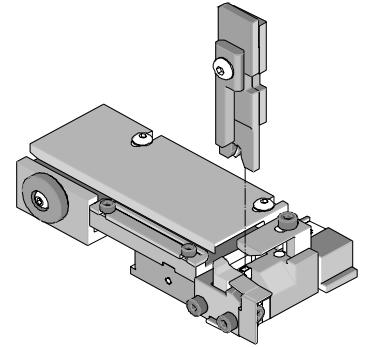




# T2 Terminator Tooling Specification Sheet Part No. 63853-5200



## FEATURES

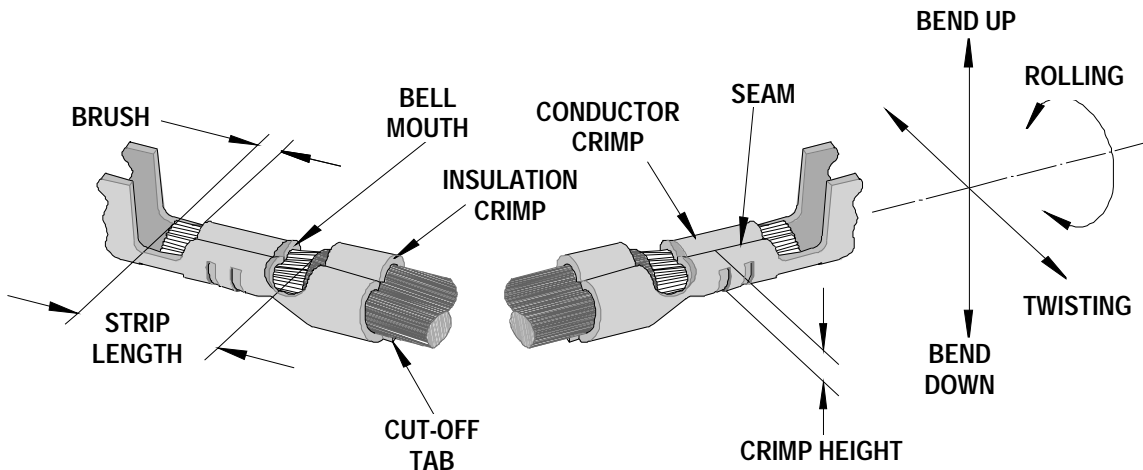
- It is ideally suited for mid-volume bench operations
- This terminator can be installed in the TM42 and the TM40 press or Base Unit adapter for 3BF press
- Quick punch removal with the push of a button for fast and easy tooling change
- Track adjustment capabilities in the T2 Terminators for improved 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: 2.00mm (.079") Pitch Crimp Terminal for 22-28 AWG.

Terminal Series No.	Terminal Order No.		Wire Size		Insulation Diameter		Strip Length	
			AWG	mm <sup>2</sup>	mm	In.	mm	In.
50639	50639-8018	50639-8049	22-28	0.35-0.08	0.55-1.15	.022-.045	2.20-2.70	.087-.106
	50639-8027	50639-8091						
	50639-8028	50639-8099						
	50639-8030							

## 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.
50639	0.20-0.50	.008-.020	0.20	.0008	0.10-0.50	0.004-.020

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		
	mm	In	mm	In	mm	In	mm	In	
50639	4	4	4	6	1.30	.051	1.40	.055	

After crimping, the conductor profile should measure the following.

Terminal Series No.	Wire Size		Conductor			
			Crimp Height		Crimp Width (Ref)	
	AWG	mm <sup>2</sup>	mm	In.	mm	In.
50639	22	0.35	0.94-0.99	.037-.039	1.20-1.40	.047-.055
	24	0.20	0.91-0.96	.036-.038	1.20-1.40	.047-.055
	26	0.13	0.82-0.87	.032-.034	1.20-1.40	.047-.055
	28	0.09	0.80-0.85	.031-.033	1.20-1.40	.047-.055

Terminal Series No.	Wire Size		Insulation				Pull Force Minimum	
			Crimp Height (Ref)		Crimp Width (Ref)			
	AWG	mm <sup>2</sup>	mm	In.	mm	In.	N	Lb.
50639	22	0.35	1.80	.071	1.30-1.50	.051-.059	34.3	7.7
	24	0.20	1.80	.071	1.30-1.50	.051-.059	24.5	5.5
	26	0.13	1.70	.067	1.30-1.50	.051-.059	14.7	3.3
	28	0.09	1.70	.067	1.30-1.50	.051-.059	9.8	2.2

