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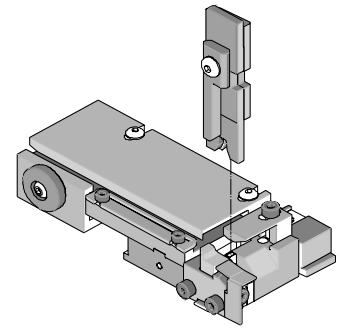
[Molex Connector Corporation](#)  
[0638544170](#)

For any questions, you can email us directly:

[sales@integrated-circuit.com](mailto:sales@integrated-circuit.com)



**T2 Terminator Tooling  
 Specification Sheet  
 Part No. 63854-4100  
 (Full Radius Insulation Crimp)**



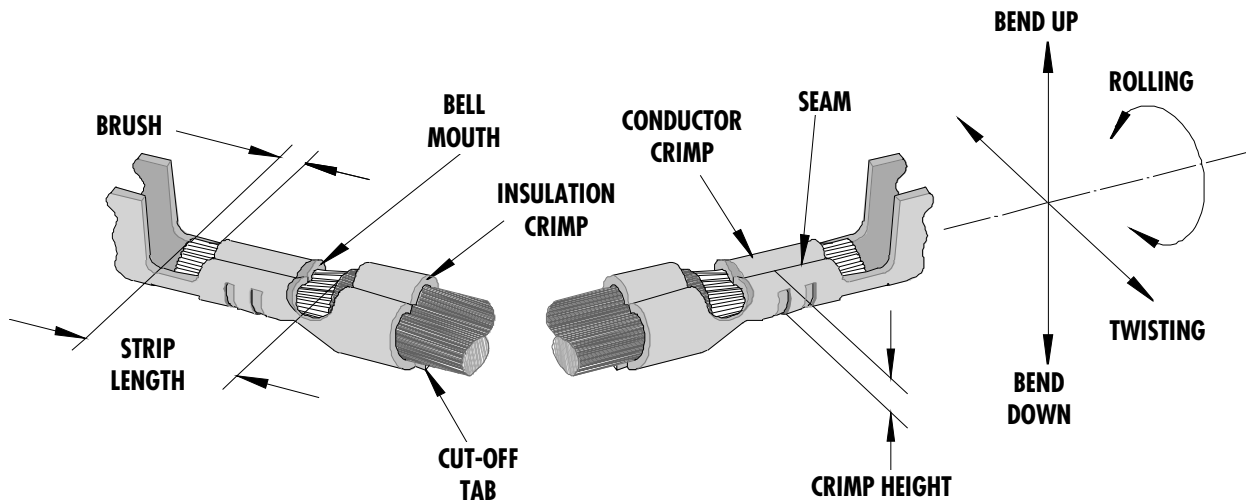
**FEATURES**

- 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
- Also available: 63854-4000 with standard "B" insulation crimp recommended for small and min. insulation diameter, (See Scope)

**SCOPE**

Terminal Series No.	Terminal Order No.	Wire Size		Insulation Diameter		Strip Length	
		AWG	mm <sup>2</sup>	mm	In.	mm	In.
42477	02-09-1615	14-18	0.81-2.07	2.36-3.56	.093-.140	3.96-5.33	.156-.218
42478	02-09-2611	14-18	0.81-2.07	2.36-3.56	.093-.140	3.96-5.33	.156-.218
	02-09-2612						

**DEFINITION OF TERMS**



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

63854-4100 T2 Terminator for .093 Pin and Socket Terminals

**CRIMP SPECIFICATION**

Terminal Series No.	Bell mouth		Cut-off Tab Max.		Conductor Brush	
	mm	In.	mm	In.	mm	In.
42477	0.25-0.58	.010-.023	0.25	.010	0.13-0.55	.005-.022
42478	0.25-0.58	.010-.023	0.25	.010	0.13-0.55	.005-.022

Terminal Series No.	Bend up	Bend down	Twist	Roll	Punch Width mm (Ref)				Seam Seam shall not be open and no wire allowed out of the crimping area
	Degree		Degree		Conductor		Insulation		
					mm	In	mm	In	
42477	3	3	4	8	2.30	.090	3.60	.141	
42478	3	3	4	8	2.30	.090	3.60	.141	

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.
42477	14	2.07	1.91-1.80	.075-.071	222.4	50.00
42477	16	1.31	1.70-1.60	.067-.063	177.9	40.00
42477	18	0.81	1.55-1.47	.061-.058	115.6	26.00
42478	14	2.07	1.91-1.80	.075-.071	222.4	50.00
42478	16	1.31	1.70-1.60	.067-.063	177.9	40.00
42478	18	0.81	1.55-1.47	.061-.058	115.6	26.00

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

The above specifications are guidelines to an optimum crimp.

