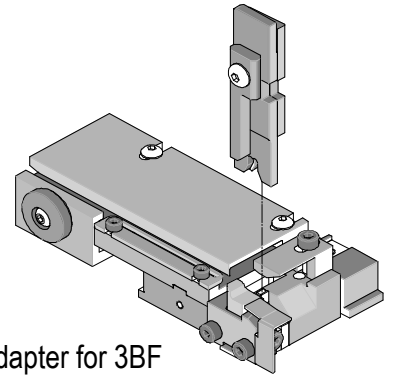




T2 Terminator Tooling Application Tooling Specification Sheet Order No. 63851-7100



FEATURES

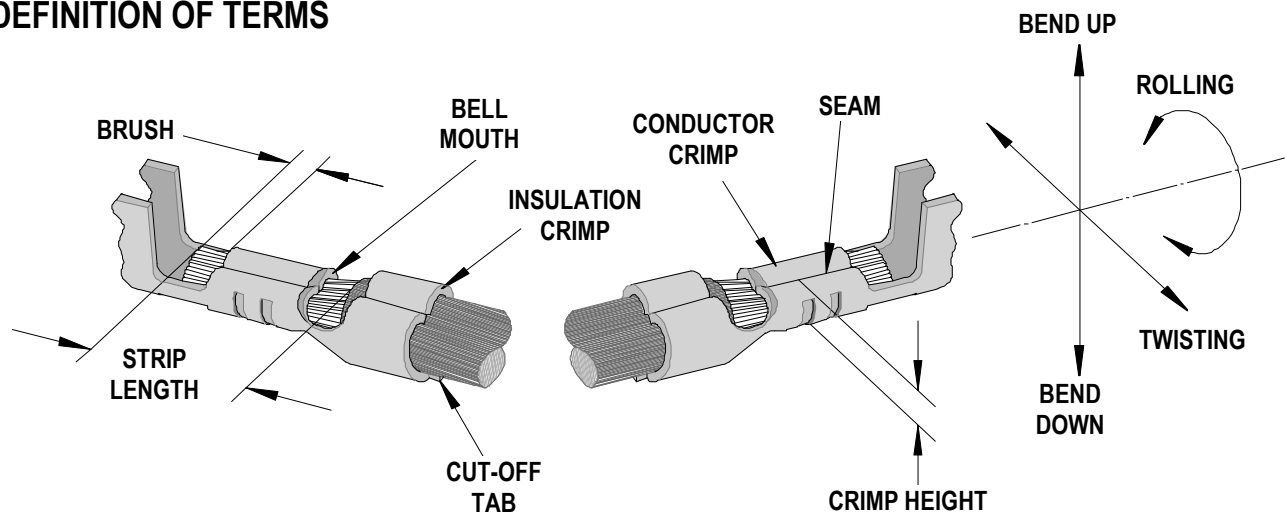
- This terminator can be installed in the TM42 and the TM40 press or Base Unit adapter for 3BF press
- It is ideally suited for mid-volume bench operations
- Quick punch removal with the push of a button for fast and easy tooling change
- Track adjustment capabilities in the T2 Terminators for improved 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: 2.5 Mini Splash Proof Wire-to-Wire Crimp Terminal 20-22 AWG.

Terminal Series No.	Terminal Order No.	Wire Size		Insulation Diameter		Strip Length	
		AWG	mm ²	mm	In.	mm	In.
50147 50148	50147-8000 50148-8000	22	---	1.40-1.90	.075-.055	2.00-2.50	.078-.098
			AVSS-0.3				
			CAVS-0.3				
			CAVUS-0.3				
		20	---				
			AVSS-0.5				
	CAVS-0.5						
			CAVUS-0.5				

DEFINITION OF TERMS



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

CRIMP SPECIFICATION

Terminal Series No.	Bell mouth		Cut-off Tab Maximum		Conductor Brush	
	mm	In.	mm	In.	mm	In.
50147	0.00-0.30	.000-.012	0.00-0.30	.000-.012	0.10-0.90	.004-.035
50148						

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
	Degree		Degree		Conductor		Insulation		
	mm	In	mm	In	mm	In	mm	In	
50147	2	3	3	10	1.40	.055	1.60	.063	
50148									

After crimping, the crimp profiles should measure the following:

Terminal Series No.	Wire Size		Conductor		Insulation		Pull Force Minimum		
			Crimp Height		Crimp Height Maximum				
	AWG	mm ²	mm	In.	mm	In.	N	Lb.	
50147 50148	22	---	0.94-0.99	.037-.039	1.70	.067	49.0	11.0	
		AVSS-0.3	0.94-0.99	.037-.039	1.70	.067	49.0	11.0	
		CAVS-0.3							
		20	---	0.96-1.06	.038-.042	1.80	.071	53.9	12.1
		AVSS-0.5	0.96-1.06	.038-.042	1.80	.071	53.9	12.1	
		CAVS-0.5							
		CAVUS-0.3	0.94-0.99	.037-.039	1.55	.061	49.0	11.0	
		CAVUS-0.5	0.96-1.06	.038-.042	1.80	.067	53.9	12.1	

■ 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.

