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Molex Connector Corporation
0639113000

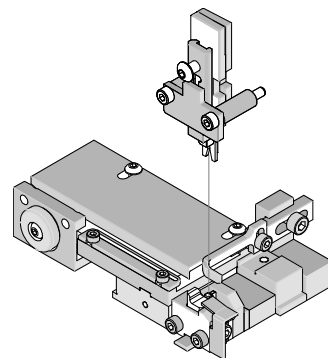For any questions, you can email us directly:
sales@integrated-circuit.com

T2 Terminator for Sabre™ Flat Blade Crimp Terminal

T2 Terminator Tooling Specification Sheet Part No. 63911-3000

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
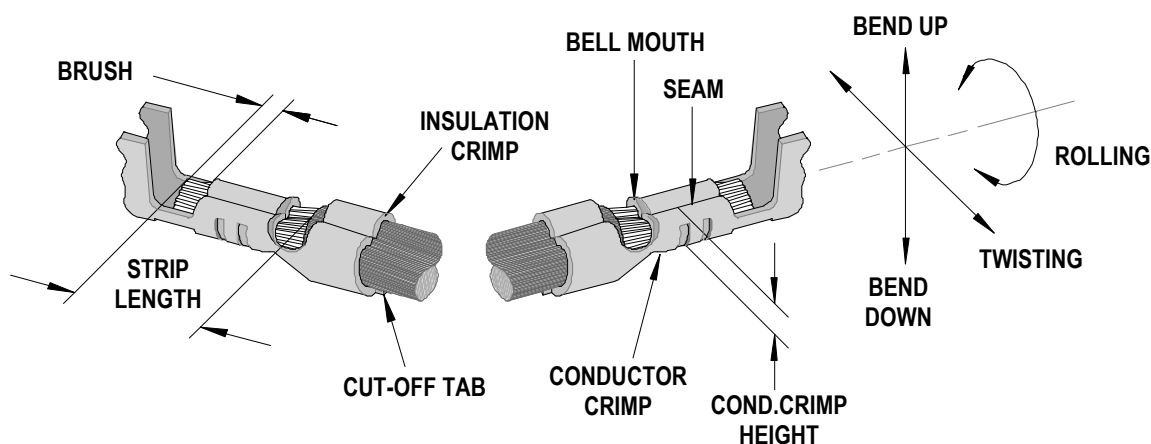
SCOPE

<u>Products</u>: Sabre™ Flat Blade Crimp Terminal (2) 20 AWG, UL1015 wires.

Terminal Series No.	Terminal Order No.	Wire Size		Insulation Diameter		Strip Length	
		AWG	mm²	mm	In.	mm	In.
43374	43374-5001	(2) 20	(2) 0.50	(2) 2.54	(2) 1.100	3.96-5.54	.156-.218
43375	43375-5001	(2) 20	(2) 0.50	(2) 2.54	(2) 1.100	3.96-5.54	.156-.218
Note: Terminal will accommodate the UL1015 wires. For UL1007 wires use Applicator 63901-2900.							

DEFINITION OF TERMS

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

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Datasheet of 0639113000 - T2 TERMINATOR ASSEMBLY
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CRIMP SPECIFICATION

Terminal Series No.	Bell mouth		Cut-off Tab Maximum		Conductor Brush Maximum	
	mm	In.	mm	In.	mm	In.
43374	0.20-0.50	.008-.020	0.30	.012	0.76	.030
43375						

Terminal Series No.	Bend up	Bend down	Twist	Roll	Punch Width (Ref)				Seam
					Conductor		Insulation		
	Degree (Max)		Degree (Max)		mm	In	mm	In	Seam shall not be open and no wire allowed out of the crimping area
43374	3	3	4	8	2.50	.098	4.30	.169	
43375									

After crimping, the conductor profile should measure the following.

Terminal Series No.	Wire Size		Conductor Crimp Height		Insulation Crimp Height (Ref)		Pull Force Minimum	
	AWG	mm²	mm	In.	mm	In.	N	Lb.
43374	(2) 20	(2) 0.50	1.23-1.31	.048-.051	3.30	.130	57.0	13.00
43375	(2) 20	(2) 0.50	1.23-1.31	.048-.051	3.30	.130	57.0	13.00

Pull Force should be measured with no influence from the insulation crimp.
The above specifications are guidelines to an optimum crimp.

