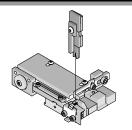




Application Tooling Specification Sheet



Order No. 63912-4600

## FEATURES

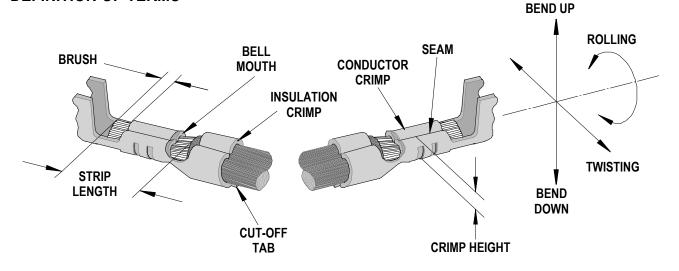
- This terminator can be installed in the TM42 and the TM40 press or Base Unit adapter for 3BF press
- It is ideally suited for mid-volume bench operations
- Quick punch removal with the push of a button for fast and easy tooling change
- Track adjustment capabilities in the T2 Terminators for improved 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	
Terminal Order No.			AWG	mm²	mm	ln.	mm	In.
42477	02-09-1615		16-18	0.81-1.30	2.36-3.20	.093126	3.96-5.33	.156218
42478	02-09-2611	02-09-2612	16-18	0.81-1.30	2.36-3.20	.093126	3.96-5.33	.156218
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 n	nouth	Cut-off Tak	o Maximum	Conductor Brush	
Terminal Series NO.	mm	In.	mm	ln.	mm	ln.
42477	0.25-0.58	.010023	0.25	.010	0.13-0.55	.005022
42478	0.25-0.58	.010023	0.25	.010	0.13-0.55	.005022

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

After crimping, the conductor profile should measure the following.

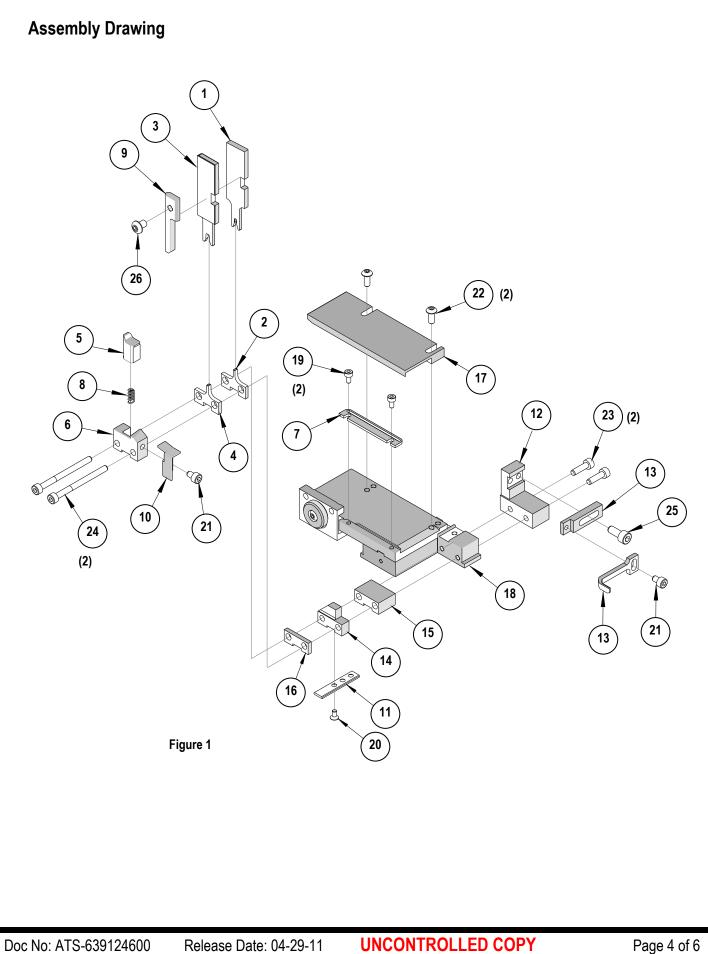
Terminal Series No.	Wire Size		Conductor C	rimp Height	Pull Force Minimum		
Terminal Series No.	AWG	mm <sup>2</sup>	mm	In.	Ν	Lb.	
42477	16	1.31	1.70-1.60	.067063	177.9	40.00	
	18	0.81	1.55-1.47	.061058	115.6	26.00	
42478	16	1.31	1.70-1.60	.067063	177.9	40.00	
	18	0.81	1.55-1.47	.061058	115.6	26.00	

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

The above specifications are guidelines to an optimum crimp.

# PARTS LIST

T2 Terminator 63912-4600									
Item	Order No Engineering No. Description		Quantity						
Perishable Tooling									
	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					
		Other Con	nponents						
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	Кеу	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					
	Frame								
18	63800-8500	63800-8500	T2 Terminator	1					
Hardware									
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**					
** Ava	** Available from an industrial supply company such as MSC (1-800-645-7270).								



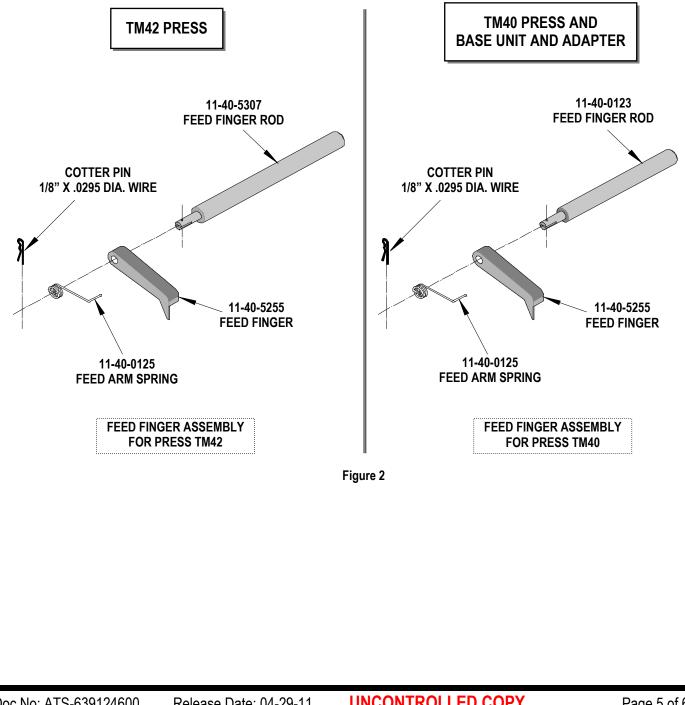
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# NOTES

#### 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).



### 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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