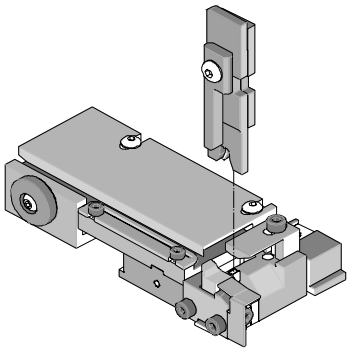
T2 Terminator Tooling Specification Sheet Part No. 63852-2000



FEATURES

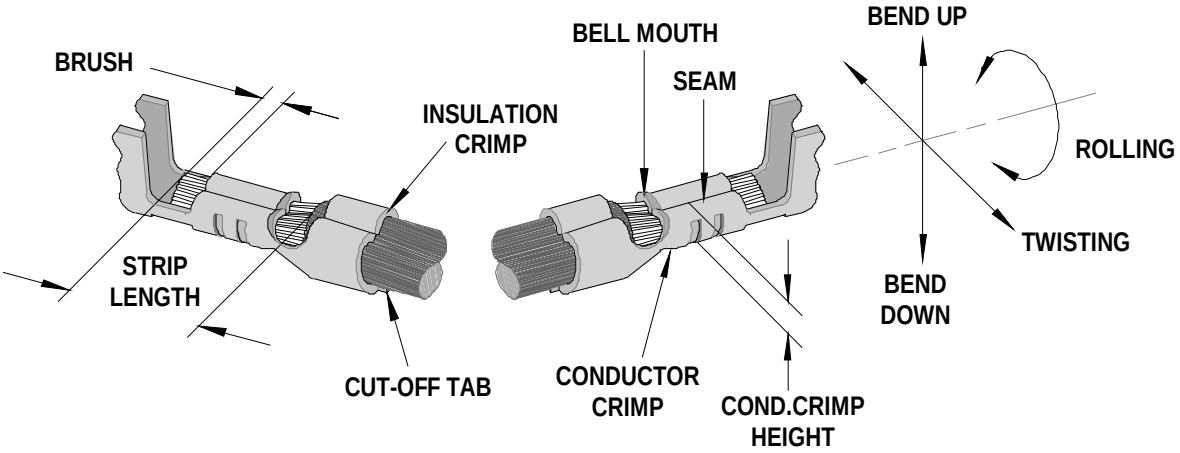
- It is ideally suited for mid-volume bench operations
- This terminator can be installed in the TM42 and the TM40 press or Base Unit adapter for 3BF press
- Quick punch removal with the push of a button for fast and easy tooling change
- Track adjustment capabilities in the T2 Terminators for improved 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: 1.27mm (.050") Pitch Ulti-Mate™ Commercial Micro D, 26-28 AWG

Terminal Series No.	Terminal Order No.		Wire Size		Insulation Diameter		Strip Length	
			AWG	mm²	mm	In.	mm	In.
83000	83000-9502	83000-9503	26	0.14	0.89-1.02	.035-.040	1.30-1.60	.051-.063
	83000-9547	83000-9550						
	83000-9557	83000-9558						
	83000-9559	83000-9561						
	83000-9562							
	83000-9502	83000-9503	28	0.08	0.50-1.00	.020-.039	1.30-1.60	.051-.063
	83000-9547	83000-9550						
	83000-9557	83000-9558						
	83000-9559	83000-9561						
	83000-9562							

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.
83000	0.00-0.10	.000-.004	0.15	.006	0.00-0.45	.000-.018

Terminal Series No.	Bend up	Bend down	Twist	Roll	Punch Width (Ref)				Seam
					Conductor		Insulation		
	Degree		Degree		mm	In.	mm	In.	
83000	3	3	8	10	0.80	.031	0.90	.035	Seam shall not be open and no wire allowed out of the crimping area

The above specifications are guidelines to an optimum crimp.

CONDITIONS

After crimping, the conductor profile should measure the following.

Terminal Order No.	Wire Size		Crimp Height		Pull Force Minimum	
	AWG	mm^2	mm	In.	N	Lb.
83000-9502	28	0.08	0.41-0.46	.016-.018	9.8	2.20
	26	0.14	0.54-0.58	.021-.023	13.4	3.00
83000-9503	28	0.08	0.41-0.46	.016-.018	9.8	2.20
	26	0.14	0.54-0.58	.021-.023	13.4	3.00
83000-9547	28	0.08	0.41-0.46	.016-.018	9.8	2.20
	26	0.14	0.54-0.58	.021-.023	13.4	3.00
83000-9550	28	0.08	0.41-0.46	.016-.018	9.8	2.20
	26	0.14	0.54-0.58	.021-.023	13.4	3.00
83000-9557	28	0.08	0.41-0.46	.016-.018	9.8	2.20
	26	0.14	0.54-0.58	.021-.023	13.4	3.00
83000-9558	28	0.08	0.41-0.46	.016-.018	9.8	2.20
	26	0.14	0.54-0.58	.021-.023	13.4	3.00
83000-9559	28	0.08	0.41-0.46	.016-.018	9.8	2.20
	26	0.14	0.54-0.58	.021-.023	13.4	3.00
83000-9561	28	0.08	0.41-0.46	.016-.018	9.8	2.20
	26	0.14	0.54-0.58	.021-.023	13.4	3.00
83000-9562	28	0.08	0.41-0.46	.016-.018	9.8	2.20
	26	0.14	0.54-0.58	.021-.023	13.4	3.00

