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0639114300

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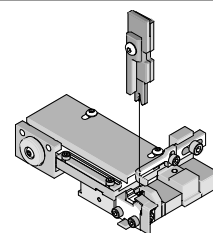sales@integrated-circuit.com

T2 Terminator for .070 Female Crimp Terminal

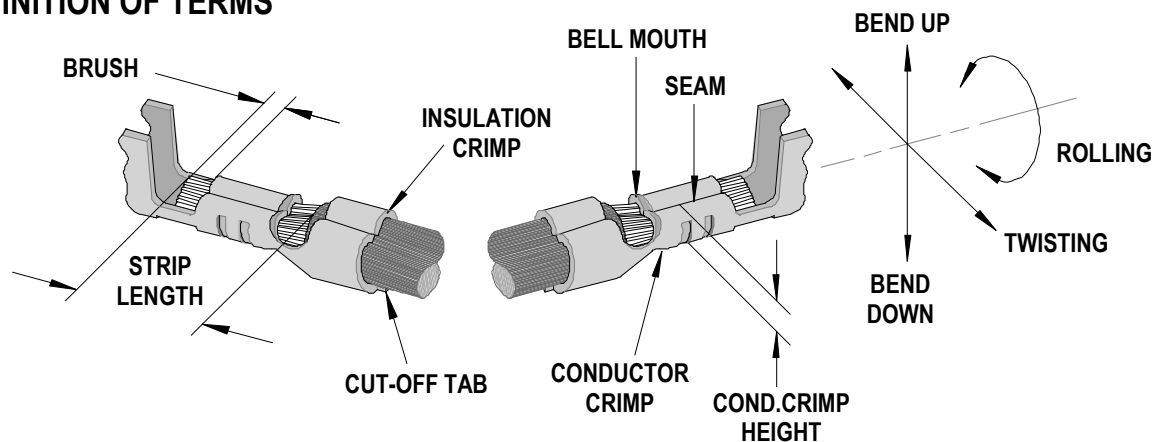| T2 Terminator Tooling	molex® Application Tooling Specification Sheet	
		Order No. 63911-4300

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: .070 Female Crimp Terminals, 24-26 AWG.

Terminal Series No.	Terminal Order No.	Wire Size		Insulation Diameter				Strip Length	
				IPC/WHMA-A60 (1)		Terminal (2)			
		AWG	mm²	mm	In.	mm	In.	mm	In.
35746	35746-0410	24	0.20	1.32-1.45	.052-.057	1.32-1.45	.052-.057	4.0-4.8	.157-.189
	35746-0411	26	0.12						
35748	35748-0410	24	0.20	1.32-1.45	.052-.057	1.32-1.45	.052-.057	4.0-4.8	.157-.189
	35748-0411	26	0.12						
(1) To achieve optimum IPC-A620 Class 2 insulation crimps, use this insulation OD.									
(2) Overall insulation OD specification for terminal.									

DEFINITION OF TERMS

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

T2 Terminator for .070 Female Crimp Terminal

CRIMP SPECIFICATION

Terminal Series No.	Bell mouth		Cut-off Tab Maximum		Conductor Brush	
	mm	In.	mm	In.	mm	In.
35746	0.2-0.5	.008-.020	0.40	.016	0.3-0.8	.012-.032
35748	0.2-0.5	.008-.020	0.40	.016	0.3-0.8	.012-.032

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
					Conductor		Insulation		
	Degree		Degree		mm	In	mm	In	
35746	3	3	3	5	1.40	.055	2.30	.091	
35748	3	3	3	5	1.40	.055	2.30	.091	

After crimping, the crimp profiles should measure the following:

Terminal Series No.	Wire Size		Conductor				Insulation				Pull Force Minimum	
			Crimp Height		Crimp Width (Ref)		Crimp Height (Ref)		Crimp Width (Ref)			
	AWG	mm²	mm	In.	mm	In.	mm	In.	mm	In.	N	Lb.
35746	24	0.20	1.00-1.10	.039-.043	1.40-1.60	.055-.063	2.55	.100	2.30-2.50	.091-.098	29.4	6.61
	26	0.12	0.90-1.00	.035-.039	1.40-1.60	.055-.063	2.45	.097	2.30-2.50	.091-.098	19.6	4.41
35748	24	0.20	1.00-1.10	.039-.043	1.40-1.60	.055-.063	2.55	.100	2.30-2.50	.091-.098	29.4	6.61
	26	0.12	0.90-1.00	.035-.039	1.40-1.60	.055-.063	2.45	.097	2.30-2.50	.091-.098	19.6	4.41

T 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.

