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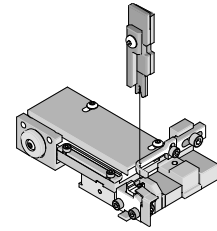
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T2 Terminator for 2.00mm (.079") Pitch Wire-to-Board Crimp Terminal

**T2 Terminator Tooling (Overlap Insulation Crimp)**



**Application Tooling Specification Sheet**



**Order No. 63912-4600**

**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

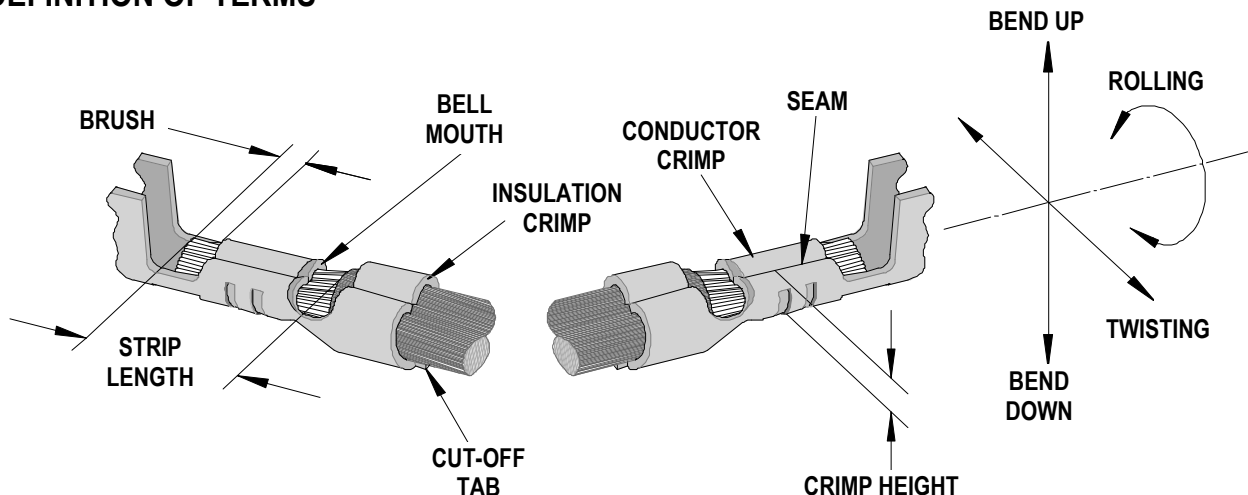
**SCOPE**

Products: Standard .093" (2.63mm) Pin and Socket Crimp Terminal

Terminal Order No.	Terminal Series No.		Wire Size		Insulation Diameter		Strip Length	
			AWG	mm <sup>2</sup>	mm	In.	mm	In.
42477	02-09-1615		16-18	0.81-1.30	2.36-3.20	.093-.126	3.96-5.33	.156-.218
42478	02-09-2611	02-09-2612	16-18	0.81-1.30	2.36-3.20	.093-.126	3.96-5.33	.156-.218

For 14AWG 2.79mm (.110") -3.56mm (.140") insulation diameter, use 63912-4700 Terminator.

**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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**CRIMP SPECIFICATION**

Terminal Series No.	Bell mouth		Cut-off Tab Maximum		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 (Ref)				Seam
					Conductor		Insulation		
	Degree	Degree	mm	In	mm	In			
42477	3	3	4	8	2.30	.090	3.60	.141	Seam shall not be open and no wire allowed out of the crimping area
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		Conductor Crimp Height		Pull Force Minimum	
	AWG	mm <sup>2</sup>	mm	In.	N	Lb.
42477	16	1.31	1.70-1.60	.067-.063	177.9	40.00
	18	0.81	1.55-1.47	.061-.058	115.6	26.00
42478	16	1.31	1.70-1.60	.067-.063	177.9	40.00
	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**

