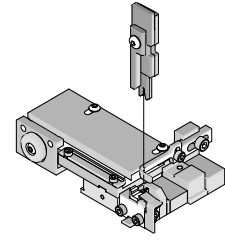


**T2 Terminator Tooling**



**Application Tooling Specification Sheet**



**Order No. 63910-9000**

**FEATURES**

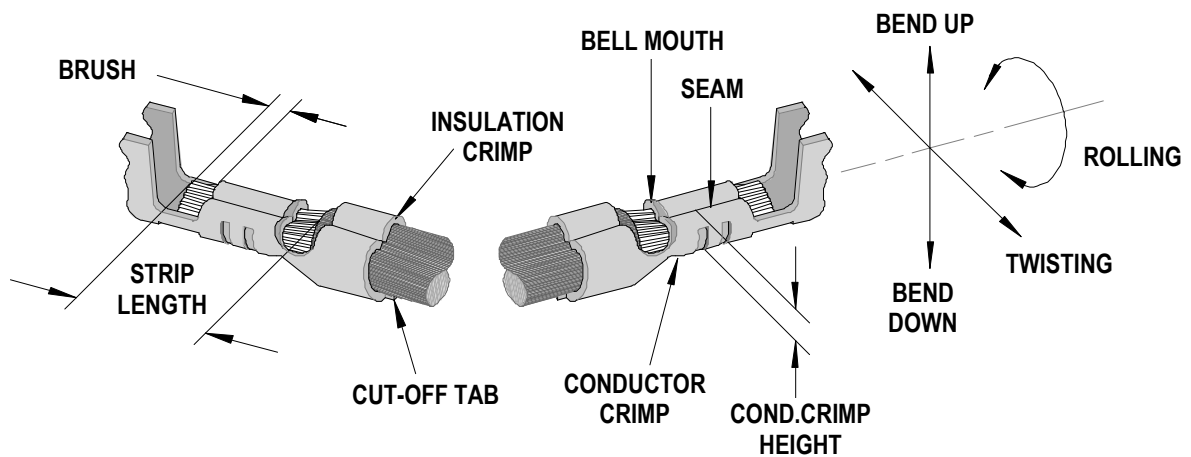
- It is ideally suited for mid-volume bench operations
- This terminator can be installed in the TM42 and the TM40 press or Base Unit adapter for 3BF press
- Quick punch removal with the push of a button for fast and easy tooling change
- Track adjustment capabilities in the T2 Terminators for improved 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: 6.35mm (.250") Tab Heavy Tab Terminal, A-type, 16-18 AWG.

Terminal Series No.	Terminal Order No.	Wire Size		Insulation Diameter Maximum		Strip Length	
		AWG	mm <sup>2</sup>	mm	In.	mm	In.
35452	35452-9802	16-18	1.31-0.82	3.60	.142	4.80-5.20	.189-.205
35453	35453-9802	16-18	1.31-0.82	3.60	.142	4.80-5.20	.189-.205

**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.
35452	0.30-0.60	.012-.024	0.50	.020	0.30-0.80	.012-.032
35453	0.30-0.60	.012-.024	0.50	.020	0.30-0.80	.012-.032

Terminal Series No.	Bend up	Bend down	Twist	Roll	Punch Width (Ref)				Seam Seam shall not be open and no wire allowed out of the crimping area
					Conductor		Insulation		
	Degree		Degree		mm	In	mm	In	
35452	3 °	3 °	3 °	5 °	2.70	.106	4.00	.157	
35453	3 °	3 °	3 °	5 °	2.70	.106	4.00	.157	

After crimping, the crimp profiles should measure the following:

Terminal Series No.	Wire Size		Conductor				Insulation				Pull Force Minimum	
			Crimp Height		Crimp Width		Crimp Height Maximum		Crimp Width			
	AWG	mm <sup>2</sup>	mm	In.	mm	In.	mm	In.	mm	In.	N	Lb.
35452	16	1.31	1.60-1.80	.063-.071	2.69-2.91	.106-.115	4.40	.173	4.00	.157	176.4	39.7
	18	0.82	1.30-1.50	.051-.059	2.69-2.91	.106-.115	4.40	.173	4.00	.157	122.6	27.6
35453	16	1.31	1.60-1.80	.063-.071	2.69-2.91	.106-.115	4.40	.173	4.00	.157	176.4	39.7
	18	0.82	1.30-1.50	.051-.059	2.69-2.91	.106-.115	4.40	.173	4.00	.157	122.6	27.6

Tool Qualification Notes:

1. This Applicator was qualified to the above specifications with UL1015 wire.
2. Pull Force should be measured with no influence from the insulation crimp.
3. The above specifications are guidelines to an optimum crimp.