T2 Terminator for .070 Female Crimp Terminal

PARTS LIST

Item	Order No	Engineering No.	Description	Quantity
T2 Terminator 63911-4300				
Perishable Tooling				
	63911-4370	63911-4370	Tool Kit (All "Y" Items)	REF
1	63444-1441	63444-1441	Conductor Punch	1 Y
2	63445-1467	63445-1467	Conductor Anvil	1 Y
3	63446-2313	63446-2313	Insulation Punch	1 Y
4	63445-2315	63445-2315	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	11-17-0022	1739-21	Hold Down Spring	1
8	11-18-4083	60707-8	Feed Guide	1
9	11-24-1067	4996-4	Cut-off Plunger Spring	1
10	11-40-4039	8302-5	Front Plunger Striker	1
11	63443-0009	63443-0009	Front Scrap Chute	1
12	63443-0024	63443-0024	Key	1
13	63443-0085	63443-0085	Wire Stop L-Bracket	1
14	63443-0090	63443-0090	Wire Stop	1
15	63443-0093	63443-0093	Shank	1
16	63443-1720	63443-1720	19.00mm Height Spacer	1
17	63443-2214	63443-2214	14.00mm Spacer	1
18	63443-2319	63443-2319	3.95mm Spacer	1
19	63443-6011	63443-6011	Rear Cover	1
20	63443-7115	63443-7115	Terminal Hold Down	1
Frame				
21	63800-8500	63800-8500	T2 Terminator	1
Hardware				
22	N/A	N/A	M3 by 6 Long FHCS	1**
23	N/A	N/A	M3 by 6 Long SHCS	2**
24	N/A	N/A	M3 by 8 Long SHCS	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 50 Long SHCS	2**
29	N/A	N/A	M5 by 12 Long SHCS	1**
30	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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Revision Date: 07-20-10
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Datasheet of 0639114300 - T2 TERMINATOR ASSEMBLY
Contact us: sales@integrated-circuit.com Website: www.integrated-circuit.com

T2 Terminator for .070 Female Crimp Terminal

Assembly Drawing

Figure 1

Doc No: ATS-639114300
Revision: B

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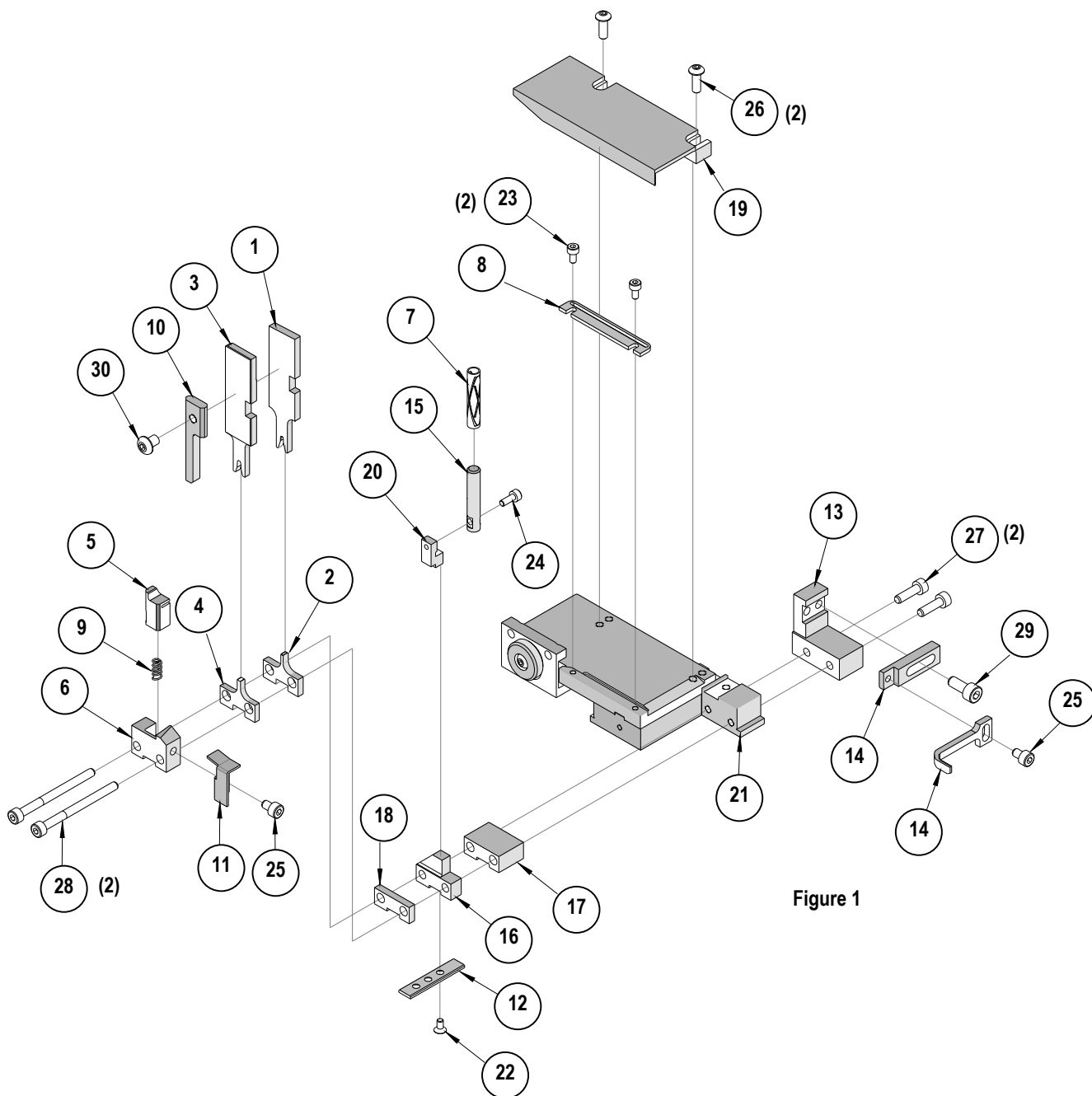Revision Date: 07-20-10