T2 Terminator 63912-4600				
Item	Order No	Engineering No.	Description	Quantity
<b>Perishable Tooling</b>				
	63912-4670	63912-4670	Tool Kit (All "Y" Items)	REF
1	63444-2325	63444-2325	Conductor Punch	1 Y
2	63445-2348	63445-2348	Conductor Anvil	1 Y
3	63454-0066	63454-0066	Insulation Punch	1 Y
4	63445-3614	63445-3614	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
<b>Other Components</b>				
7	11-18-4083	60707-8	Feed Guide	1
8	11-24-1067	4996-4	Cut-Off Plunger Spring	1
9	63443-3160	63443-3160	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	63443-1719	63443-1719	18.90mm Height Spacer	1
15	63443-2214	63443-2214	14.00mm Coarse Spacer	1
16	63443-2308	63443-2308	3.40mm Fine Spacer	1
17	63443-6011	63443-6011	Rear Cover	1
<b>Frame</b>				
18	63800-8500	63800-8500	T2 Terminator	1
<b>Hardware</b>				
19	N/A	N/A	M3 by 6 Long SHCS	2**
20	N/A	N/A	M3 by 6 Long FHCS	1**
21	N/A	N/A	M4 by 6 Long SHCS	2**
22	N/A	N/A	M4 by 12 Long BHCS	2**
23	N/A	N/A	M4 by 14 Long SHCS	2**
24	N/A	N/A	M4 by 50 Long SHCS	2**
25	N/A	N/A	M5 by 12 Long SHCS	1**
26	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**

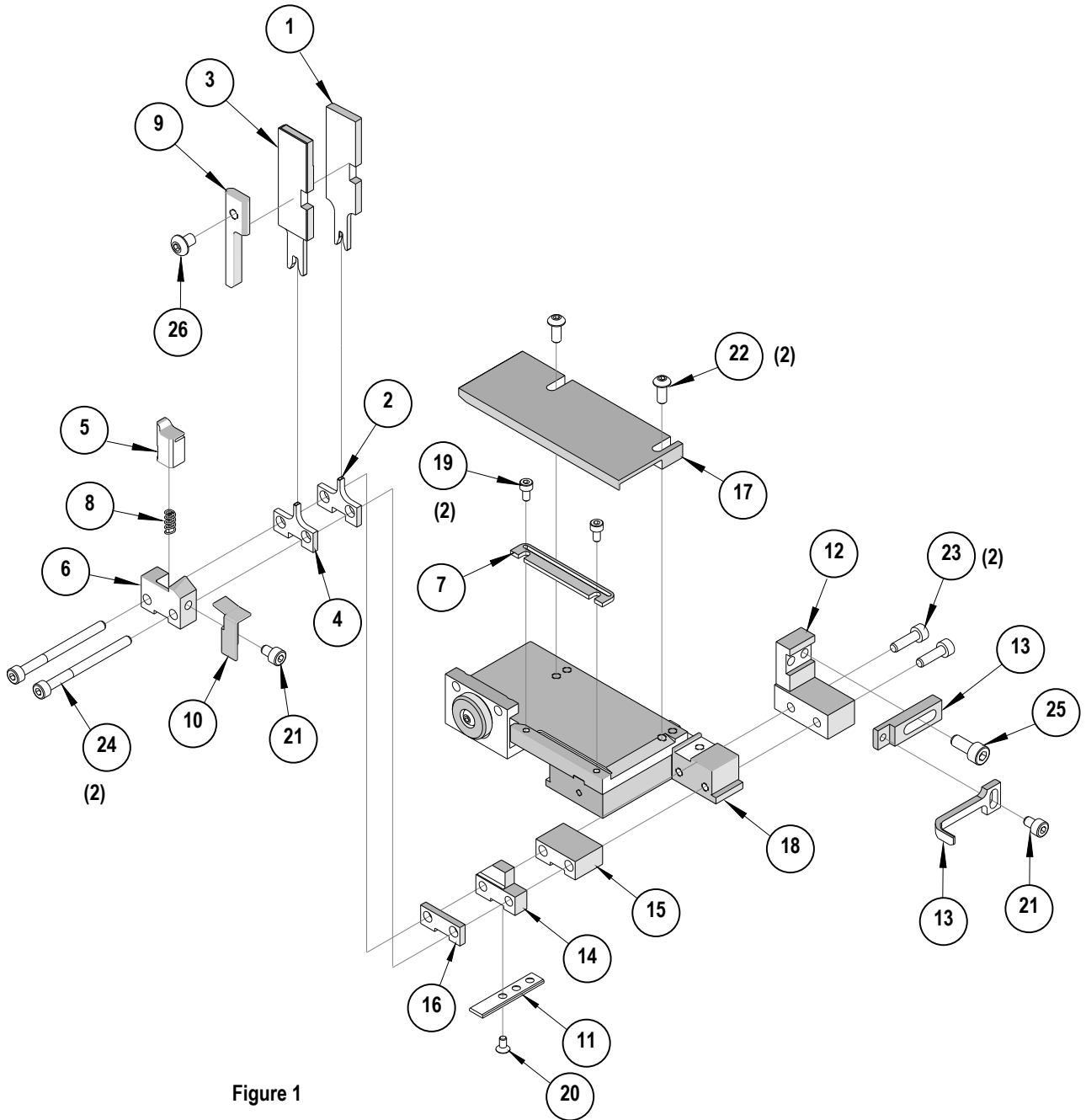


Figure 1

T2 Terminator for 2.00mm (.079") Pitch Wire-to-Board 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).

