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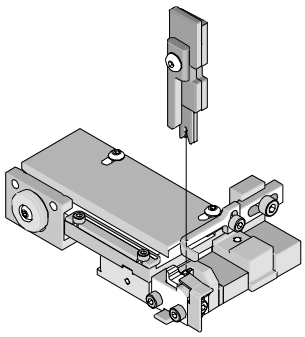
T2 Terminator Tooling Specification Sheet Order No. 63856-2000



FEATURES

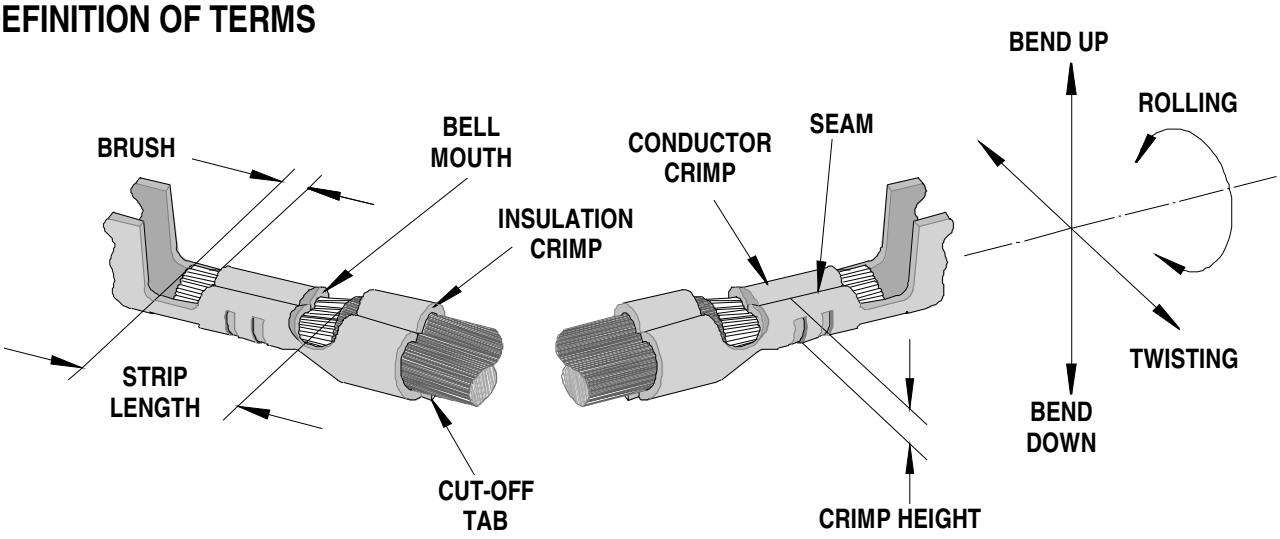
- It is ideally suited for mid-volume bench operations
- This terminator can be installed in the TM42 and the TM40 press or Base Unit adapter for 3BF press
- Quick punch removal with the push of a button for fast and easy tooling change
- Track adjustment capabilities in the T2 Terminators for improved 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: KK® 3.96mm (.156") Centers Female Terminals 18-20 AWG.

Terminal Series No.	Terminal Order No.	Wire Size		Insulation Diameter		Strip Length	
		AWG	mm²	mm	In.	mm	In.
45570	45570-3000	18-20	0.82-0.52	1.70-2.85	.067-.112	2.40-3.40	.094-.134
	45570-3002	18-20	0.82-0.52	1.70-2.85	.067-.112	2.40-3.40	.094-.134
	45570-3004	18-20	0.82-0.52	1.70-2.85	.067-.112	2.40-3.40	.094-.134

DEFINITION OF TERMS



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

CRIMP SPECIFICATION

Terminal Series No.	Bell mouth		Cut-off Tab Maximum		Conductor Brush	
	mm	In.	mm	In.	mm	In.
45570	0.20-0.50	.008-.020	0.40	.015	0.30-0.90	.012-.035

Terminal Series No.	Bend up	Bend down	Twist	Roll	Punch Width (Ref)				Seam
	Degree		Degree		Conductor		Insulation		
					mm	In	mm	In	
45570	5	1	4	8	1.80	.071	3.00	.118	Seam shall not be open and no wire allowed out of the crimping area

After crimping, the conductor profile should measure the following.