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 63853-5200</b>				
<b>Item</b>	<b>Order No</b>	<b>Engineering No.</b>	<b>Description</b>	<b>Quantity</b>
<b>Perishable Tooling</b>				
	63853-5270	63853-5270	Tool Kit (All "Y" Items)	REF
1	63444-1301	63444-1301	Conductor Punch	1 Y
2	63445-1324	63445-1324	Conductor Anvil	1 Y
3	63446-1414	63446-1414	Insulation Punch	1 Y
4	63445-1424	63445-1424	Insulation Anvil	1 Y
5	63443-0002	63443-0002	Front Cut-Off Plunger	1 Y
6	63443-0012	63443-0012	Front Plunger Retainer	1 Y
<b>Other Components (REF 535250)</b>				
7	11-18-4083	60707-8	Feed Guide	1
8	11-24-1067	4996-4	Cut-Off Plunger Spring	1
9	11-40-4039	8302-5	Plunger Striker	1
10	63443-0009	63443-0009	Front Scrap Chute	1
11	63443-0021	63443-0021	Key	1
12	63443-2406	63443-2406	Anvil Mount	1
13	63443-4005	63443-4005	Wire Stop	1
14	63443-6003	63443-6003	Rear Cover	1
<b>Frame</b>				
15	63800-8500	63800-8500	T2 Terminator	1
<b>Hardware</b>				
16	N/A	N/A	M3 by 6 Long SHCS	2**
17	N/A	N/A	M4 by 6 Long SHCS	1**
18	N/A	N/A	M4 by 12 Long BHCS	2**
19	N/A	N/A	M4 by 16 Long SHCS	1**
20	N/A	N/A	M4 by 20 Long SHCS	1**
21	N/A	N/A	M4 by 50 Long SHCS	1**
22	N/A	N/A	3MM by 6 Long Roll Pin	1**
23	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

