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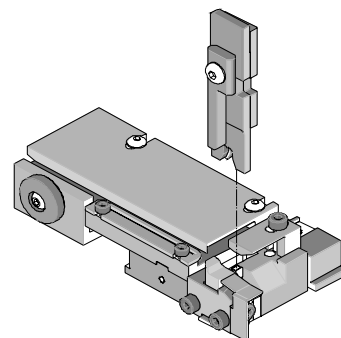
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T2 Terminator for Right Angle 2.00mm (.079") Board-in-Terminals



**T2 Terminator Tooling
 Specification Sheet
 Part No. 63853-2000**



FEATURES

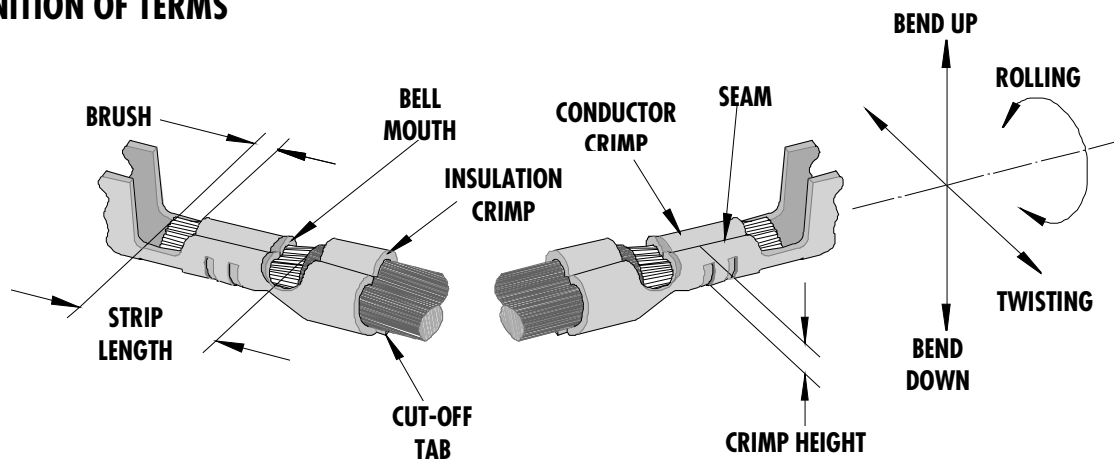
- It is ideally suited for mid-volume bench operations
- This terminator can be installed in the TM42 and the TM40 press or Base Unit adapter for 3BF press
- Quick punch removal with the push of a button for fast and easy tooling change
- Track adjustment capabilities in the T2 Terminators for improved 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: Right Angle, 2.00mm (.079") Board-In Terminal for 24-30 AWG.

Terminal Series No.	Terminal Order No.		Wire Size		Insulation Diameter Max		Strip Length	
			AWG	mm ²	mm	In.	mm	In.
35021	35021-1201	35021-1310	24-30	0.20-0.05	1.50	.059	1.80-2.20	.071-.087
	35021-1300	35021-1360						
	35021-1301							

DEFINITION OF TERMS



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

T2 Terminator for Right Angle 2.00mm (.079") Board-in-Terminals

CRIMP SPECIFICATION

Terminal Series No.	Bell mouth		Cut-off Tab Max.		Conductor Brush	
	mm	In.	mm	In.	mm	In.
35021	0.20-0.50	.008-.020	0.30	.012	0.0-1.0	0.0-.039

Terminal Series No.	Bend up Bend down		Twist	Roll	Punch Width mm (Ref)				Seam
	Degree				Degree		Conductor		
	mm	In	mm	In	mm	In	mm	In	
35021	3	3	3	3	1.20	.047	1.60	.063	Seam shall not be open and no wire allowed out of the crimping area

After crimping, the conductor profile should measure the following.

Terminal Series No.	Wire Size		Conductor			
			Crimp Height		Crimp Width (Ref)	
	AWG	mm ²	mm	In.	mm	In.
35021	24	0.20	0.75-0.80	.030-.032	1.22	.048
	26	0.13	0.75-0.80	.030-.032	1.22	.048
	28	0.08	0.68-0.73	.027-.029	1.22	.048
	30	0.05	0.65-0.70	.026-.028	1.22	.048

Terminal Series No.	Wire Size		Insulation				Pull Force Min.	
			Crimp Height (Ref)		Crimp Width (Ref)			
	AWG	mm ²	Mm	In.	mm	In.	N	Lb.
35021	24	0.20	1.50	.059	1.70	.067	29.4	6.60
	26	0.13	1.45	.057	1.70	.067	19.6	4.40
	28	0.08	1.40	.055	1.70	.067	9.8	2.20
	30	0.05	1.35	.053	1.70	.067	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.