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T2 Terminator for .070 Female 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.
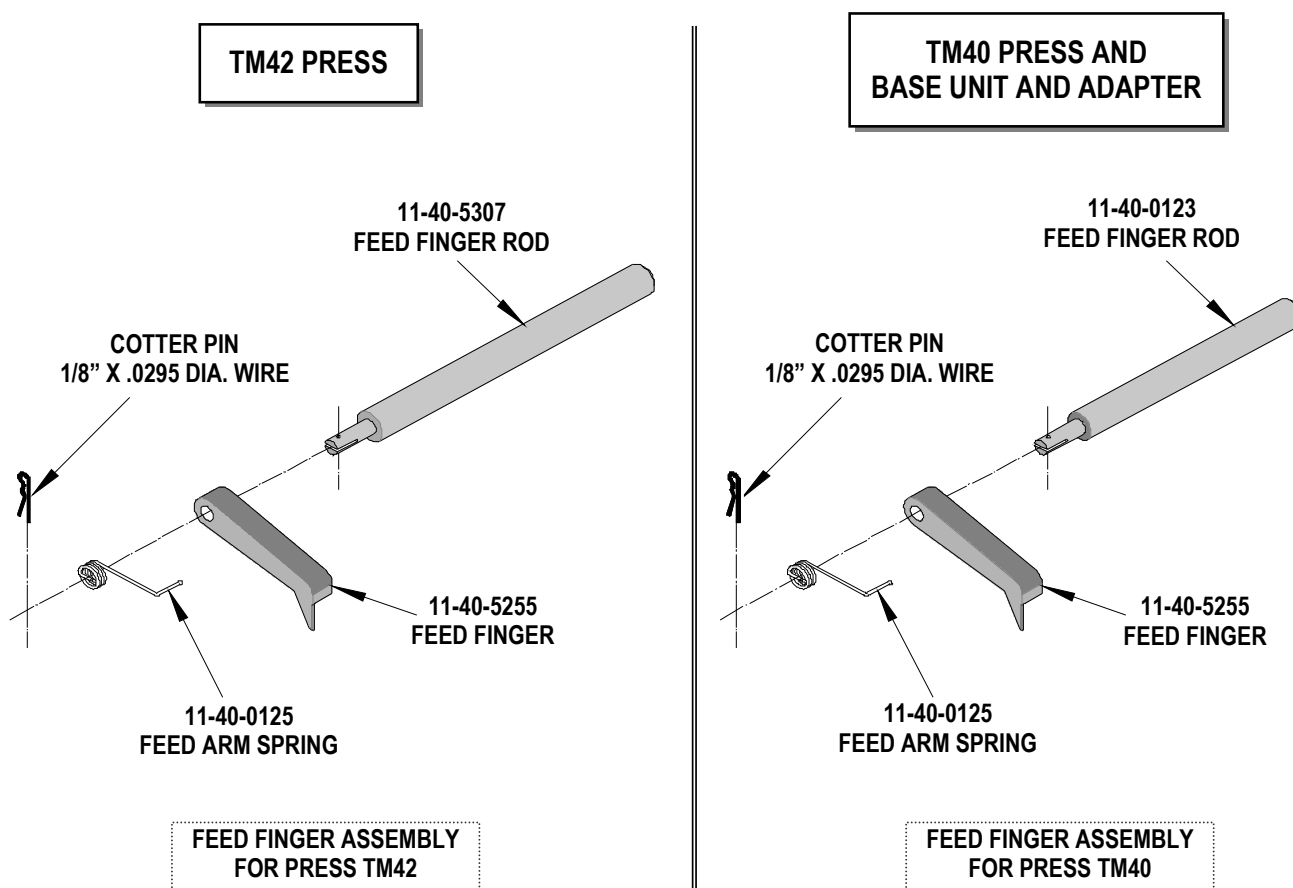6. Position feed finger for selected product. (Refer to Figure 5.1 in the T2 Manual).

TM42 PRESS	TM40 PRESS AND BASE UNIT AND ADAPTER

11-40-5307 FEED FINGER ROD

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

11-40-5255 FEED FINGER

11-40-0125 FEED ARM SPRING

FEED FINGER ASSEMBLY FOR PRESS TM42

11-40-0123 FEED FINGER ROD

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

11-40-5255 FEED FINGER

11-40-0125 FEED ARM SPRING

FEED FINGER ASSEMBLY FOR PRESS TM40

Figure 2

T2 Terminator for .070 Female 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 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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