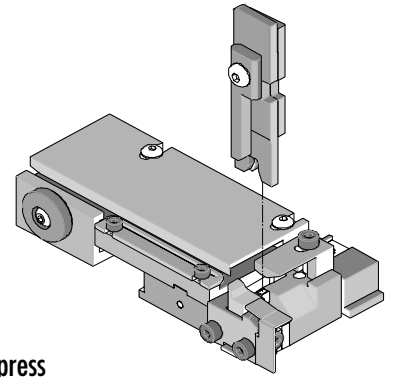




## T2 Terminator Tooling Specification Sheet Part No. 63854-3000



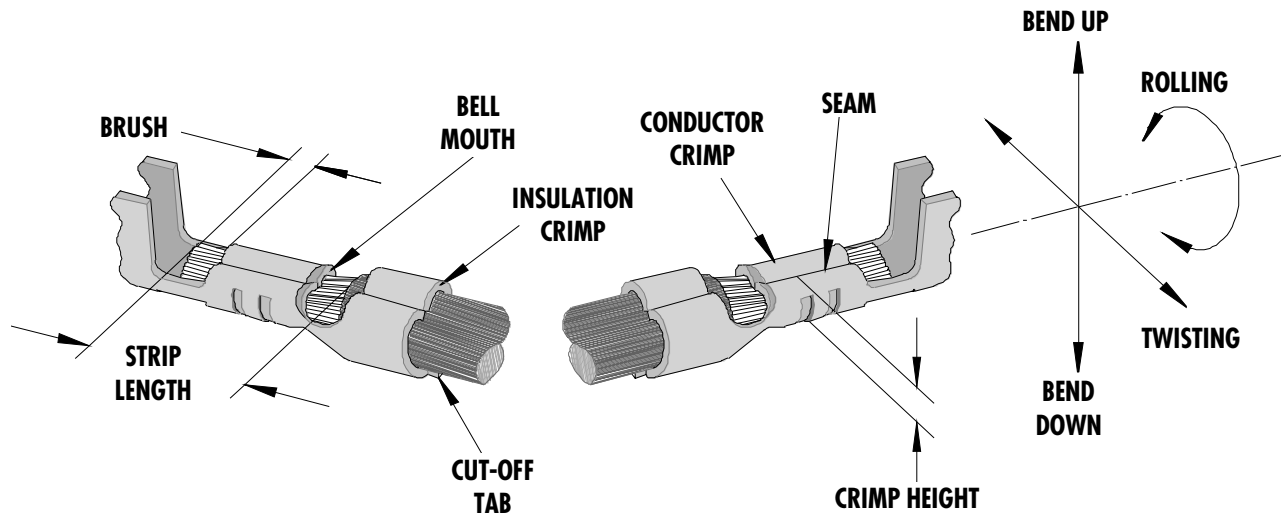
### FEATURES

- 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	
	AWG	mm <sup>2</sup>	mm	In.	mm	In.
50212-8*00	24-30	0.20-0.05	0.80-1.40	.031-.055	1.30-1.80	.051-.071
50394-8***	24-30	0.20-0.05	0.80-1.40	.031-.055	1.30-1.80	.051-.071

### 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 Max.		Conductor Brush	
	mm	In.	mm	In.	mm	In.
50212-8*00	0.05-0.35	.002-.014	0.20	.008	0.00-0.50	.000-.020
50394-8***	0.05-0.35	.002-.014	0.20	.008	0.00-0.50	.000-.020

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
	Degree		Degree		Conductor		Insulation		
					mm	In	mm	In	
50212-8*00	4	3	3	4	1.00	.039	1.40	.055	
50394-8***	4	3	3	4	1.00	.039	1.40	.055	

After crimping, the conductor profile should measure the following.

Terminal Series No.	Wire Size		Crimp Height		Pull Force Min.	
	AWG	mm <sup>2</sup>	mm	In.	N	Lb.
50212-8*00	24	0.20	0.60-0.65	.024-.026	29.3	6.60
50212-8*00	26	0.12	0.59-0.64	.023-.025	19.6	4.40
50212-8*00	28	0.08	0.56-0.61	.022-.024	9.8	2.20
50212-8*00	30	0.05	0.53-0.58	.021-.023	4.9	1.10
50394-8***	24	0.20	0.60-0.65	.024-.026	29.3	6.60
50394-8***	26	0.12	0.59-0.64	.023-.025	19.6	4.40
50394-8***	28	0.08	0.56-0.61	.022-.024	9.8	2.20
50394-8***	30	0.05	0.53-0.58	.021-.023	4.9	1.10

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

The above specifications are guidelines to an optimum crimp.

