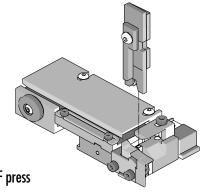


T2 Terminator Tooling Specification Sheet Part No. 63853-3000



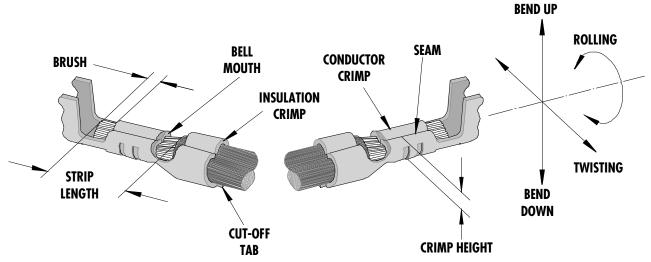
FEATURES

- This terminator can be installed in the TM42 and the TM40 press or Base Unit adapter for 3BF press
- It is ideally suited for mid-volume bench operations
- 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 Series No.	Wire Size		Insulation	Diameter	Strip Length		
Terminur Jeries No.	AWG	mm²	mm	ln.	mm	ln.	
36535-000*	14	2.00	3.30-5.10	.130200	4.00-4.70	.157185	
36535-000*	16	1.30	3.30-5.10	.130200	4.00-4.70	.157185	
36535-000*	2 - 18	(2) 0.80	(2 X) 2.03-2.84	(2 X) .080112	4.00-4.70	.157185	
36536-000*	14	2.00	3.30-5.10	.130200	4.00-4.70	.157185	
36536-000*	36-000* 16 1.30		3.30-5.10	.130200	4.00-4.70	.157185	
36536-000*	2 - 18	(2) 0.80	(2 X) 2.03-2.84	(2 X) .080112	4.00-4.70	.157185	

DEFINITION OF TERMS



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

Doc No. 63853-3000 Release Date: 06-06-03 **UNCONTROLLED COPY** Page 1 of 6 Revision Date: 12-15-03

CRIMP SPECIFICATION

Terminal Series No.	Bell n	nouth	Cut-off 1	ab Max.	Conductor Brush	
Terminal Series No.	mm	ln.	mm	ln.	mm	ln.
36535-000*	0.25-0.65	.010025	0.30	.012	0.38-0.69	.015027
36536-000*	0.25-0.65	.010025	0.30	.012	0.38-0.69	.015027

Ī		Bend up Bend down		Twist Roll		Punch Width mm (Ref)				
	Terminal Series No.	Degree		Degree		Conductor		Insulation		Seam
İ						mm	ln	mm	ln	Seam shall not be open and no wire allowed out
ĺ	36535-000*	3	3	4	8	2.60	.102	4.80	.189	of the crimping area
	36536-000*	3	3	4	8	2.60	.102	4.80	.189	or mo crimping area

After crimping, the conductor profile should measure the following.

Terminal Series No.	Wir	e Size	Crimp	Height	Pull Force Min.	
Termina Jeries No.	AWG	mm²	mm	ln.	N	Lb.
36535-000*	14	2.00	1.57-1.67	.062066	222.4	50
36535-000*	16	1.30	1.38-1.48	.054058	133.4	30
36535-000*	2 - 18	(2) 0.80	1.52-1.60	.060063	88.9	20
36536-000*	14	2.00	1.57-1.67	.062066	222.4	50
36536-000*	16	1.30	1.38-1.48	.054058	133.4	30
36536-000*	2 - 18	(2) 0.80	1.52-1.60	.060063	88.9	20

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

The above specifications are guidelines to an optimum crimp.