Terminal Series No.	Wire Size		Crimp Height		Pull Force Minimum	
	AWG	mm^2	mm	In.	N	Lb.
45570	18	0.82	1.20-1.30	.047-.051	89.0	20.00
	20	0.52	1.10-1.20	.043-.047	57.9	13.00

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 63856-2000				
Item	**Order No.**	**Engineering No.**	**Description**	**Quantity**
Perishable Tooling				
	63856-2070	63856-2070	Tool Kit (All "Y" Items)	REF
1	63444-1820	63444-1820	Conductor Punch	1 Y
2	63445-1836	63445-1836	Conductor Anvil	1 Y
3	63446-3002	63446-3002	Insulation Punch	1 Y
4	63445-3017	63445-3017	Insulation Anvil	1 Y
5	63443-0002	63443-0002	Cut-Off Plunger	2 Y
6	63443-0012	63443-0012	Front Plunger Retainer	1 Y
7	63443-1002	63443-1002	Rear Plunger Retainer	1 Y
8	63443-1403	63443-1403	Cut-off Die Blade	1 Y
Other Components (REF 562050)				
9	11-18-4083	60707-8	Feed Guide	1
10	11-24-1067	4996-4	Cut-Off Plunger Spring	2
11	63443-0025	63443-0025	Key	1
12	63443-0085	63443-0085	Wire Stop L-Bracket	1
13	63443-0091	63443-0091	Wire Stop	1
14	63443-1741	63443-1741	17.00mm Height Spacer	1
15	63443-2204	63443-2204	4.00mm Coarse Spacer	1
16	63443-2310	63443-2310	3.50mm Fine Spacer	1
17	63443-3160	63443-3160	Front Plunger Striker	1
18	63443-6009	63443-6009	Rear Cover	1
19	63459-0003	63459-0003	Relief Groove Terminal Track	1
20	63800-8502	63800-8502	Rear Plunger Striker	1
Frame				
21	63800-8500	63800-8500	T2 Terminator	1
Hardware				
22	N/A	N/A	M3 by 6 Long SHCS	2**
23	N/A	N/A	M3 by 6 Long FHCS	1**
24	N/A	N/A	M4 by 6 Long SHCS	1**
25	N/A	N/A	M4 by 12 Long BHCS	2**
26	N/A	N/A	M4 by 14 Long SHCS	2**
27	N/A	N/A	M4 by 30 Long SHCS	1**
28	N/A	N/A	M4 by 50 Long SHCS	1**
29	N/A	N/A	M5 by 10 Long SHCS	1**
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).				