T2 Terminator for Right Angle 2.00mm (.079") Board-in-Terminals

PARTS LIST

Terminator 63853-2000				
Item	Order No	Engineering No.	Description	Quantity
Perishable Tooling				
	63853-2070	63853-2070	Tool Kit (All "Y" Items)	REF
1	63863-2002	63863-2002	Conductor Punch	1 Y
2	63445-1213	63445-1213	Conductor Anvil	1 Y
3	63863-2003	63863-2003	Insulation Punch	1 Y
4	63445-1615	63445-1615	Insulation Anvil	1 Y
5	63443-0003	63443-0003	Cut-Off Plunger	1 Y
6	63443-0012	63443-0012	Front Plunger Retainer	1 Y
Other Components				
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	63443-2411	63443-2411	Anvil Mount	1
13	63443-4029	63443-4029	Wire Stop	1
14	63445-1613	63445-1613	Spacer Anvil	1
15	63443-6001	63443-6001	Rear Cover	1
Frame				
16	63800-8500	63800-8500	T2 Terminator	1
Hardware				
17	N/A	N/A	M3 by 6 Long SHCS	2**
18	N/A	N/A	M4 by 6 Long SHCS	1**
19	N/A	N/A	M4 by 10 Long BHCS	2**
20	N/A	N/A	M4 by 16 Long SHCS	1**
21	N/A	N/A	M4 by 20 Long SHCS	1**
22	N/A	N/A	M4 by 50 Long SHCS	1**
23	N/A	N/A	3MM by 6 Long Roll Pin	1**
24	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).				

