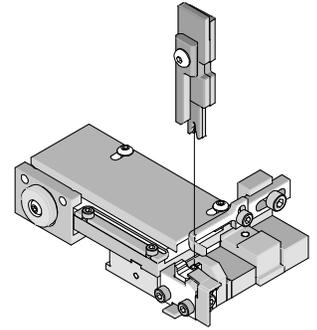




## T2 Terminator Tooling Specification Sheet Order No. 63852-6100



### FEATURES

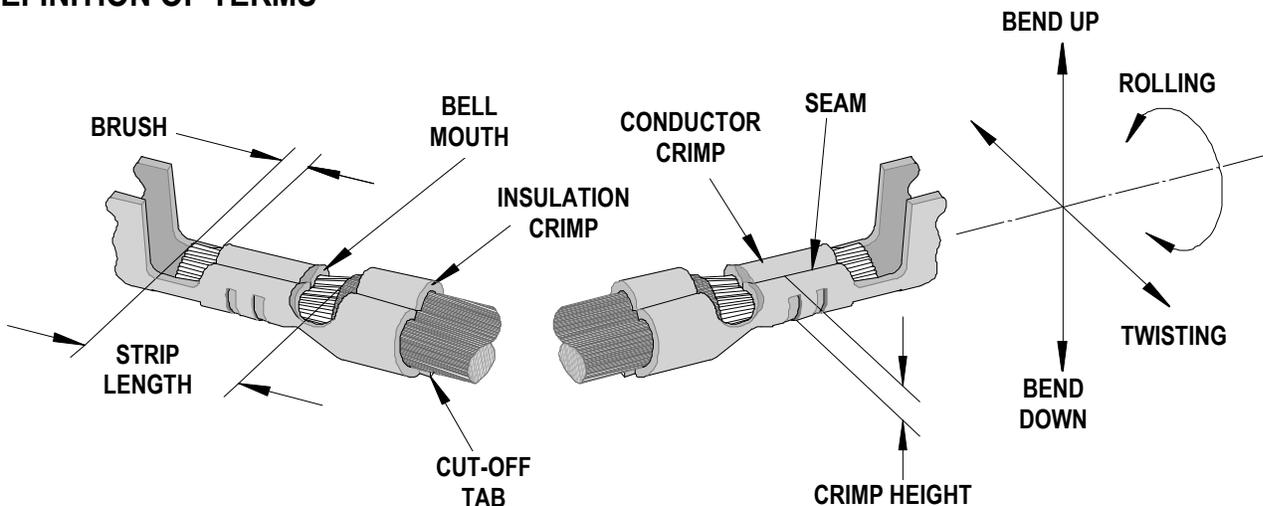
- It is ideally suited for mid-volume bench operations
- This terminator can be installed in the TM42 and the TM40 press or Base Unit adapter for 3BF press
- Quick punch removal with the push of a button for fast and easy tooling change
- Track adjustment capabilities in the T2 Terminators for improved 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, 14-18 AWG.

Terminal Series No.	Terminal Order No.		Wire Size		Insulation Diameter Maximum		Strip Length	
			AWG	mm <sup>2</sup>	mm	In.	mm	In.
50637	50637-0028	50637-0049	14-18	2.00-0.80	3.80	.150	3.90-4.40	.154-.173
50638	50638-9028	50638-9049	14-18	2.00-0.80	3.80	.150	3.90-4.40	.154-.173
50674	50674-9049	50674-9099	14-18	2.00-0.80	3.80	.150	3.90-4.40	.154-.173

### 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.
50637	0.10-0.60	.004-.024	0.30	.012	0.00-1.00	.000-.039
50638	0.10-0.60	.004-.024	0.30	.012	0.00-1.00	.000-.039
50674	0.10-0.60	.004-.024	0.30	.012	0.00-1.00	.000-.039

Terminal Series No.	Bend up	Bend down	Twist	Roll	Punch Width (Ref)				Seam
					Conductor		Insulation		
	Degree	Degree	mm	In	mm	In			
50637	5	4	4	8	2.60	.102	4.00	.157	Seam shall not be open and no wire allowed out of the crimping area
50638	5	4	4	8	2.60	.102	4.00	.157	
50674	5	4	4	8	2.60	.102	4.00	.157	

After crimping, the conductor profile should measure the following.

