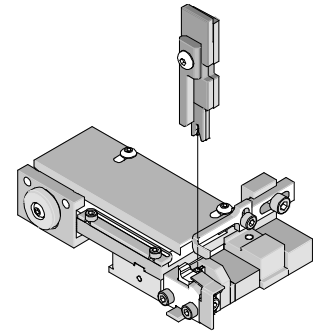




# T2 Terminator Tooling Specification Sheet Order No. 63910-0100



## 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

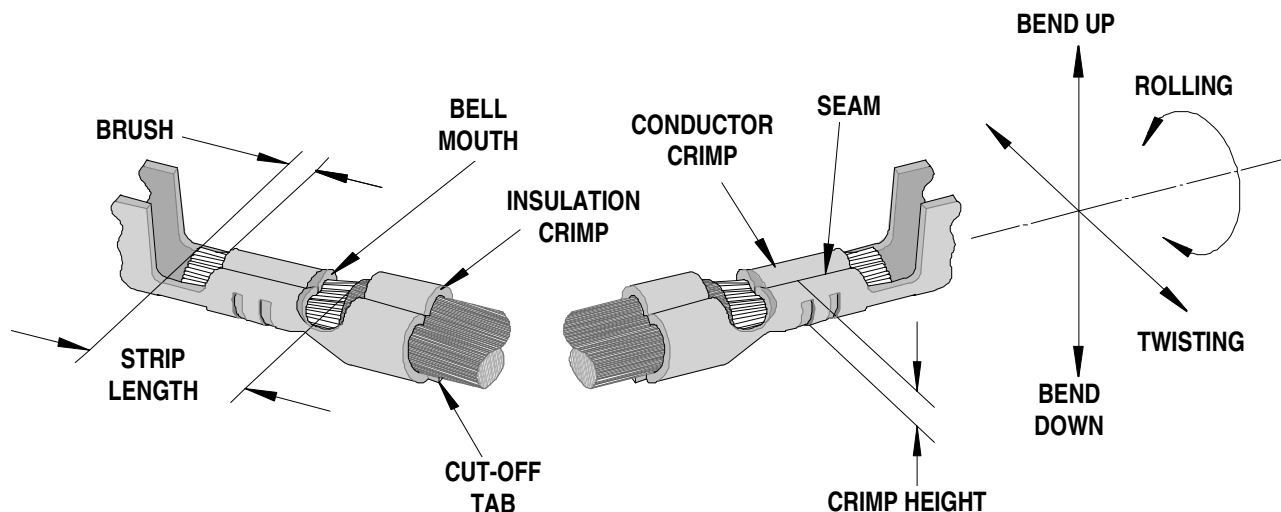
## SCOPE

Products: 2.50mm (.098") Pitch Splash Proof Crimp Terminal, 20-22 AWG.

Terminal Series No.	Terminal Order No.	Wire Size		◆ Insulation Diameter		Strip Length	
		AWG	mm <sup>2</sup>	mm	In.	mm	In.
50038	50038-8000	20-22	0.50-0.35	1.50-1.90	.059-.075	2.00-2.50	.078-.098
50039	50039-8000	20-22	0.50-0.35	1.50-1.90	.059-.075	2.00-2.50	.078-.098

◆ Note:  
Insulation OD: 1.50-1.70mm (.059-.067") will achieve optimum IPC-A620 class 2 insulation crimps.  
Insulation OD: 1.70-1.90mm (.067-.075") will not achieve optimum IPC-A620 class 2 insulation crimps.

## 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.
50038	0.00-0.30	.000-.012	0.30	.012	0.10-0.90	.004-.035
50039	0.00-0.30	.000-.012	0.30	.012	0.10-0.90	.004-.035

Terminal Series No.	Bend up Bend down		Twist	Roll	Punch Width mm (Ref)				Seam
	Degree (Max)				Degree (Max)		Conductor		
	mm	In.	mm	In.	mm	In.	mm	In.	
50038	2	0	3	10	1.40	.055	1.80	.070	Seam shall not be open and no wire allowed out of the crimping area
50039	2	0	3	10	1.40	.055	1.80	.070	

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.
50038	20	0.50	0.96-1.06	.038-.042	53.3	12.0
	22	0.35	0.94-0.99	.037-.039	48.9	11.0
50039	20	0.50	0.96-1.06	.038-.042	53.3	12.0
	22	0.35	0.94-0.99	.037-.039	48.9	11.0

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

The above specifications are guidelines to an optimum crimp.

