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T2 Terminator for 2.50mm (.098") Pitch SPOX™ Male Crimp Terminal

T2 Terminator Tooling		
Application Tooling Specification Sheet		Order No. 63912-3100

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: 2.50mm (.098") Pitch SPOX™ Male Crimp Terminal, 22 - 28 AWG.

Terminal Series No.	Terminal Order No.		Wire Size		Insulation Diameter				Strip Length	
					IPC/WHMA-A620 (1)		Terminal (2)			
					mm	In.	mm	In.		
5263	08-70-1039	39-00-0042	22 - 28	0.35-0.08	1.40-1.60	.055-.063	1.15-1.90	.045-.075	2.40-2.90	.094-.114
	08-70-1045	39-00-0151								
	08-70-1047	39-00-0160								
	08-70-1048	98-00-0242								
45627	45627-0001	45627-1001	22 - 24	0.35-0.20	1.40-1.60	.055-.063	1.15-1.90	.045-.075	2.40-2.90	.094-.114
	45627-0002	45627-1002								

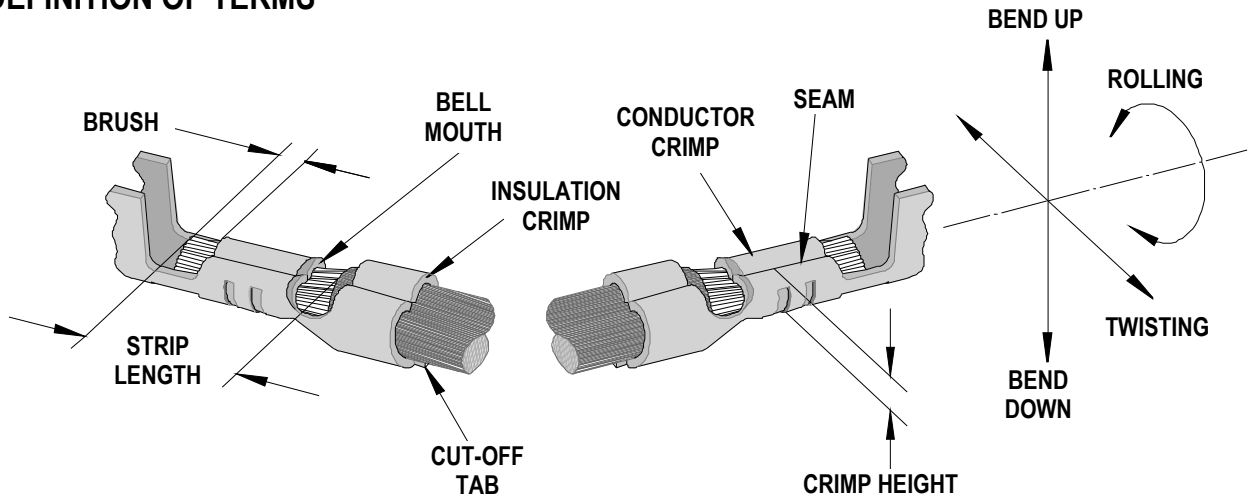
(1) To achieve optimum IPC-A620 insulation crimps, use this insulation OD range

(2) Overall insulation OD specification for terminal.

T2 Terminator 63912-6400 should be used for insulation OD 1.20-1.38mm

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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.
5263	0.20-0.50	.008-.020	0.30	.012	0.00-1.00	.000-.039
45627	0.20-0.50	.008-.020	0.30	.012	0.00-1.00	.000-.039

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		
	mm	In	mm	In	mm	In			
5263	4	2	8	8	1.40	.055	1.90	.075	
45627	4	2	8	8	1.40	.055	1.90	.075	

After crimping, the conductor profile should measure the following.

Terminal Series No.	Wire Size		Crimp Height		Pull Force Minimum	
	AWG	mm ²	mm	In.	N	Lb.
5263	22	0.35	0.69-0.76	.027-.030	39.1	8.8
	24	0.20	0.63-0.70	.025-.028	29.4	6.6
	26	0.12	0.59-0.65	.023-.026	19.6	4.4
	28	0.08	0.57-0.63	.022-.025	9.8	2.2
45627	22	0.35	0.69-0.76	.027-.030	39.1	8.8
	24	0.20	0.63-0.70	.025-.028	29.4	6.6

■ 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.