Terminal Series No.	Wire Size		Conductor Crimp Height		Pull Force Minimum	
	AWG	mm <sup>2</sup>	mm	In.	N	Lb.
50637	14	2.00	1.59-1.69	.063-.067	147.0	33.1
	16	1.30	1.39-1.49	.055-.059	127.4	28.7
	18	0.80	1.22-1.32	.048-.052	88.2	19.8
50638	14	2.00	1.59-1.69	.063-.067	147.0	33.1
	16	1.30	1.39-1.49	.055-.059	127.4	28.7
	18	0.80	1.22-1.32	.048-.052	88.2	19.8
50674	14	2.00	1.59-1.69	.063-.067	147.0	33.1
	16	1.30	1.39-1.49	.055-.059	127.4	28.7
	18	0.80	1.22-1.32	.048-.052	88.2	19.8

**\* 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**

<b>Terminator 63852-6100</b>				
<b>Item</b>	<b>Order No</b>	<b>Engineering No.</b>	<b>Description</b>	<b>Quantity</b>
<b>Perishable Tooling</b>				
	63852-6170	63852-6170	Tool Kit (All "Y" Items)	REF
1	63444-2612	63444-2612	Conductor Punch	1 Y
2	63445-2666	63445-2666	Conductor Anvil	1 Y
3	63446-4021	63446-4021	Insulation Punch	1 Y
4	63445-4031	63445-4031	Insulation Anvil	1 Y
5	63443-0002	63443-0002	Cut-Off Plunger	1 Y
6	63443-0012	63443-0012	Front Plunger Retainer	1 Y
<b>Other Components</b>				
7	11-18-4083	60707-8	Feed Guide	1
8	11-24-1067	4996-4	Cut-off Plunger Spring	1
9	63443-0009	63443-0009	Front Scrape Chute	1
10	63443-0024	63443-0024	Key	1
11	63443-0085	63443-0085	Wire Stop L-Bracket	1
12	63443-0090	63443-0090	Wire Stop	1
13	63443-1703	63443-1703	17.30mm Spacer	1
14	63443-2214	63443-2214	14.00mm Spacer	1
15	63443-2318	63443-2318	3.90mm Spacer	1
16	63443-3160	63443-3160	Front Plunger Striker	1
17	63443-6011	63443-6011	Rear Cover	1
<b>Frame</b>				
18	63800-8500	63800-8500	T2 Terminator	1
<b>Hardware</b>				
19	N/A	N/A	M3 by 6 Long FHCS	1**
20	N/A	N/A	M3 by 6 Long SHCS	2**
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 Lg SHCS	1**
26	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