**PARTS LIST**

<b>T2 Terminator 63910-0100</b>				
<b>Item</b>	<b>Order No</b>	<b>Engineering No.</b>	<b>Description</b>	<b>Quantity</b>
<b>Perishable Tooling</b>				
	63910-0170	63910-0170	Tool Kit (All "Y" Items)	REF
1	63444-1407	63444-1407	Conductor Punch	1 Y
2	63445-1426	63445-1426	Conductor Anvil	1 Y
3	63446-1808	63446-1808	Insulation Punch	1 Y
4	63445-1810	63445-1810	Insulation Anvil	1 Y
5	63443-0002	63443-0002	Cut-Off Plunger	1 Y
6	63443-0012	63443-0012	Front Plunger Retainer	1 Y
<b>Other Components (100150)</b>				
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	11-24-1149	4996-37	Shank	1
11	11-40-4039	8302-5	Front Plunger Striker	1
12	63443-0009	63443-0009	Scrape Chute	1
13	63443-0025	63443-0025	Lower Tooling Key	1
14	63443-0085	63443-0085	Wire Stop L-Bracket	1
15	63443-0090	63443-0090	Wire Stop	1
16	63443-1719	63443-1719	18.90mm Height Spacer	1
17	63443-2213	63443-2213	13.00mm Coarse Spacer	1
18	63443-2302	63443-2302	3.10mm Spacer	1
19	63443-2314	63443-2314	3.70mm Fine Spacer	1
20	63443-6003	63443-6003	Rear Cover	1
21	63443-7001	63443-7001	Terminal Hold Down	1
<b>Frame</b>				
22	63800-8500	63800-8500	T2 Terminator	1
<b>Hardware</b>				
23	N/A	N/A	M3 by 6 Long SHCS	2**
24	N/A	N/A	M3 by 6 Long FHCS	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	#5-40 by 3/8" 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