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PARTS LIST

T2 Terminator 63912-3100				
Item	Order No	Engineering No.	Description	Quantity
Perishable Tooling				
	63912-3170	63912-3170	Tool Kit (All "Y" Items)	REF
1	63444-1413	63444-1413	Conductor Punch	1 Y
2	63445-1435	63445-1435	Conductor Anvil	1 Y
3	63446-1906	63446-1906	Insulation Punch	1 Y
4	63445-1906	63445-1906	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
Other Components				
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	63443-0024	63443-0024	Key	1
12	63443-0085	63443-0085	Wire Stop L-Bracket	1
13	63443-0090	63443-0090	Wire Stop	1
14	63443-1718	63443-1718	Height Spacer	1
15	63443-2201	63443-2201	Coarse Spacer (1.00mm)	1
16	63443-2215	63443-2215	Coarse Spacer (15.00mm)	1
17	63443-2313	63443-2313	Fine Spacer (3.65mm)	1
18	63443-6011	63443-6011	Rear Cover	1
Frame				
19	63800-8500	63800-8500	T2 Terminator	1
Hardware				
20	N/A	N/A	M3 by 6 Long SHCS	2**
21	N/A	N/A	M3 by 6 Long FHCS	1**
22	N/A	N/A	M4 by 6 Long SHCS	2**
23	N/A	N/A	M4 by 12 Long BHCS	2**
24	N/A	N/A	M4 by 14 Long SHCS	2**
25	N/A	N/A	M4 by 50 Long SHCS	2**
26	N/A	N/A	M5 by 12 Long SHCS	1**
27	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).