T2 Terminator for Sabre™ Flat Blade Crimp Terminal

PARTS LIST

Item	Order No	Engineering No.	Description	Quantity
T2 Terminator 63911-3000				
Perishable Tooling				
	63911-3070	63911-3070	Tool Kit (All "Y" Items)	REF
1	63444-2513	63444-2513	Conductor Punch	1 Y
2	63445-2562	63445-2562	Conductor Anvil	1 Y
3	63446-4313	63446-4313	Insulation Punch	1 Y
4	63445-4317	63445-4317	Insulation Anvil	1 Y
5	63443-0035	63443-0035	Front Cut-Off Plunger	1 Y
6	63443-0036	63443-0036	Front Plunger Retainer	1 Y
Other Components				
7	11-18-4083	60707-8	Feed Guide	1
8	63443-0009	63443-0009	Scrap Chute	1
9	63443-0024	63443-0024	Key	1
10	63443-0085	63443-0085	Wire Stop L-Bracket	1
11	63443-0090	63443-0090	Wire Stop	1
12	63443-1719	63443-1719	18.90mm Spacer	1
13	63443-2215	63443-2215	15.00mm Spacer	1
14	63443-2302	63443-2302	3.10mm Spacer	1
15	63443-2801	63443-2801	Front Plunger Striker	1
16	63443-2913	63443-2913	Wire Hold Down Plunger	1
17	63443-6013	63443-6013	Rear Cover	1
18	63443-7201	63443-7201	Spring Cover	1
19	63600-1057	63600-1057	Striker Plunger Spring	1
20	63600-2972	63600-2972	Collar	2
21	63700-0539	63700-0539	Cut-Off Plunger Spring	1
Frame				
22	63800-8500	63800-8500	T2 Terminator	1
Hardware				
23	N/A	N/A	M3 by 6 Long SHCS	2**
24	N/A	N/A	M3 by 6 Long FHCS	1**
25	N/A	N/A	M4 by 6 Long SHCS	2**
26	N/A	N/A	M4 by 12 Long BHCS	2**
27	N/A	N/A	M4 by 14 Long SHCS	2**
28	N/A	N/A	M4 by 30 Long SHCS	2**
29	N/A	N/A	M4 by 50 Long SHCS	2**
30	N/A	N/A	M5 by 12 Long SHCS	1**
31	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).				