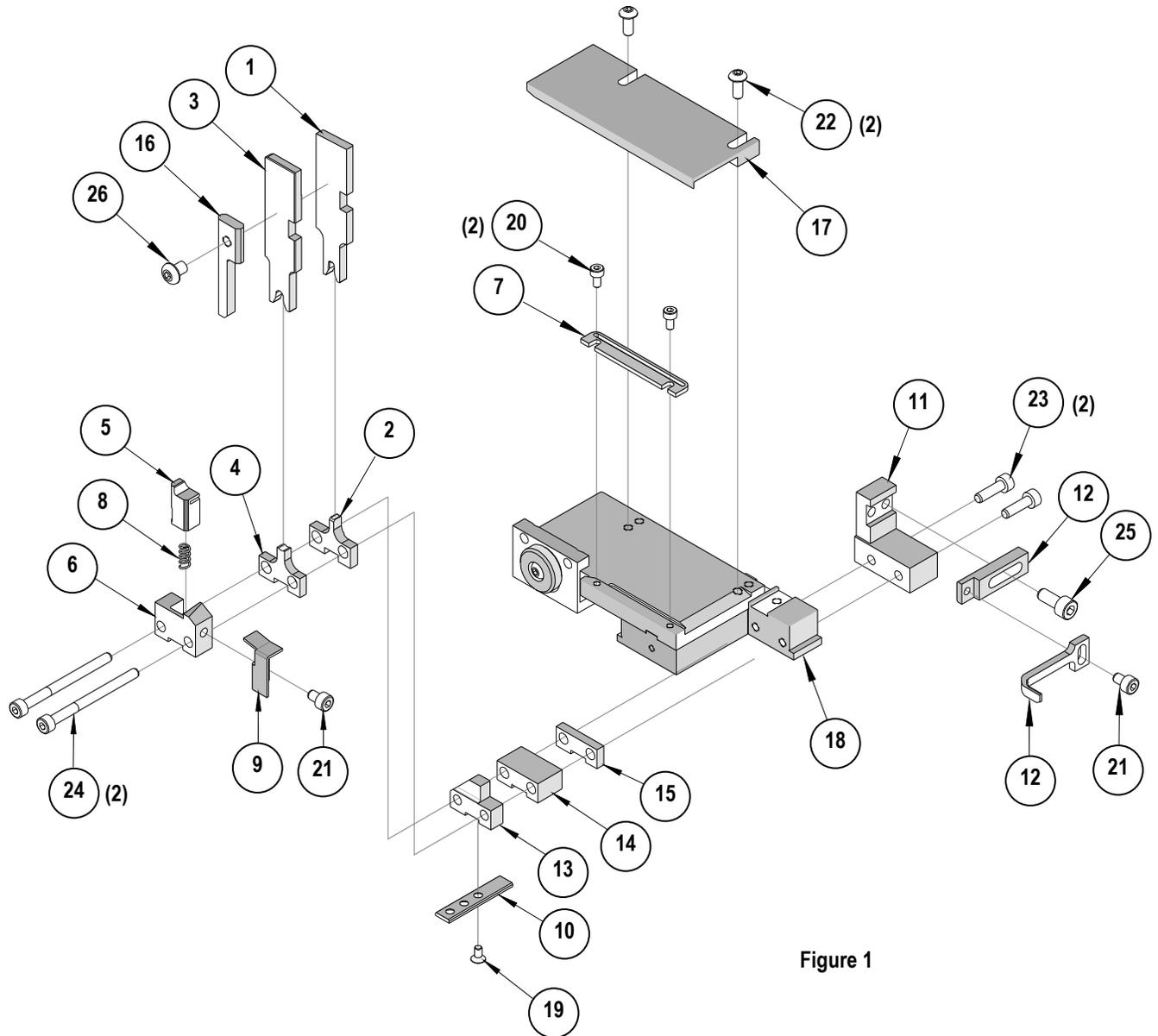


Figure 1

## 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).

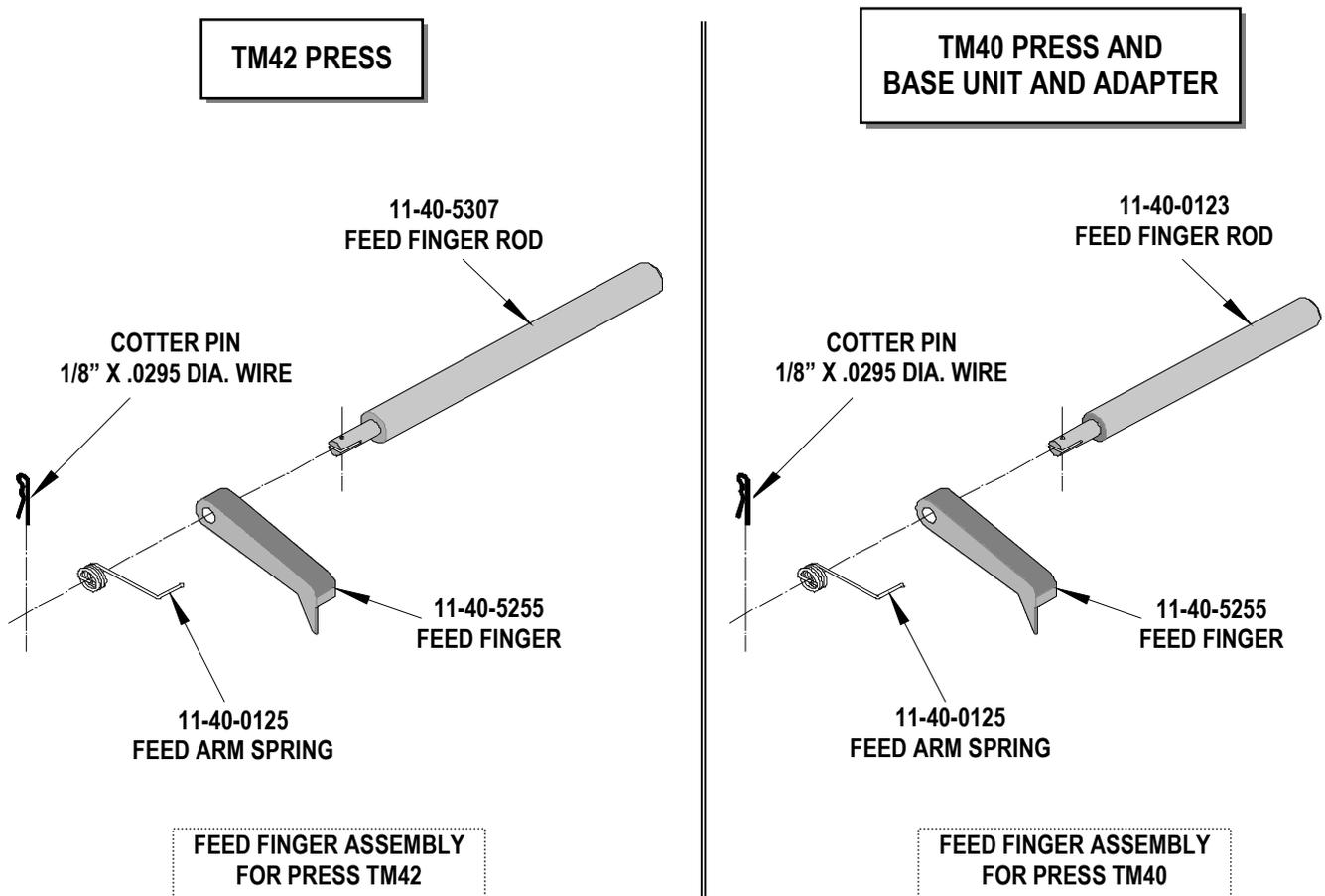


Figure 2

## 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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