Doc No. 63853-3000 Release Date: 06-06-03 Revision: B Revision Date: 12-15-03

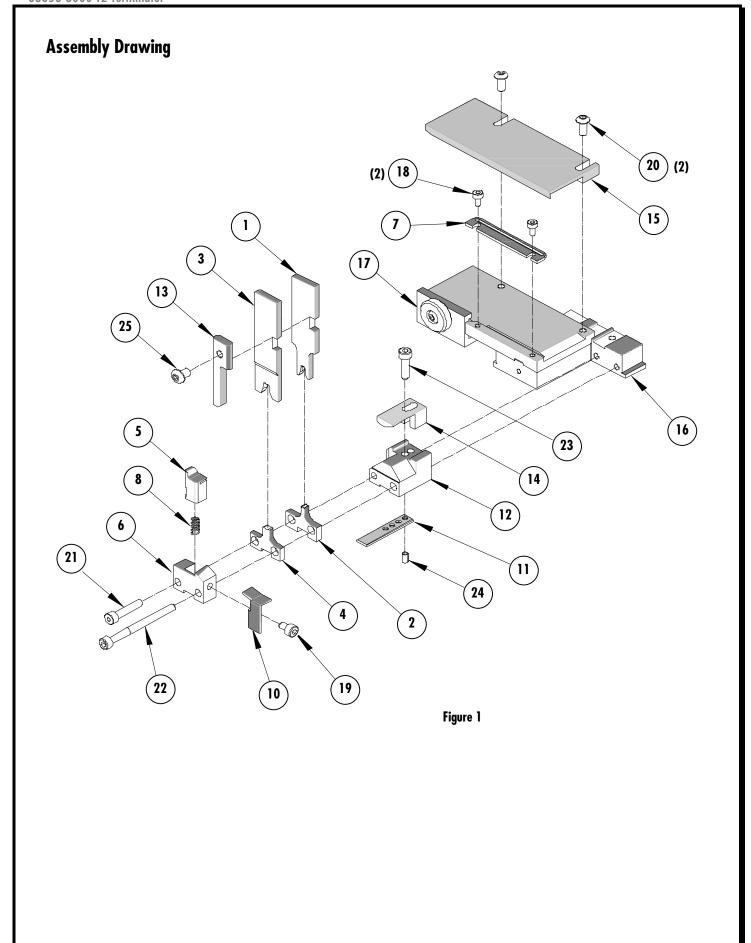
PARTS LIST

Item	Order No	Engineering No.	neering No. Description	
	63853-3000	63853-3000	T2 Terminator (Fig. 1)	REF
1	63444-2609	63444-2609	Conductor Punch	Y
2	63445-2659	63445-2659	Conductor Anvil	Y
3	63446-4805	63446-4805	Insulation Punch	Y
4	63445-4830	63445-4830	Insulation Anvil	Υ
5	63443-0003	63443-0003	Cut-Off Plunger	Υ
6	63443-0012	63443-0012	Front Plunger Retainer	Υ
7	11-18-4083	60707-8	Front Cover	1
8	11-24-1067	4996-4	Cut-off Plunger Spring]
9	11-40-0124	TM40-25	Feed Finger (Short)	1 (Fig. 2)
10	63443-0009	63443-0009	Scrape Chute	1
11	63443-0021	63443-0021	Lower Tooling Key	1
12	63443-2415	63443-2415	Anvil Mount	1
13	11-40-4039	8302-5	Front Plunger Striker	1
14	63443-4006	63443-4006	Wire Stop	1
15	63443-6011	63443-6011	Rear Cover	1
16	63800-8500	63800-8500	T2 Terminator	1
17	63860-2015	63860-2015	*Drag Frame (Modified)	1
18	N/A	N/A	M3 by 6Lg. SHCS	2**
19	N/A	N/A	M4 by 6Lg. SHCS]**
20	N/A	N/A	M4 by 10Lg. BHCS	2**
21	N/A	N/A	M4 by 20Lg. SHCS]**
22	N/A	N/A	M4 by 50Lg. SHCS]**
23	N/A	N/A	M4 by 16Lg. SHCS]**
24	N/A	N/A	3MM by 6Lg. Roll Pin]**
25	N/A	N/A	#10-32 by 1/4"Lg. BHCS]**
	63853-3070	63853-3070	Tool Kit (All Y Items)	1

^{*} Frame Part - To be modified

Doc No. 63853-3000 Release Date: 06-06-03 Revision: B Revision Date: 12-15-03

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



Doc No. 63853-3000 Revision: B Release Date: 06-06-03 Revision Date: 12-15-03

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.
- 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.
- Position feed finger for selected product. (Refer to Figure 5.1 in the T2 Manual).

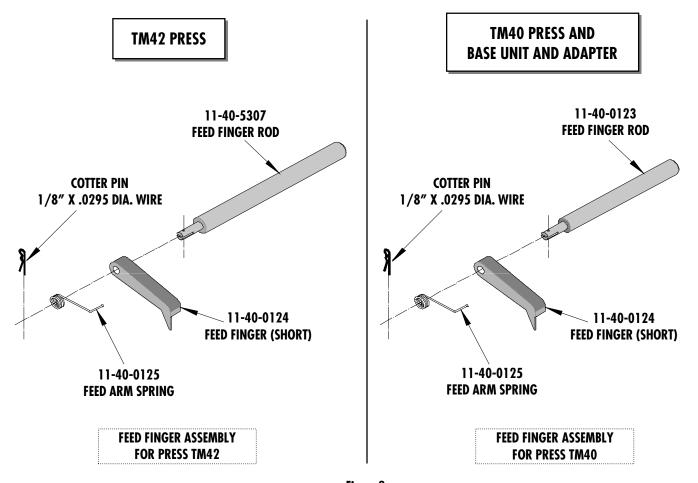


Figure 2

Doc No. 63853-3000 Release Date: 06-06-03 UNCONTROLLED COPY Page 5 of 6 Revision: B Revision Date: 12-15-03

NOTES

- 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.

Molex Application Tooling Group

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Visit our Web site at http://www.molex.com

Doc No. 63853-3000 Release Date: 06-06-03 **UNCONTROLLED COPY** Page 6 of 6 Revision: B Revision Date: 12-15-03