T2 Terminator for Sabre™ Flat Blade Crimp Terminal

Assembly Drawing
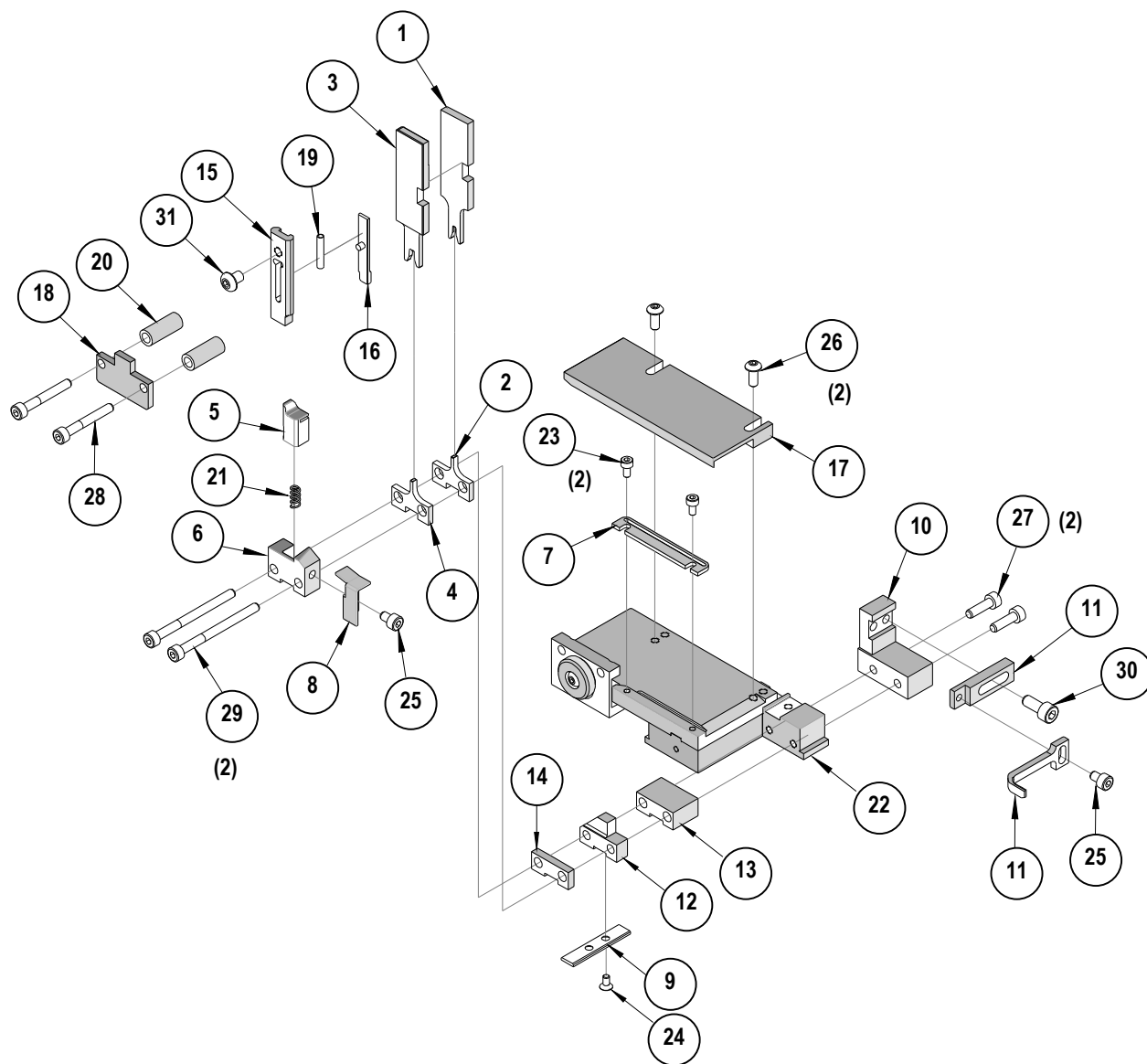
Figure 1

T2 Terminator for Sabre™ Flat Blade 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).
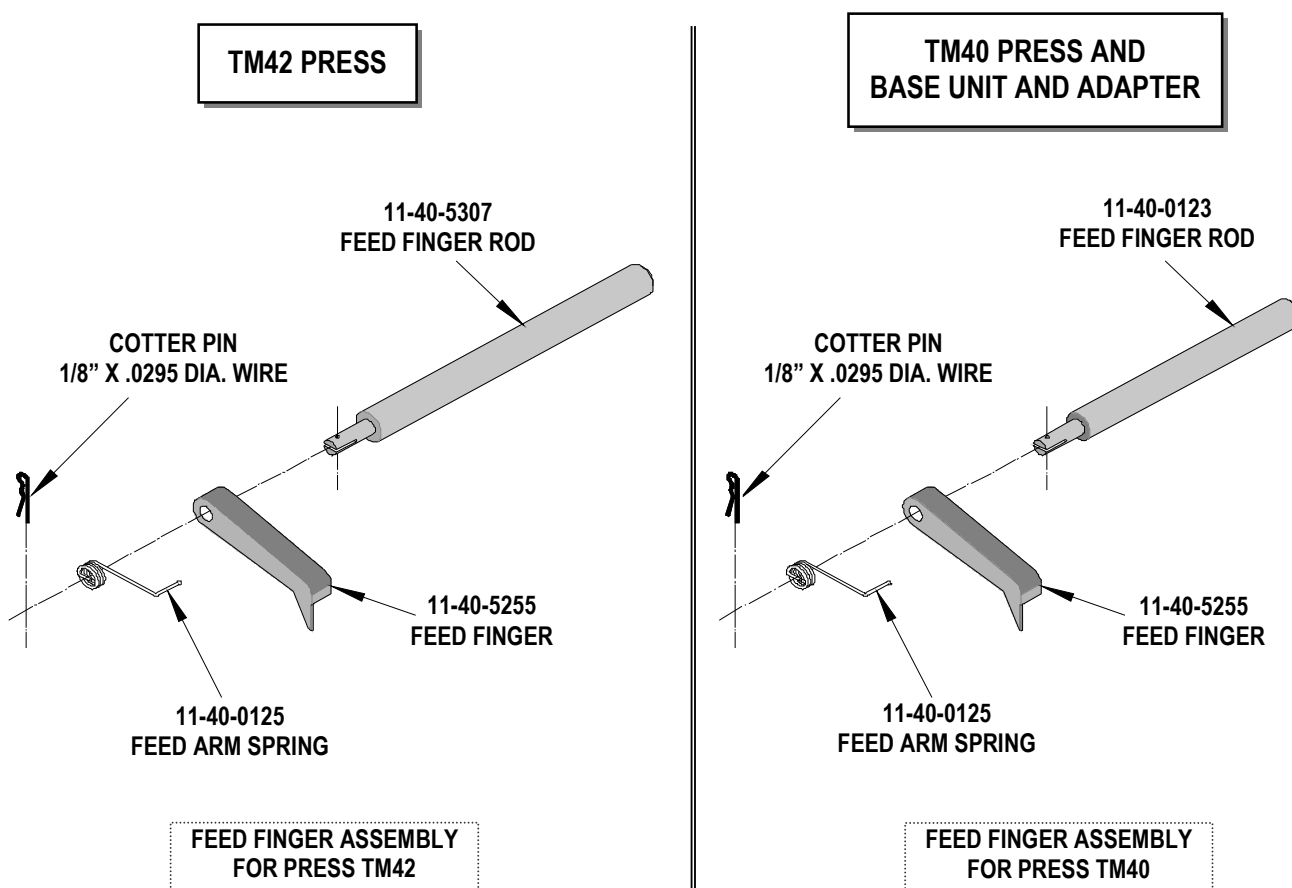

TM42 PRESS

TM40 PRESS AND
BASE UNIT AND ADAPTER

11-40-5307
FEED FINGER ROD

11-40-0123
FEED FINGER ROD

COTTER PIN
1/8" X .0295 DIA. WIRE

COTTER PIN
1/8" X .0295 DIA. WIRE

11-40-5255
FEED FINGER

11-40-5255
FEED FINGER

11-40-0125
FEED ARM SPRING

11-40-0125
FEED ARM SPRING

FEED FINGER ASSEMBLY
FOR PRESS TM42

FEED FINGER ASSEMBLY
FOR PRESS TM40

Figure 2

T2 Terminator for Sabre™ Flat Blade 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.

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