**PARTS LIST**

Item	Order No	Engineering No.	Description	Quantity
	<b>63854-3000</b>	<b>63854-3000</b>	<b>Terminator (Fig. 1)</b>	<b>REF</b>
1	63444-1003	63444-1003	Conductor Punch	1 Y
2	63445-1013	63445-1013	Conductor Anvil	1 Y
3	63446-1430	63446-1430	Insulation Punch	1 Y
4	63445-1405	63445-1405	Insulation Anvil	1 Y
5	63443-0003	63443-0003	Cut-Off Plunger	1 Y
6	63443-0012	63443-0012	Front Plunger Retainer	1 Y
7	11-18-4083	60707-8	Front Cover	1
8	11-24-1067	4996-4	Cut-off Plunger Spring	1
9	11-40-4039	8302-5	Front Plunger Striker	1
10	63443-0009	63443-0009	Scrape Chute	1
11	63443-0021	63443-0021	Lower Tooling Key	1
12	63443-2421	63443-2421	Anvil Mount	1
13	63443-4025	63443-4025	Wire Stop	1
14	63443-6003	63443-6003	Rear Cover	1
15	63800-8500	63800-8500	T2 Terminator	1
16	N/A	N/A	M3 by 6Lg. SHCS	2**
17	N/A	N/A	M4 by 6Lg. SHCS	1**
18	N/A	N/A	M4 by 12Lg. BHCS	2**
19	N/A	N/A	M4 by 16Lg. SHCS	1**
20	N/A	N/A	M4 by 20Lg. SHCS	1**
21	N/A	N/A	M4 by 50Lg. SHCS	1**
22	N/A	N/A	3MM by 6Lg. Roll Pin	1**
23	N/A	N/A	#10-32 by 3/8"Lg. BHCS	1**
	<b>63854-3070</b>	<b>63854-3070</b>	<b>Tool Kit (All Y Items)</b>	<b>REF</b>