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

PARTS LIST

T2 Terminator 63852-2000				
Item	**Order No**	**Engineering No.**	**Description**	**Quantity**
Perishable Tooling				
	63852-2070	63852-2070	Tool Kit (All "Y" Items)	REF
1	63820-7801	63820-7801	Conductor Punch	1 Y
2	63445-0807	63445-0807	Conductor Anvil	1 Y
3	63454-0019	63454-0019	Insulation Punch	1 Y
4	63445-0906	63445-0906	Insulation Anvil	1 Y
5	63443-0003	63443-0003	Cut-Off Plunger Front	1 Y
6	63443-0012	63443-0012	Plunger Retainer Front	1 Y
Other Components (REF 522050)				
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	63443-2423	63443-2423	Anvil Mount	1
13	63443-4025	63443-4025	Wire Stop	1
14	63443-6001	63443-6001	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 Lg 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

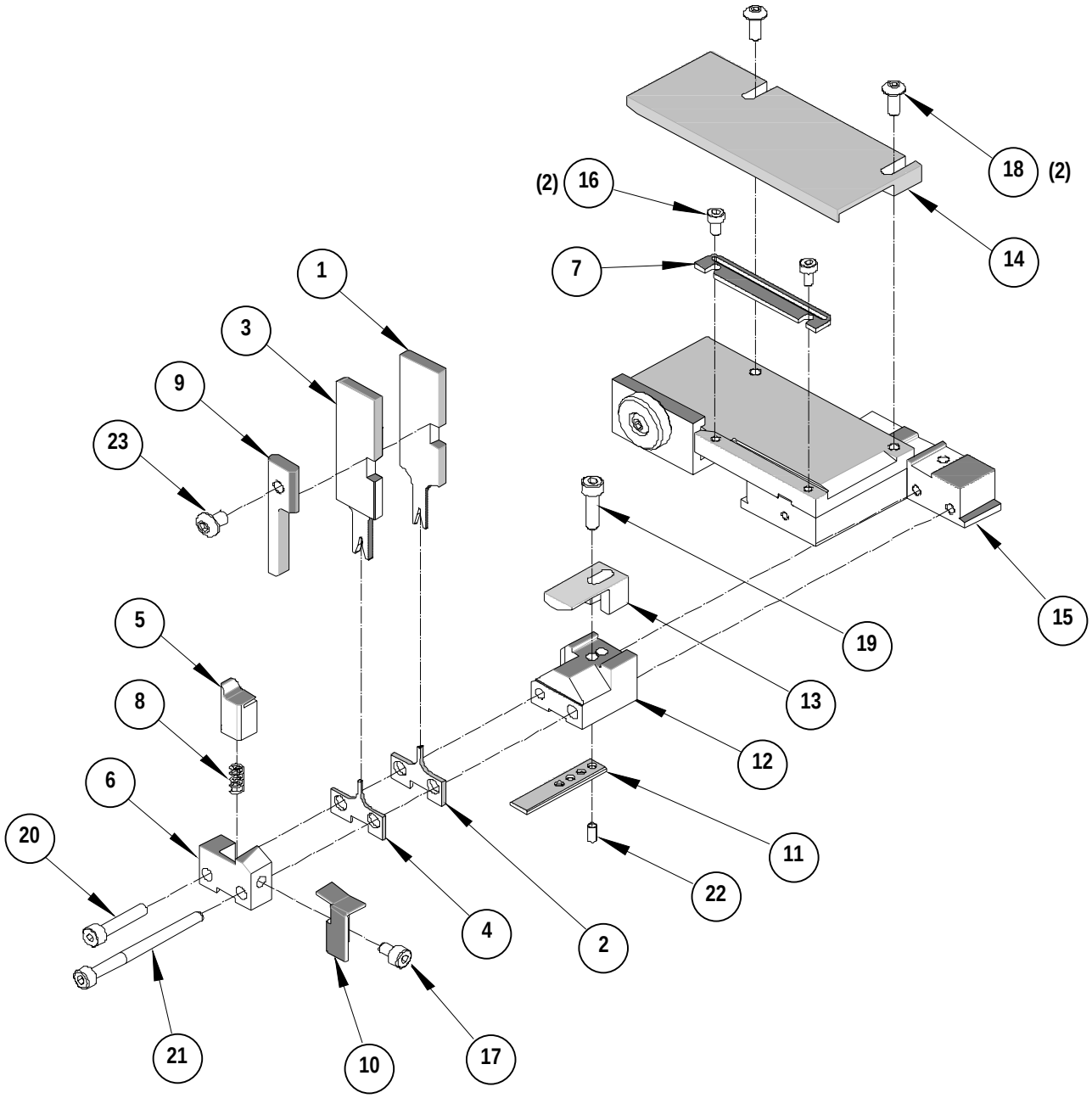


Figure 1

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).

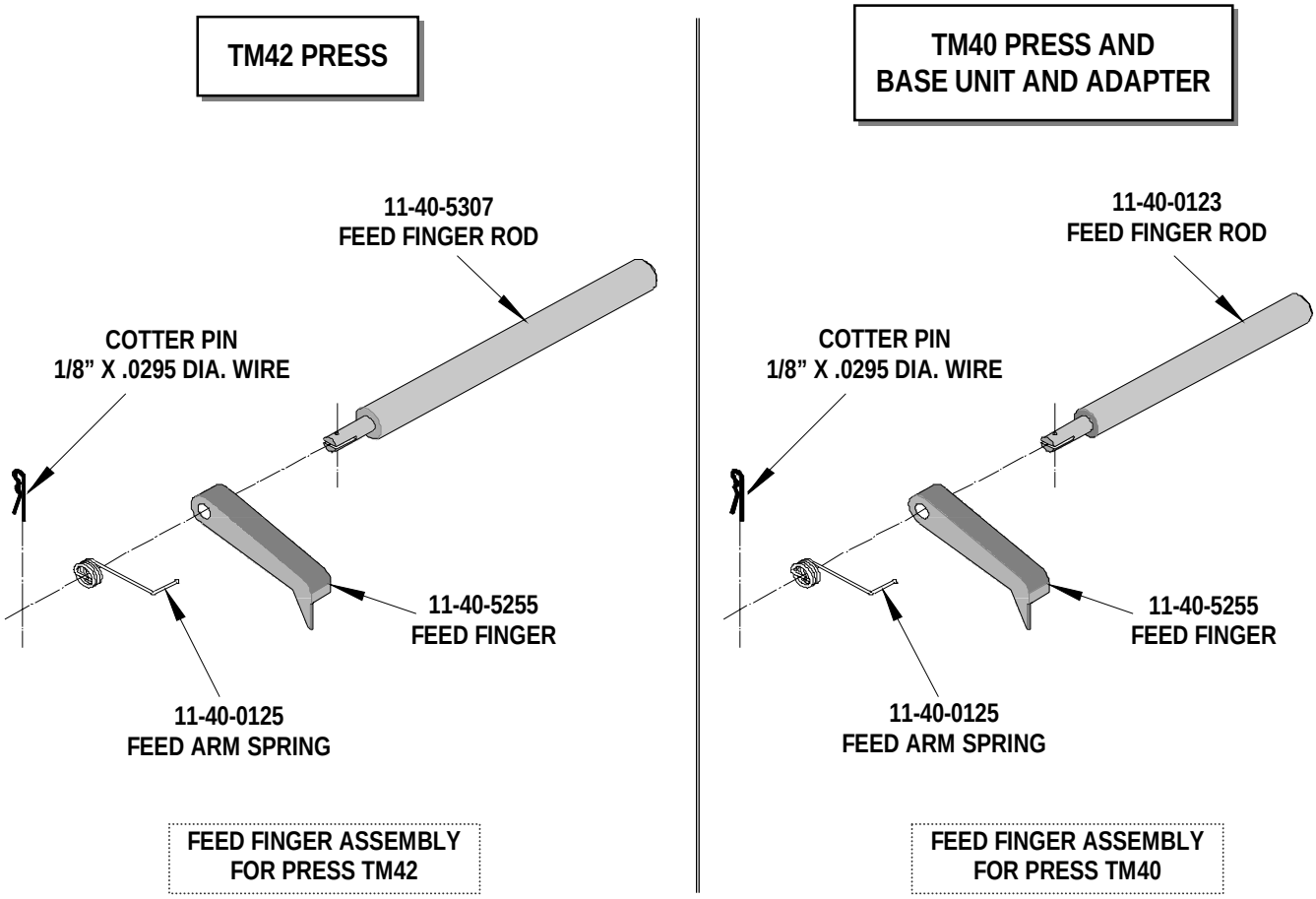


Figure 2

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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