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**PARTS LIST**

<b>T2 Terminator 63854-4100</b>				
<b>Item</b>	<b>Order No</b>	<b>Engineering No.</b>	<b>Description</b>	<b>Quantity</b>
<b>Perishable Tooling</b>				
	<b>63854-4170</b>	<b>63854-4170</b>	<b>Tool Kit (All "Y" Items)</b>	<b>REF</b>
1	63444-2323	63444-2323	Conductor Punch	1 Y
2	63445-2348	63445-2348	Conductor Anvil	1 Y
3	63446-3606	63446-3606	Insulation Punch-Full Radius	1 Y
4	63445-3613	63445-3613	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	Front Cover	1
8	11-24-1067	4996-4	Cut-off Plunger Spring	1
9	63443-0009	63443-0009	Scrape Chute	1
10	63443-0021	63443-0021	Lower Tooling Key	1
11	63443-2417	63443-2417	Anvil Mount	1
12	63443-3160	63443-3160	Front Plunger Striker	1
13	63443-4006	63443-4006	Wire Stop	1
14	63443-6011	63443-6011	Rear Cover	1
<b>Frame</b>				
15	63800-8500	63800-8500	T2 Terminator Frame	1
<b>Hardware</b>				
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 1/4"Lg. BHCS	1**
** Available from an industrial supply company such as MSC (1-800-645-7270).				



63854-4100 T2 Terminator for .093 Pin and Socket 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).

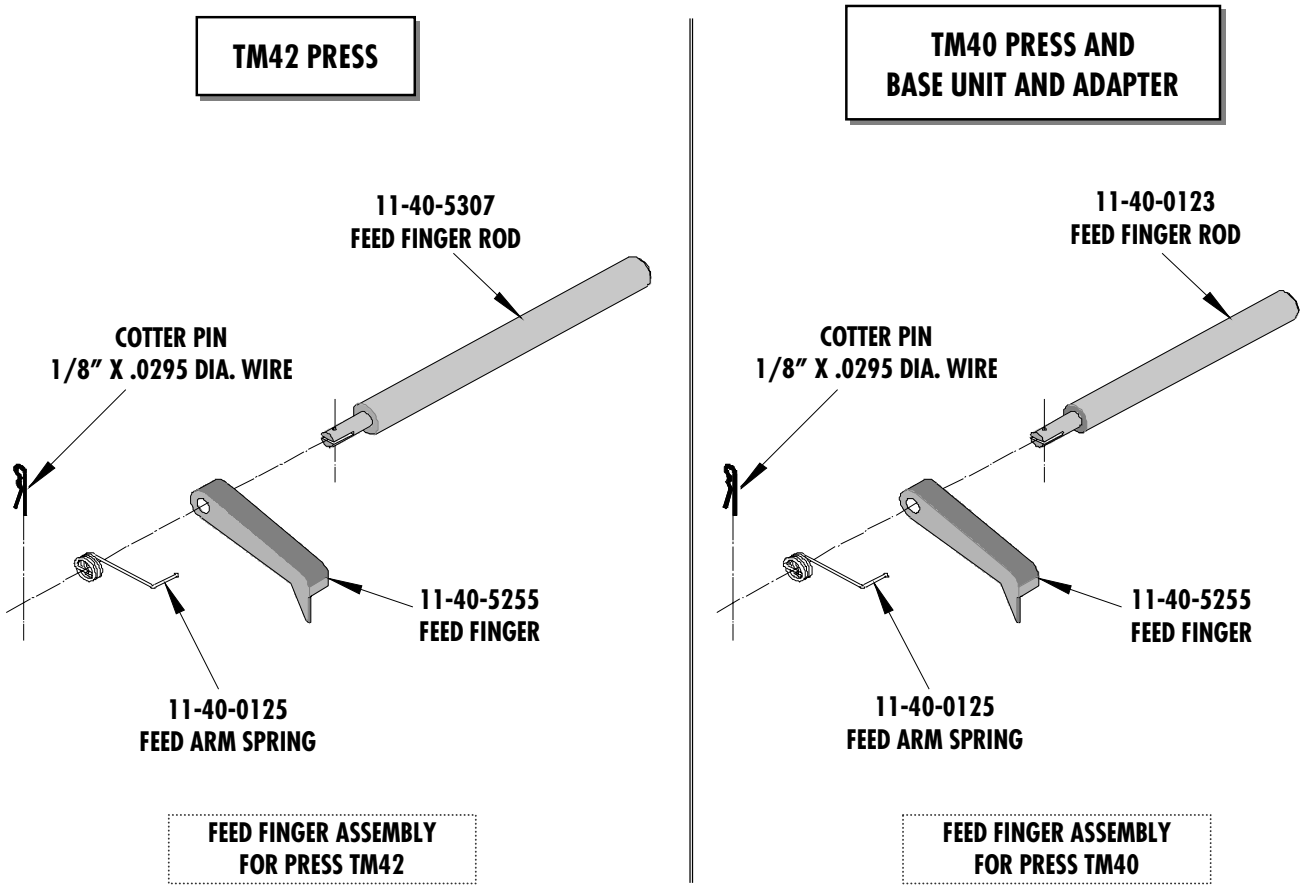


Figure 2

63854-4100 T2 Terminator for .093 Pin and Socket 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 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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