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

# Assembly Drawing

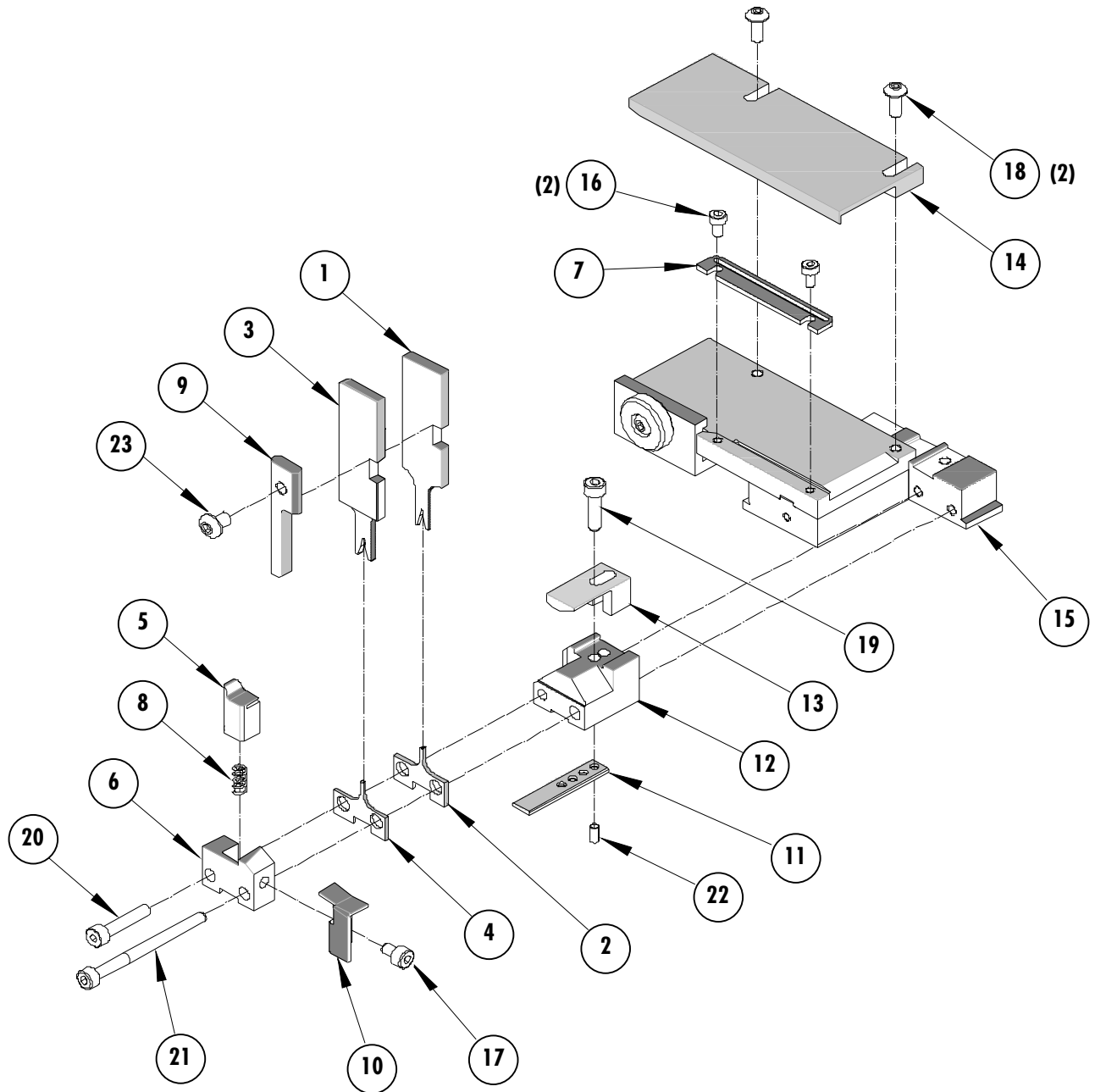


Figure 1

## 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).

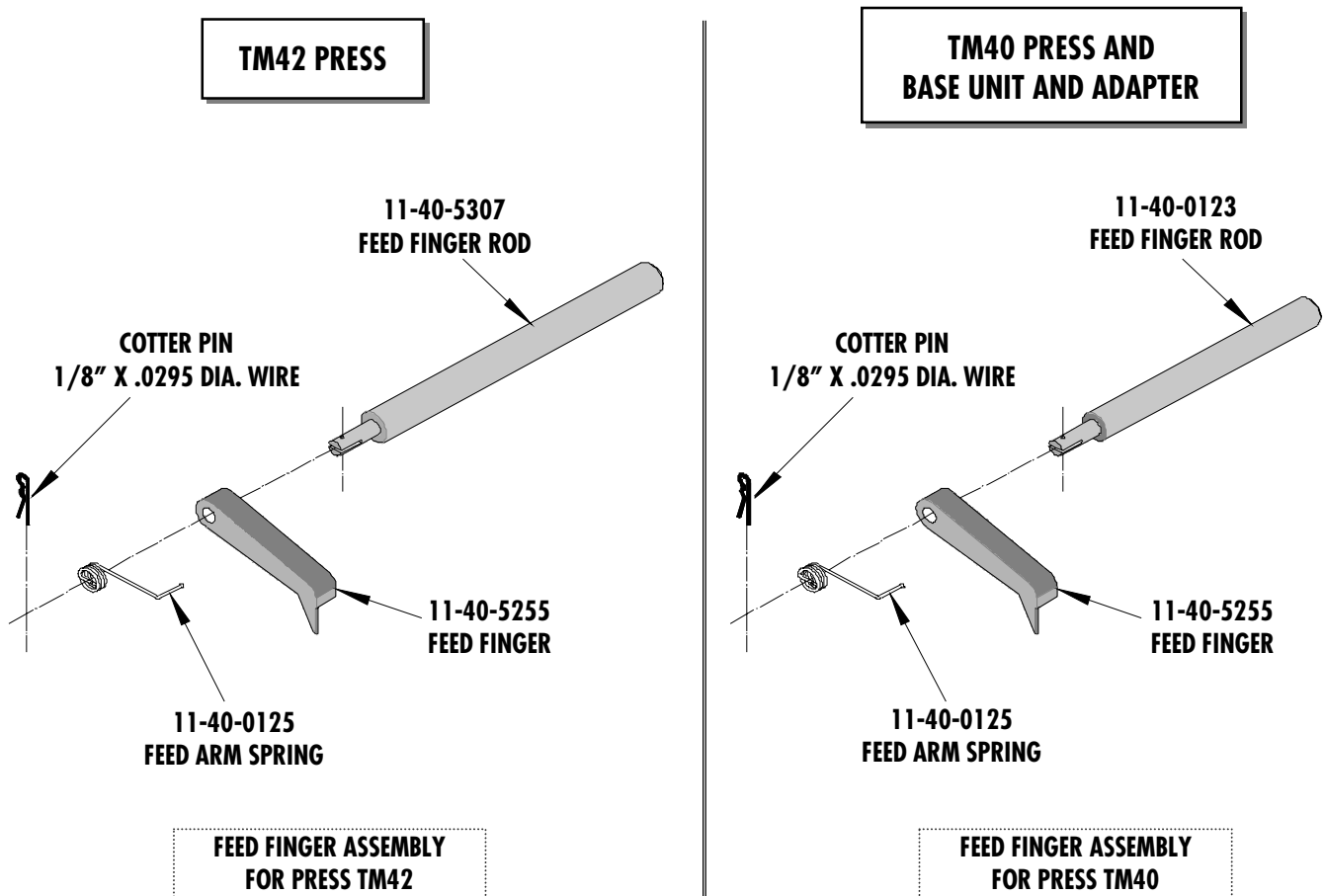


Figure 2

## 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, terminators and tooling.

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