T2 Terminator for Right Angle 2.00mm (.079") Board-in-Terminals

Assembly Drawing

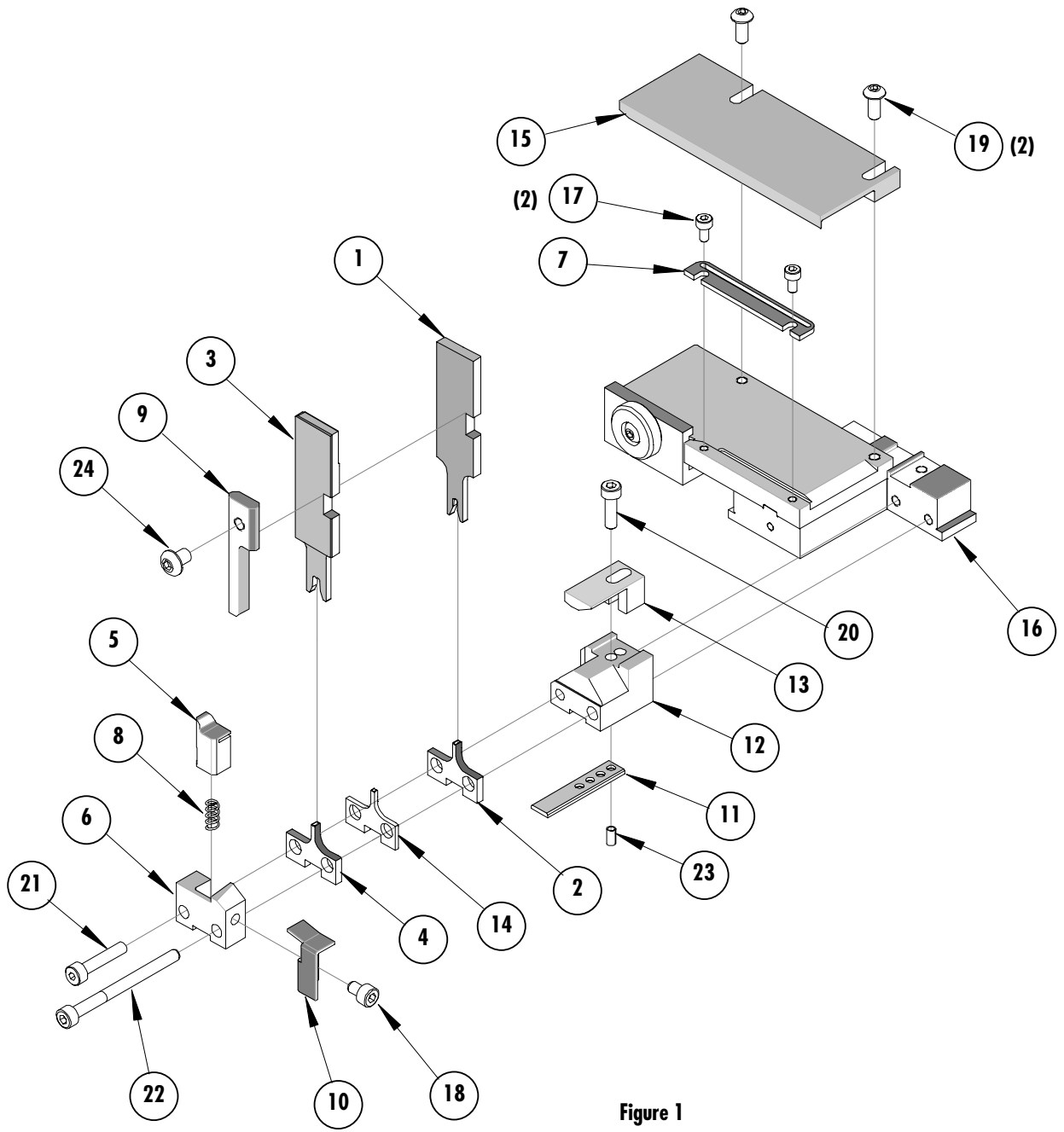


Figure 1

T2 Terminator for Right Angle 2.00mm (.079") Board-in-Terminals

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).

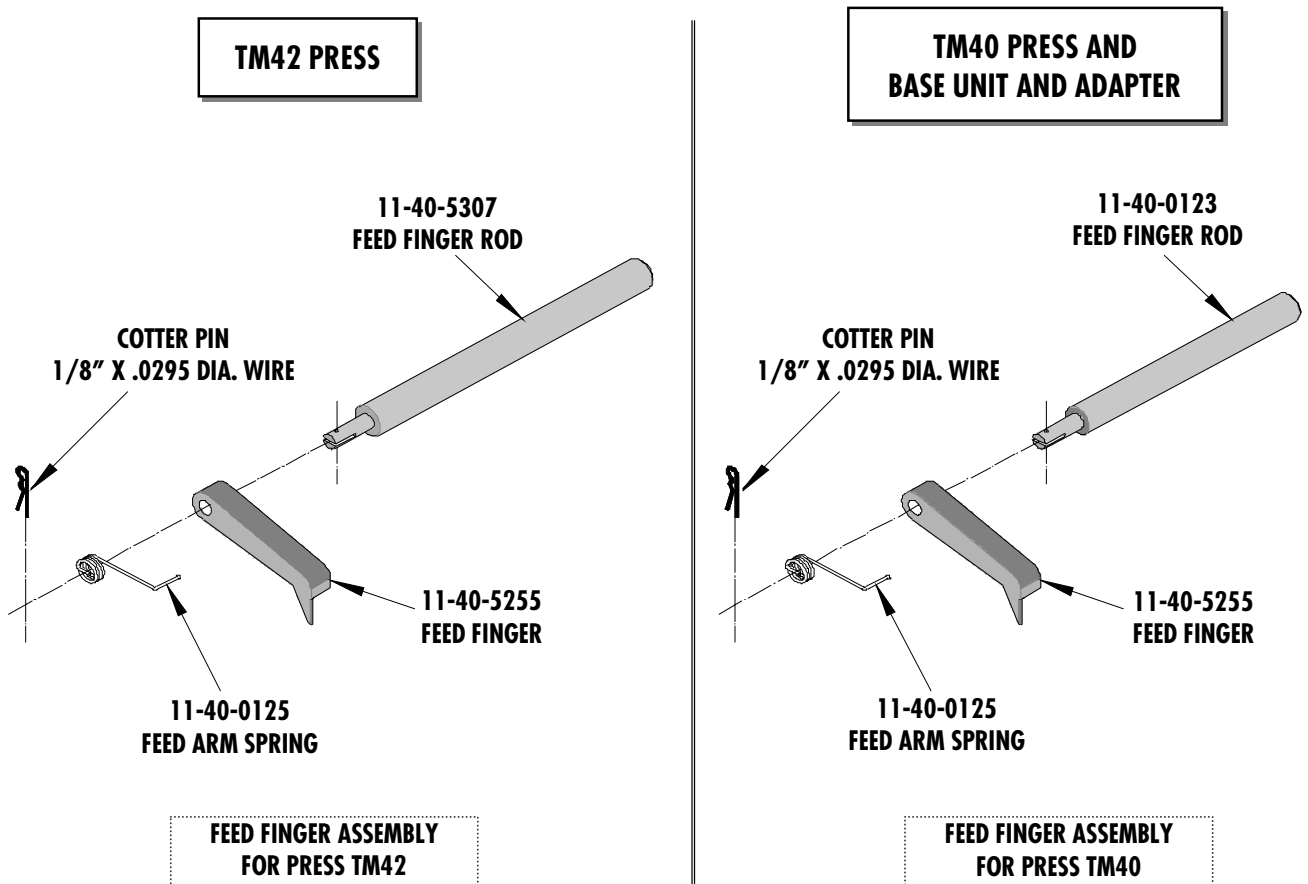


Figure 2

T2 Terminator for Right Angle 2.00mm (.079") Board-in-Terminals

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 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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