PARTS LIST

T-2 Terminator 63851-7100				
Item	Order No	Engineering No.	Description	Quantity
Perishable Tooling				
	63851-7170	63851-7170	Tool Kit (All "Y" Items)	REF
1	63444-1407	63444-1407	Conductor Punch	1 Y
2	63445-1430	63445-1430	Conductor Anvil	1 Y
3	63454-1601	63454-1601	Insulation Punch	1 Y
4	63445-1615	63445-1615	Insulation Anvil	1 Y
5	63443-0002	63443-0002	Cut-Off Plunger	1 Y
6	63443-0012	63443-0012	Plunger Retainer Front	1 Y
Other Components (18050)				
7	11-18-4083	60707-8	Front Cover	1
8	11-24-1067	4996-4	Cut-off Plunger Spring	1
9	11-40-4039	8302-5	Plunger Striker Front	1
10	63443-0009	63443-0009	Scrap Chute Front	1
11	63443-0021	63443-0021	Lower Tooling Key	1
12	63443-2405	63443-2405	Anvil Mount	1
13	63443-4005	63443-4005	Wire Stop	1
14	63443-6003	63443-6003	Rear Cover	1
Frame				
15	63800-8500	63800-8500	T2 Terminator	1
Hardware				
16	N/A	N/A	M3 by 6 Long SHCS	2**
17	N/A	N/A	M4 by 6 Long SHCS	1**
18	N/A	N/A	M4 by 12 Long BHCS	2**
19	N/A	N/A	M4 by 16 Long SHCS	1**
20	N/A	N/A	M4 by 20 Long SHCS	1**
21	N/A	N/A	M4 by 50 Long SHCS	1**
22	N/A	N/A	3MM by 6 Long Roll Pin	1**
23	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).				