**PARTS LIST**

<b>T2 Terminator 63910-9000</b>				
<b>Item</b>	<b>Order No</b>	<b>Engineering No.</b>	<b>Description</b>	<b>Quantity</b>
<b>Perishable Tooling</b>				
	63910-9070	63910-9070	Tool Kit (All "Y" Items)	REF
1	63444-2725	63444-2725	Conductor Punch	1 Y
2	63445-2778	63445-2778	Conductor Anvil	1 Y
3	63446-4025	63446-4025	Insulation Punch	1 Y
4	63445-4048	63445-4048	Insulation Anvil	1 Y
5	63443-0035	63443-0035	Front Cut-Off Plunger	1 Y
6	63443-0036	63443-0036	Front Plunger Retainer	1 Y
<b>Other Components</b>				
7	11-18-4083	60707-8	Feed Guide	1
8	63443-0009	63443-0009	Front Scrap Chute	1
9	63443-0024	63443-0024	Key	1
10	63443-0085	63443-0085	Wire Stop L-Bracket	1
11	63443-0090	63443-0090	Wire Stop	1
12	63443-1712	63443-1712	Height Spacer	1
13	63443-2214	63443-2214	Coarse Spacer (14.00mm)	1
14	63443-2304	63443-2304	Fine Spacer (3.20mm)	1
15	63443-3160	63443-3160	Plunger Striker	1
16	63443-6013	63443-6013	Rear Cover	1
17	63700-0539	63700-0539	Cut-Off Plunger Spring	1
<b>Frame</b>				
18	63800-8500	63800-8800	T2 Terminator Wide Track	1
<b>Hardware</b>				
19	N/A	N/A	M3 by 6 Long SHCS	2**
20	N/A	N/A	M3 by 6 Long FHCS	1**
21	N/A	N/A	M4 by 6 Long SHCS	2**
22	N/A	N/A	M4 by 12 Long BHCS	2**
23	N/A	N/A	M4 by 14 Long SHCS	2**
24	N/A	N/A	M4 by 50 Long SHCS	2**
25	N/A	N/A	M5 by 12 Long SHCS	1**
26	N/A	N/A	#10-32 by 1/4" Long BHCS	1**
** Available from an industrial supply company such as MSC (1-800-645-7270).				