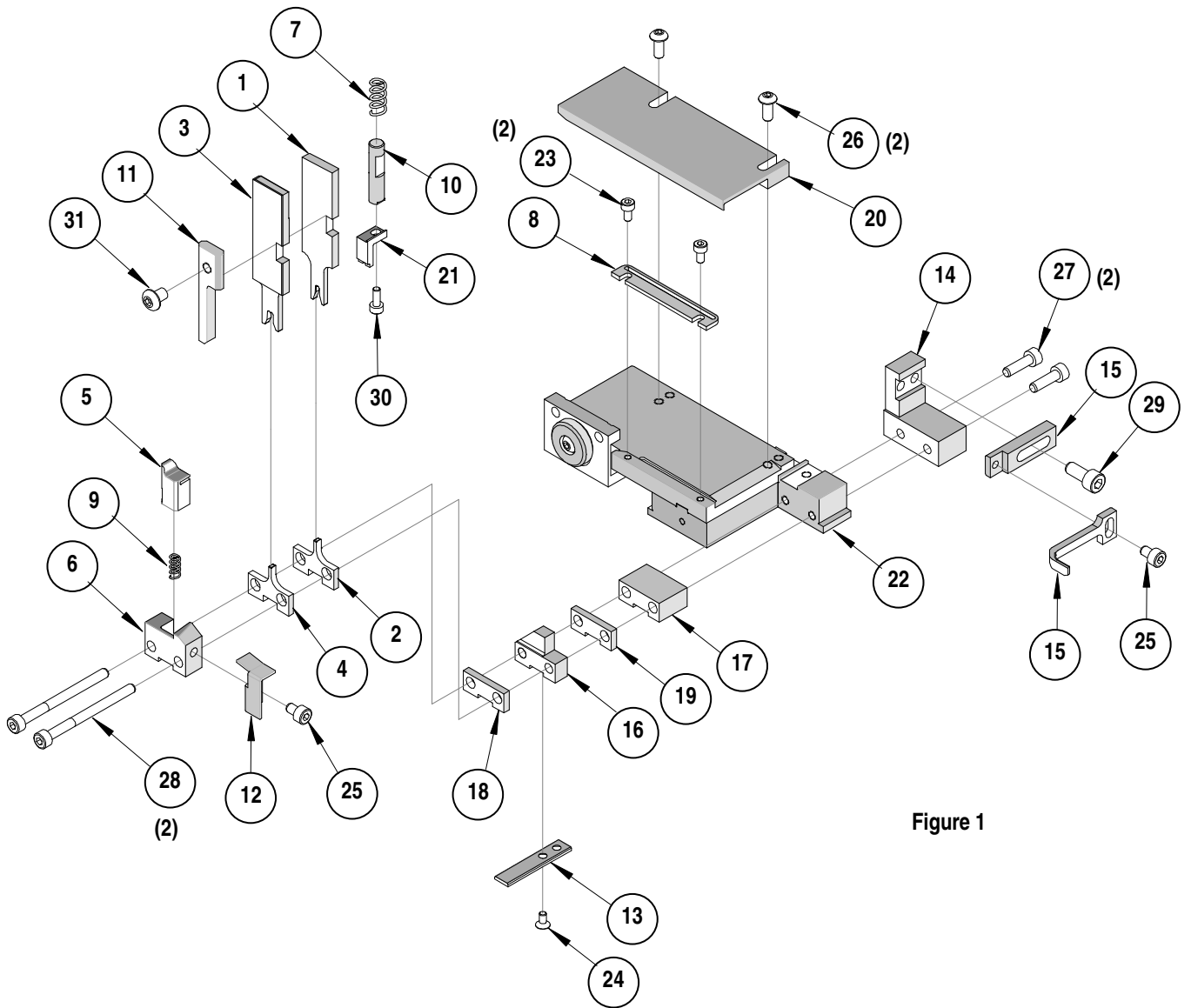


Figure 1

## 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).

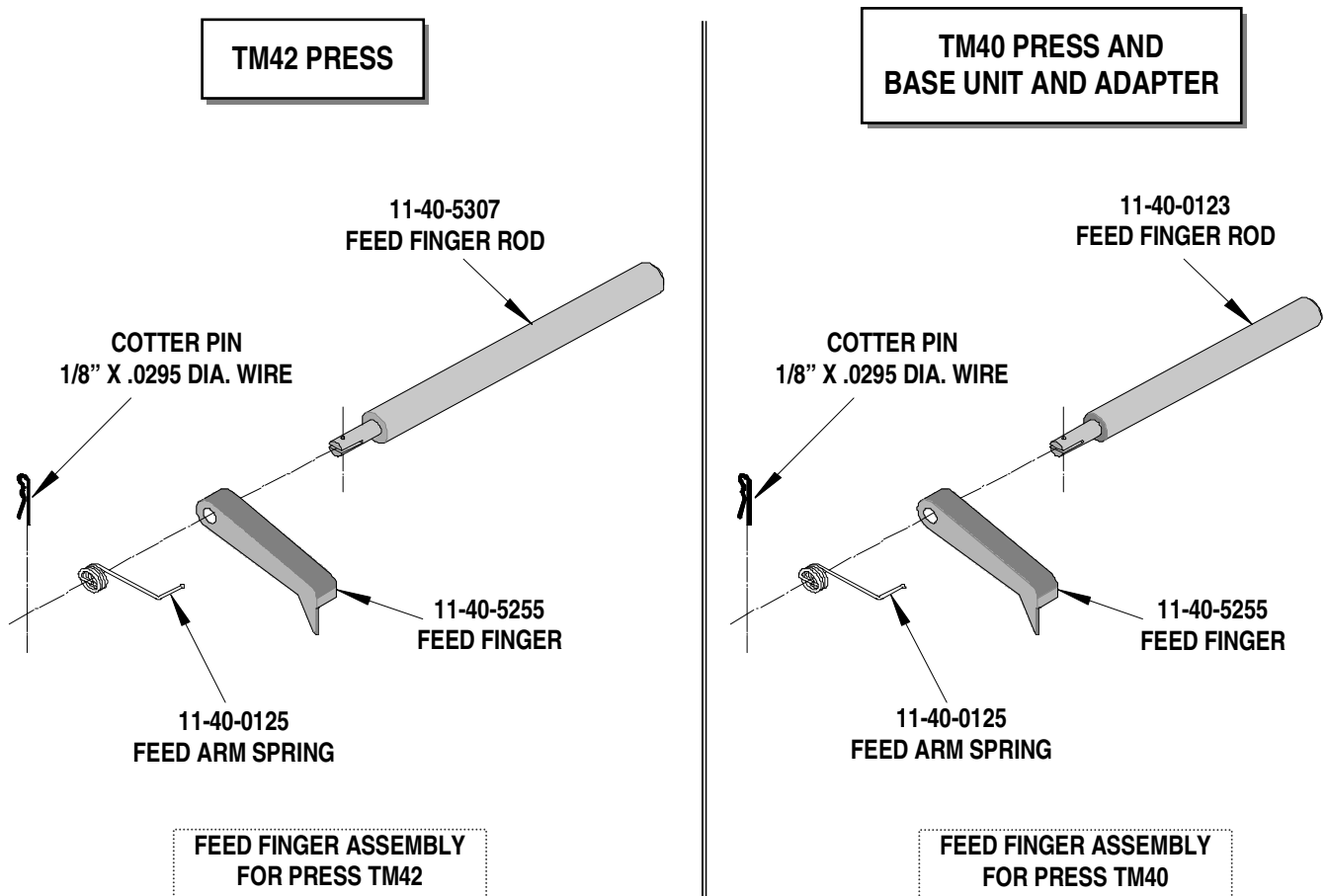


Figure 2

## 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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