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Assembly Drawing

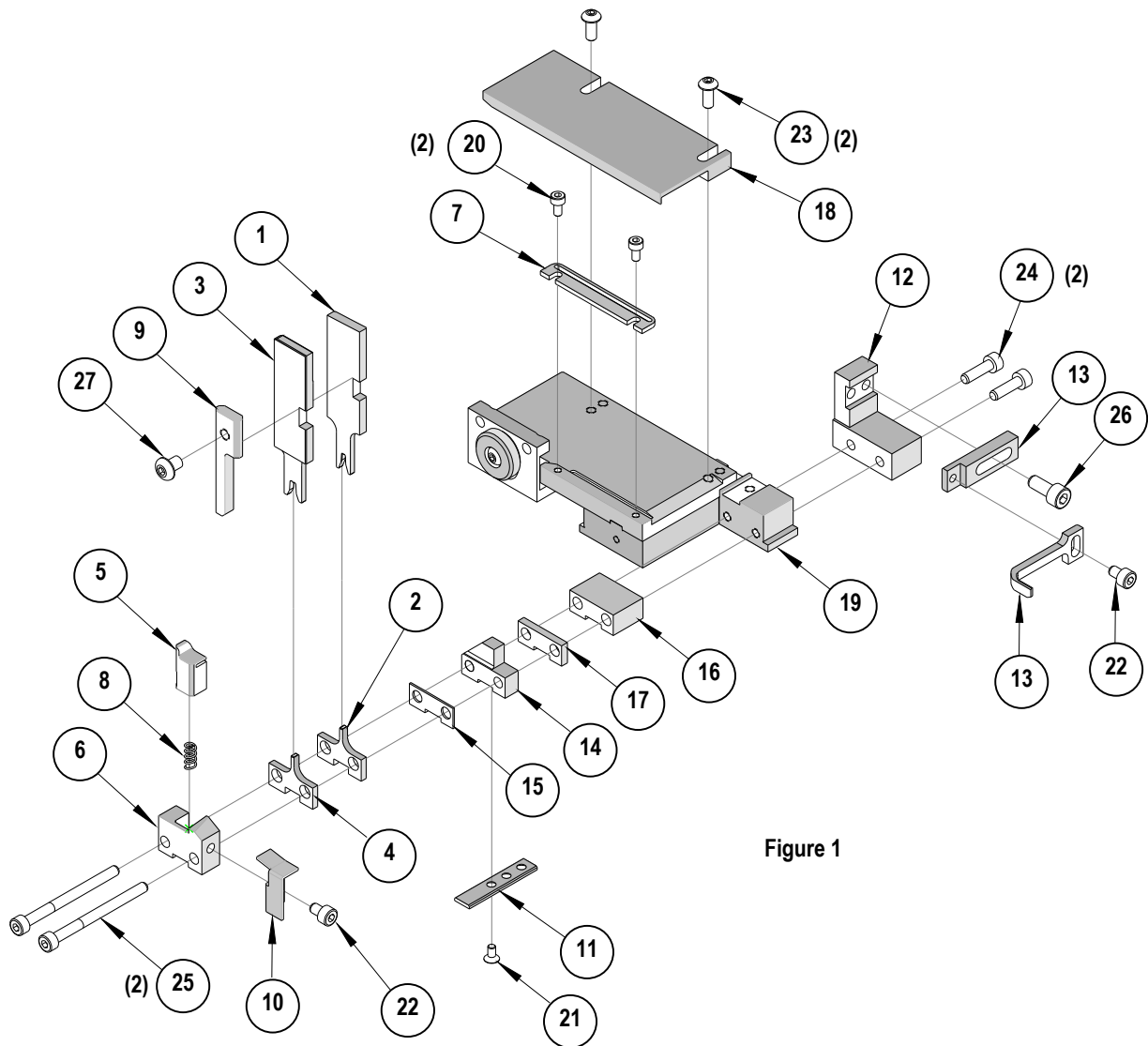


Figure 1

T2 Terminator for 2.50mm (.098") Pitch SPOX™ Male Crimp Terminal

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).

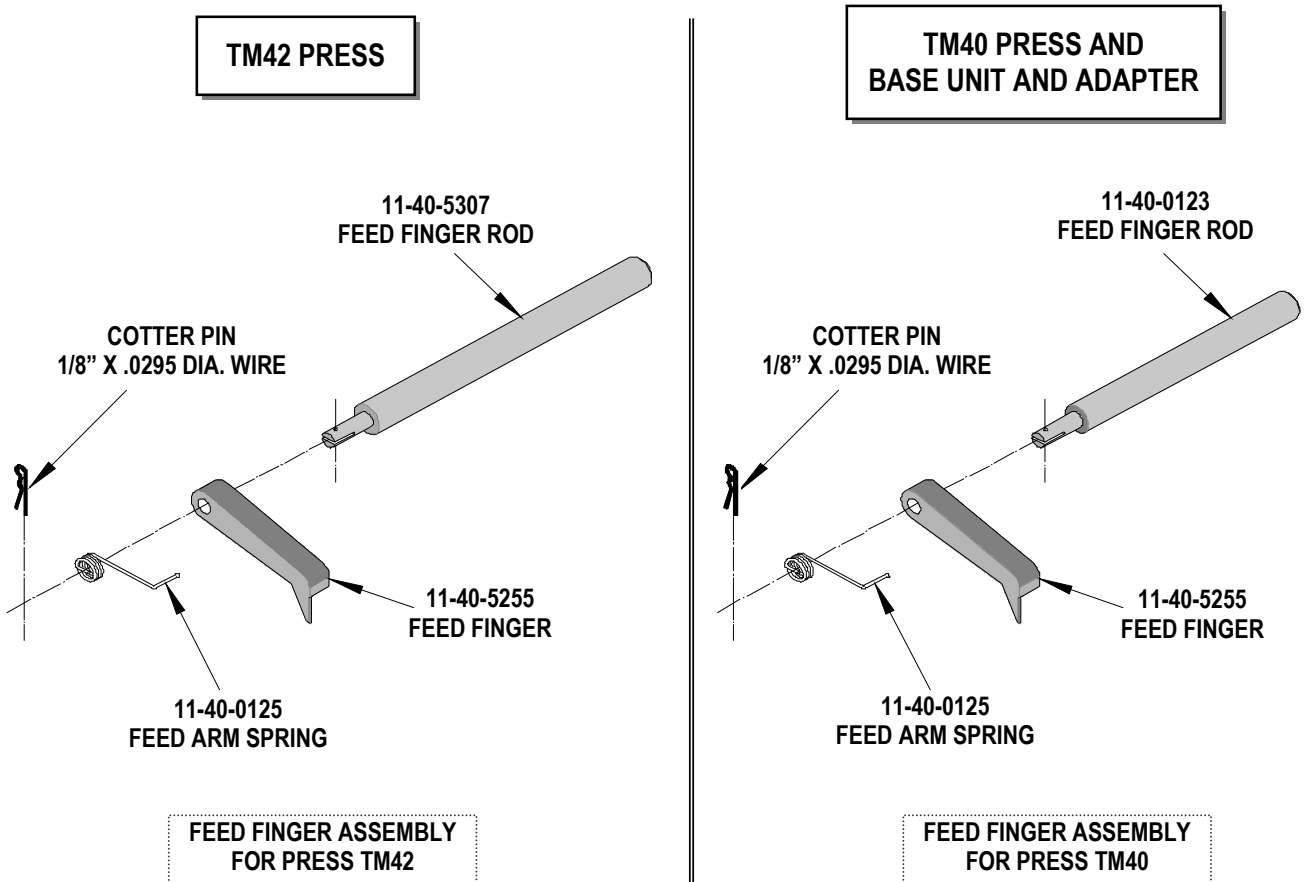


Figure 2

T2 Terminator for 2.50mm (.098") Pitch SPOX™ Male Crimp Terminal

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>