Assembly Drawing

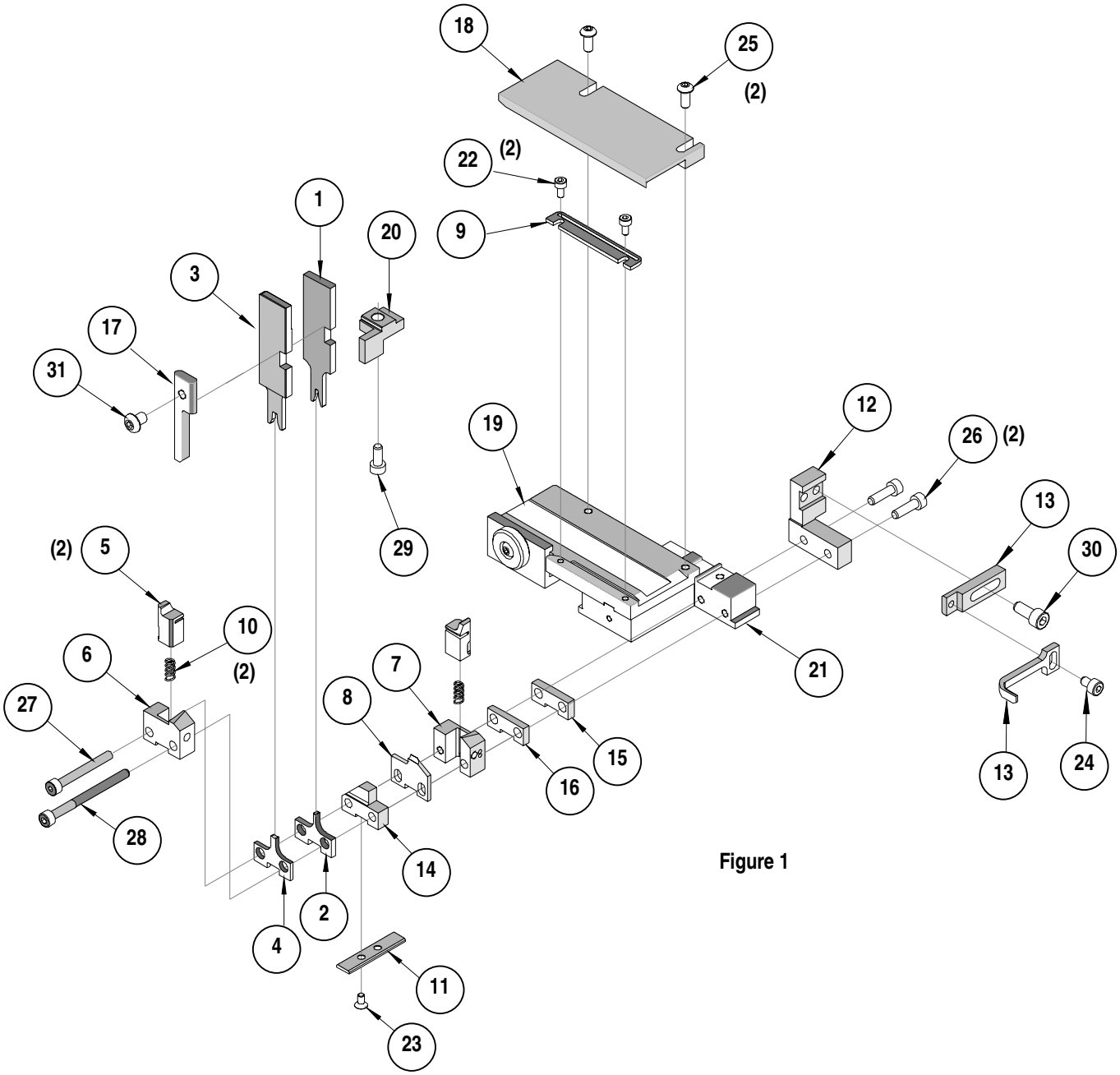


Figure 1

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).

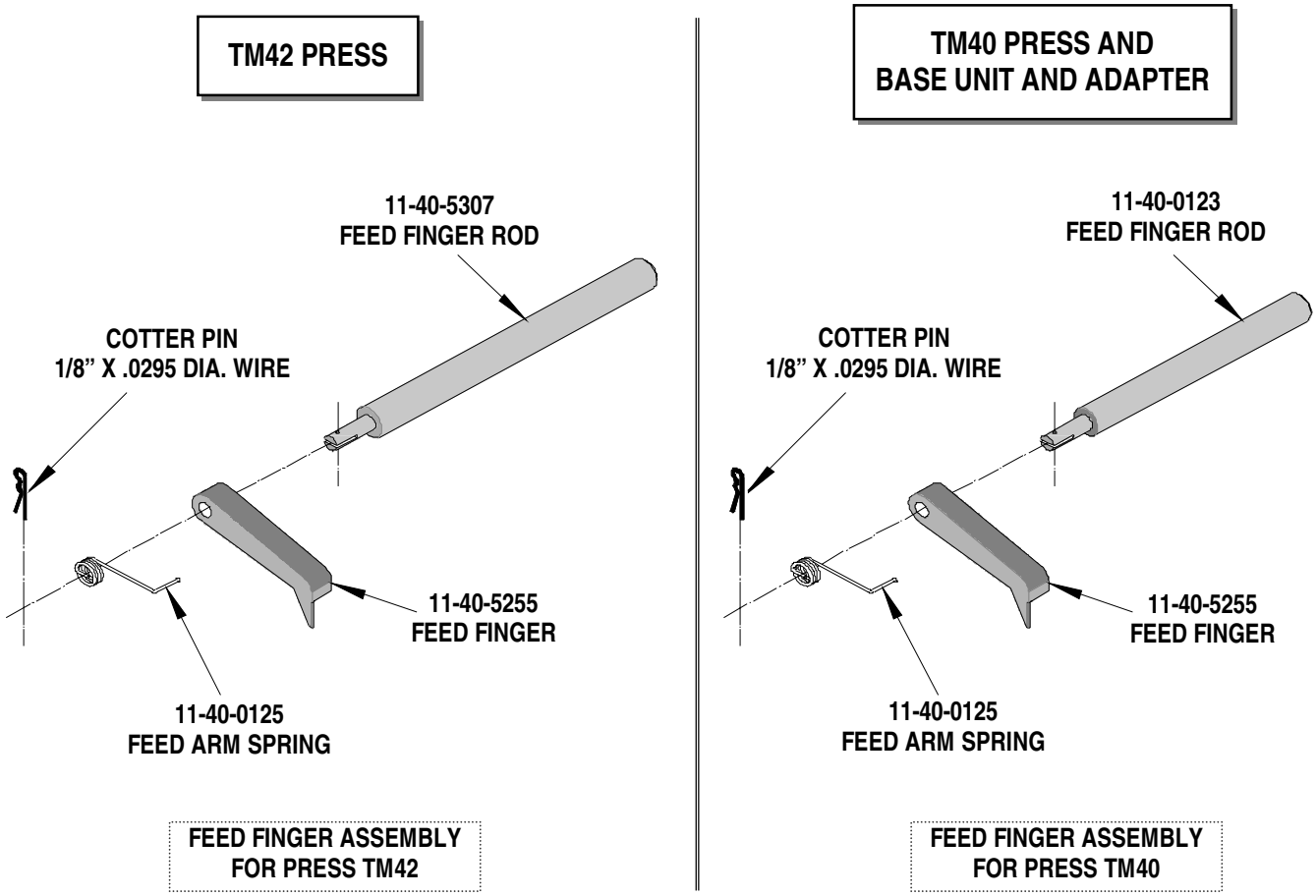


Figure 2

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 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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