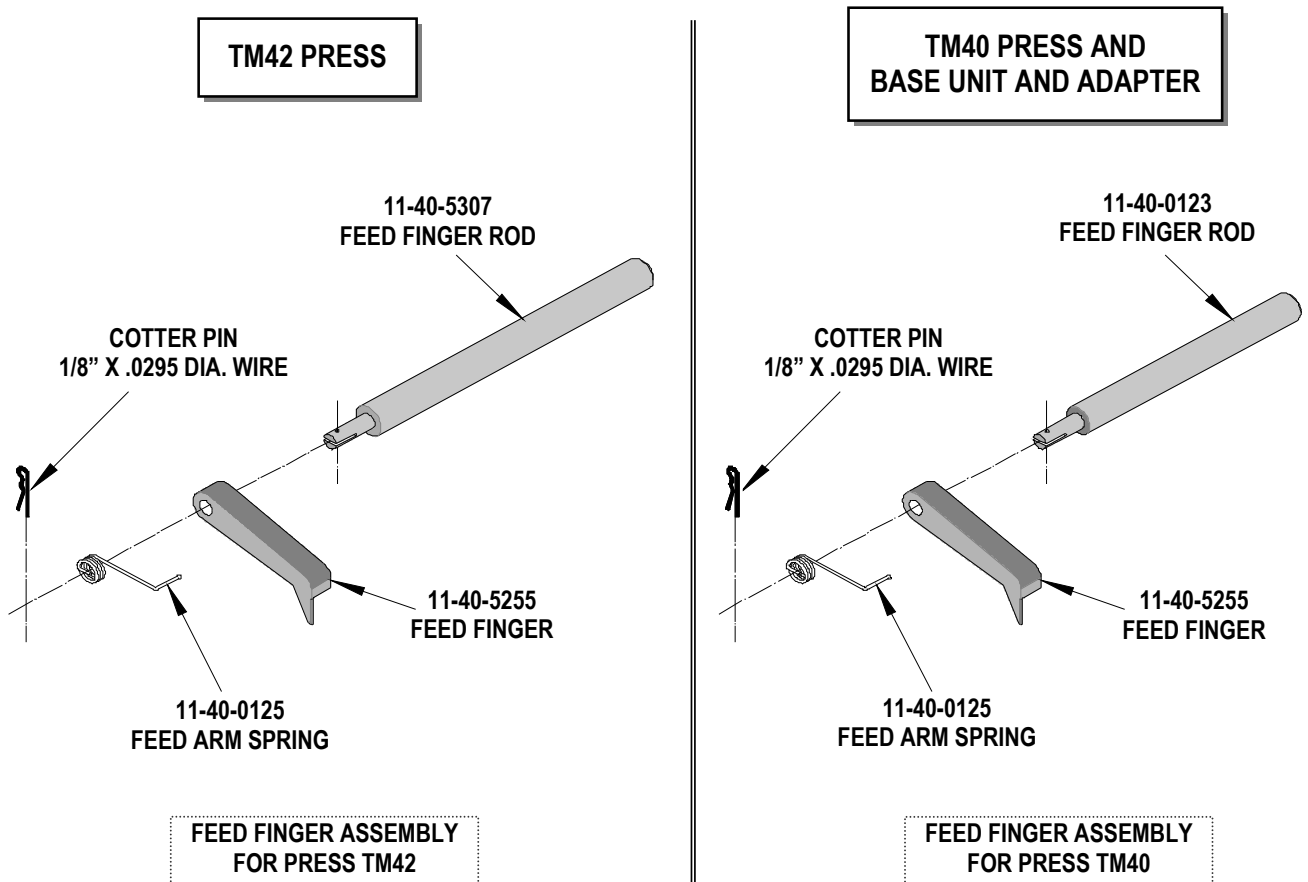


Figure 2

T2 Terminator for 2.00mm (.079") Pitch Wire-to-Board 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, terminators and tooling.

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