Assembly Drawing

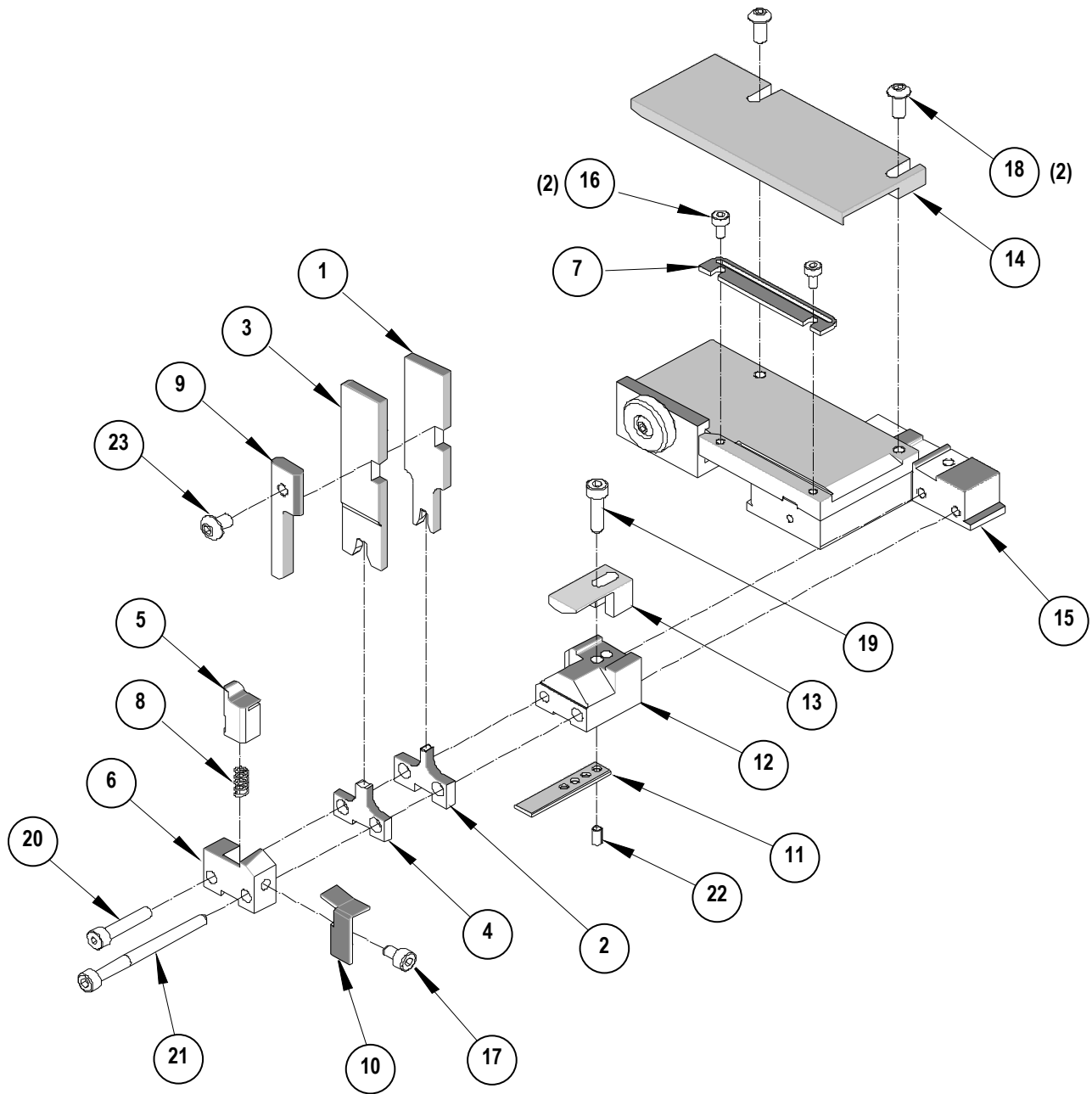


Figure 1

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).

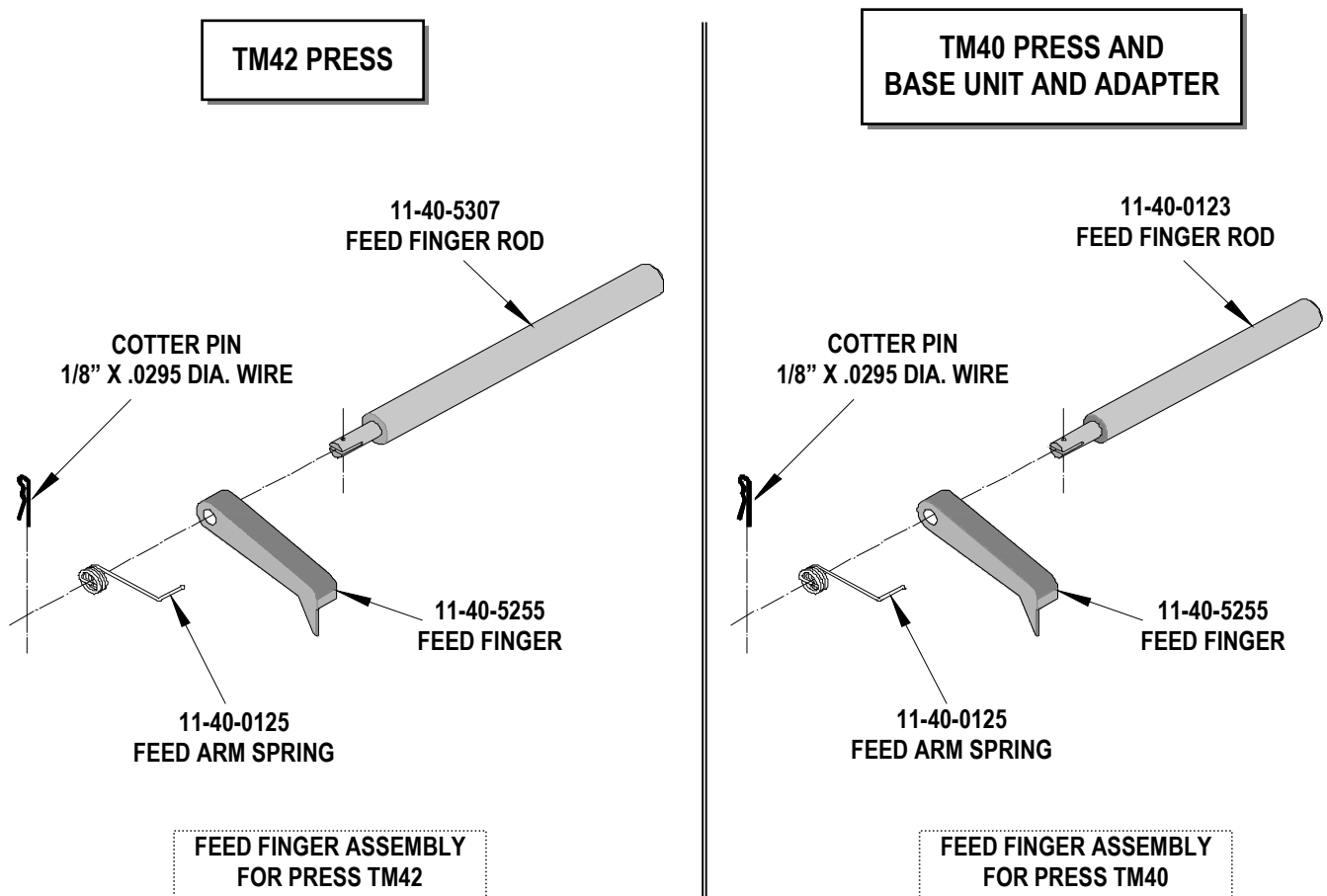


Figure 2

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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