### Assembly Drawing

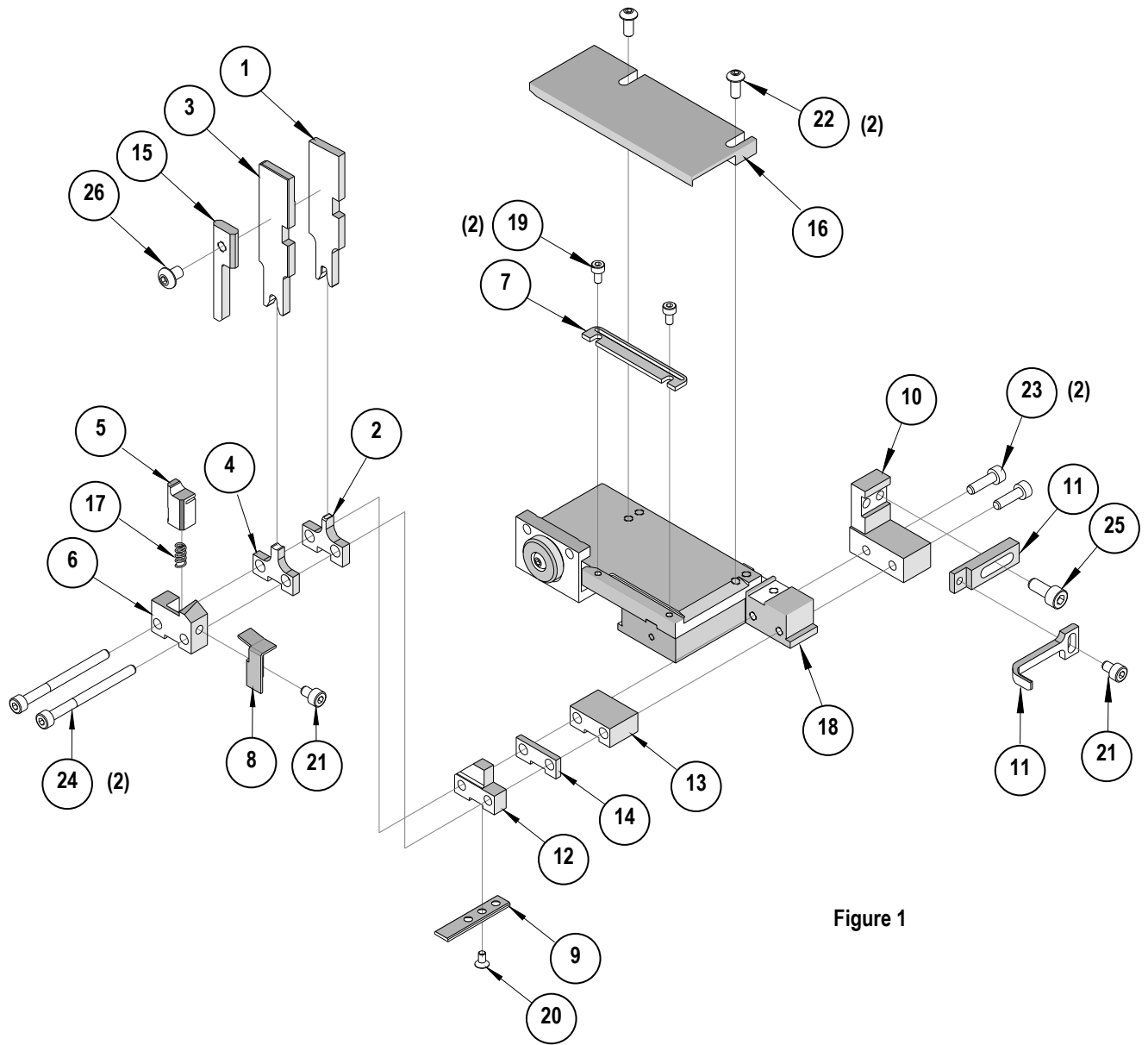


Figure 1

## 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).

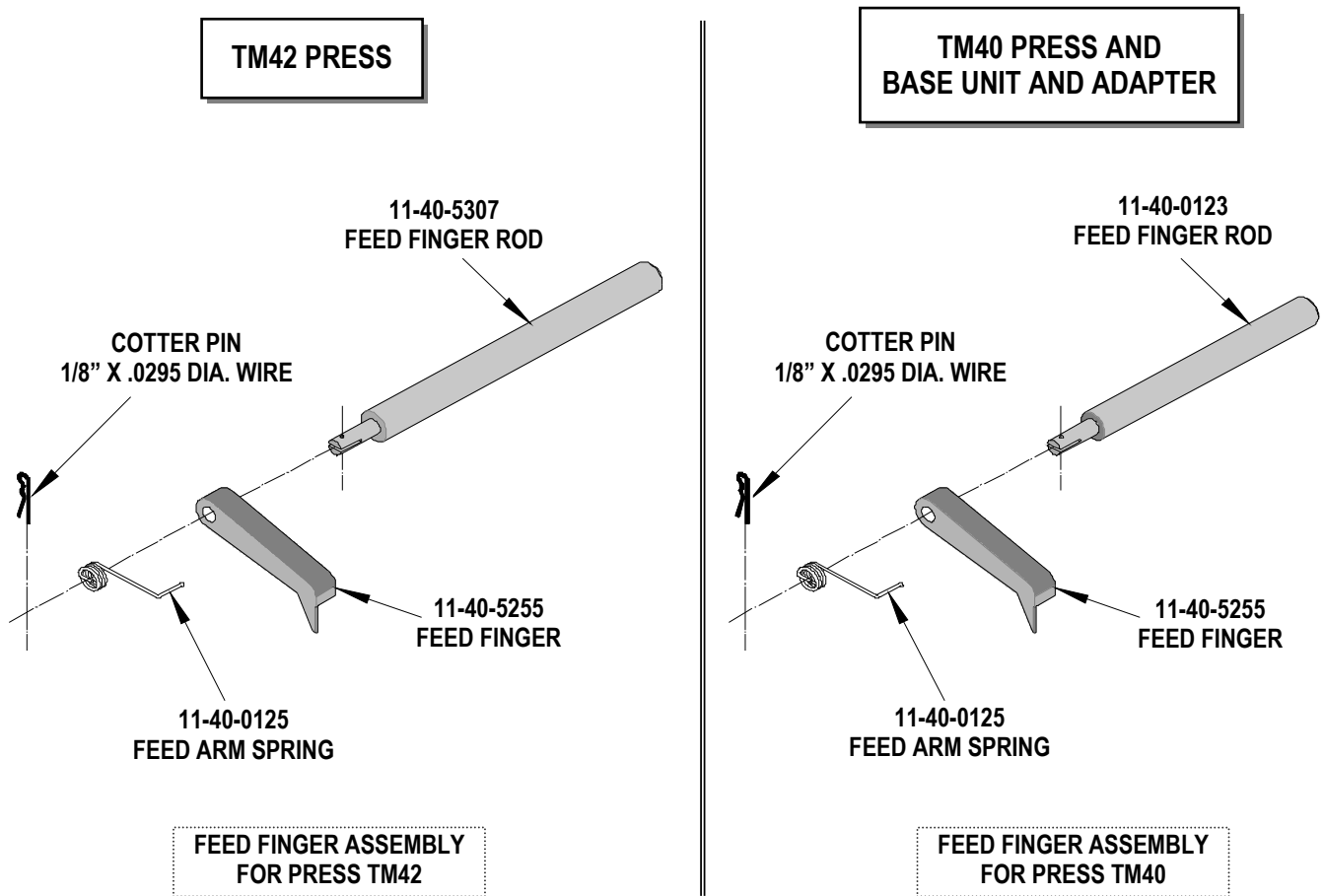


Figure 2

## 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.

<http://www.molex.com>