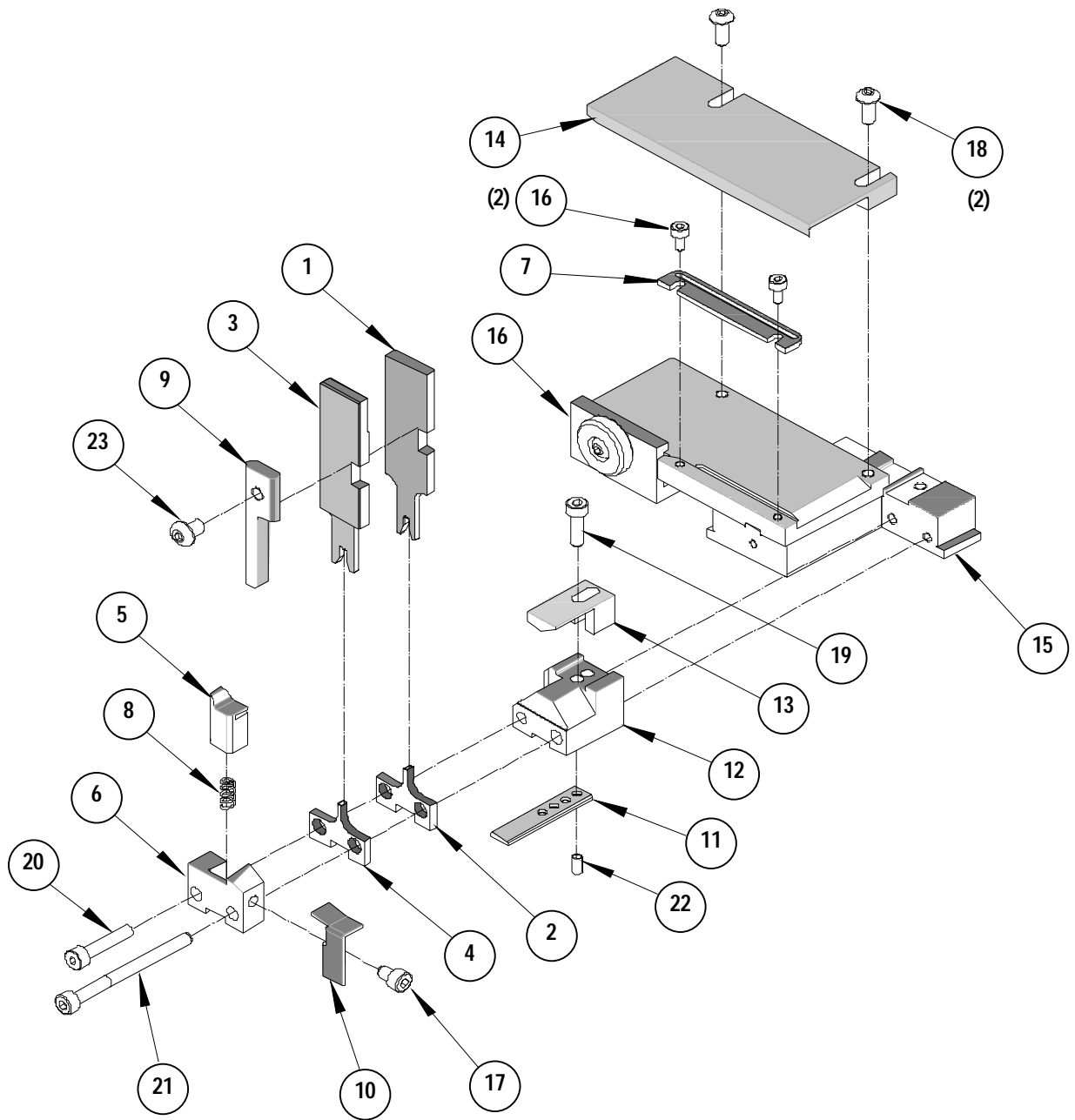


Figure 1

## 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).

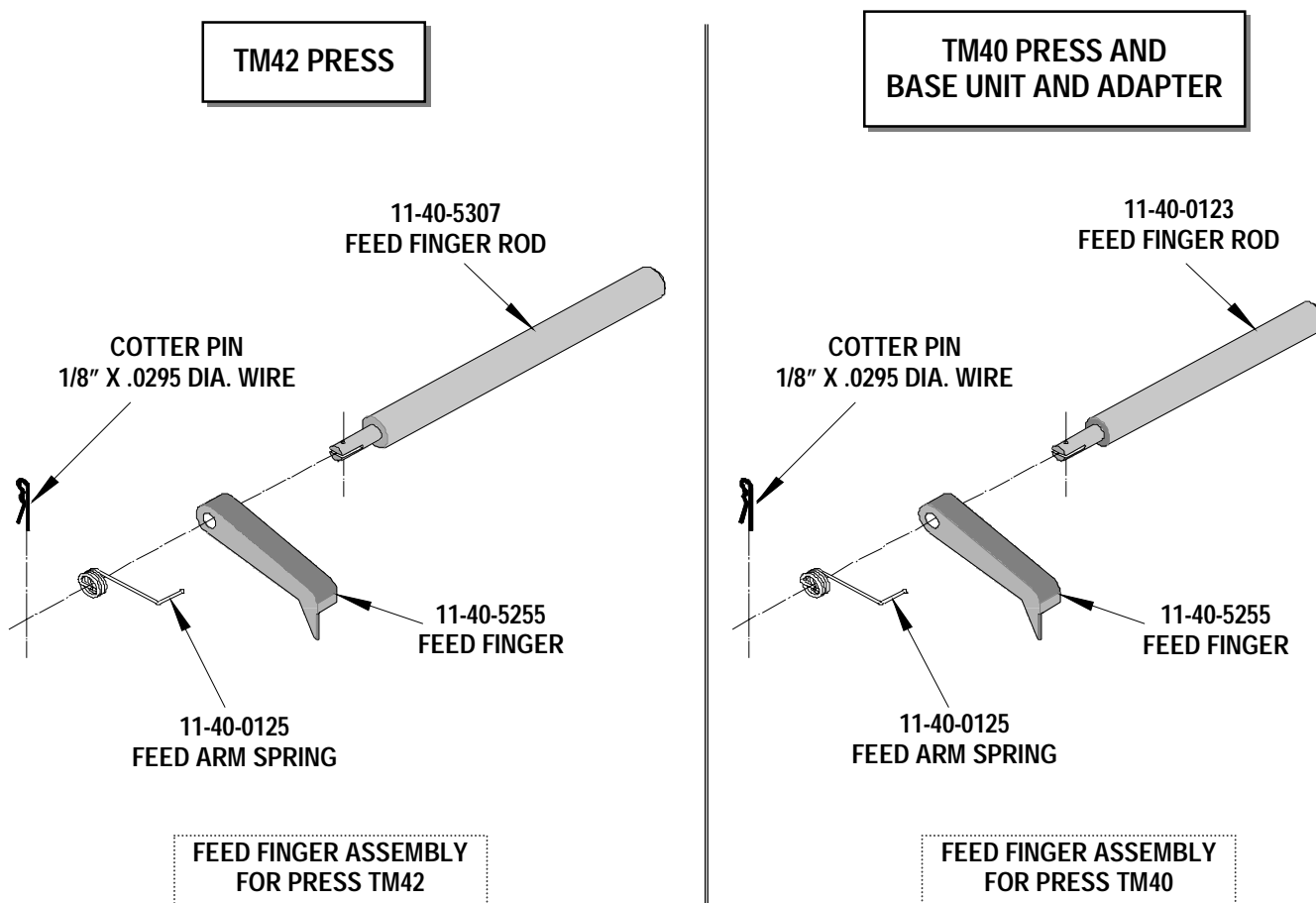


Figure 2

## 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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