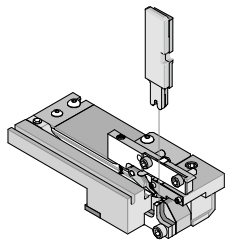
T Style Terminator Tooling

molex

Application Tooling Specification Sheet



Order No. 11-40-2096
Engineering No. T8301AX

FEATURES

- It is ideally suited for mid-volume bench operations
- This terminator can be installed in the TM42, TM40, and Base Unit adapter for 3BF press
- Quick punch removal with the push of a button for fast and easy tooling change
- Flexible and inexpensive

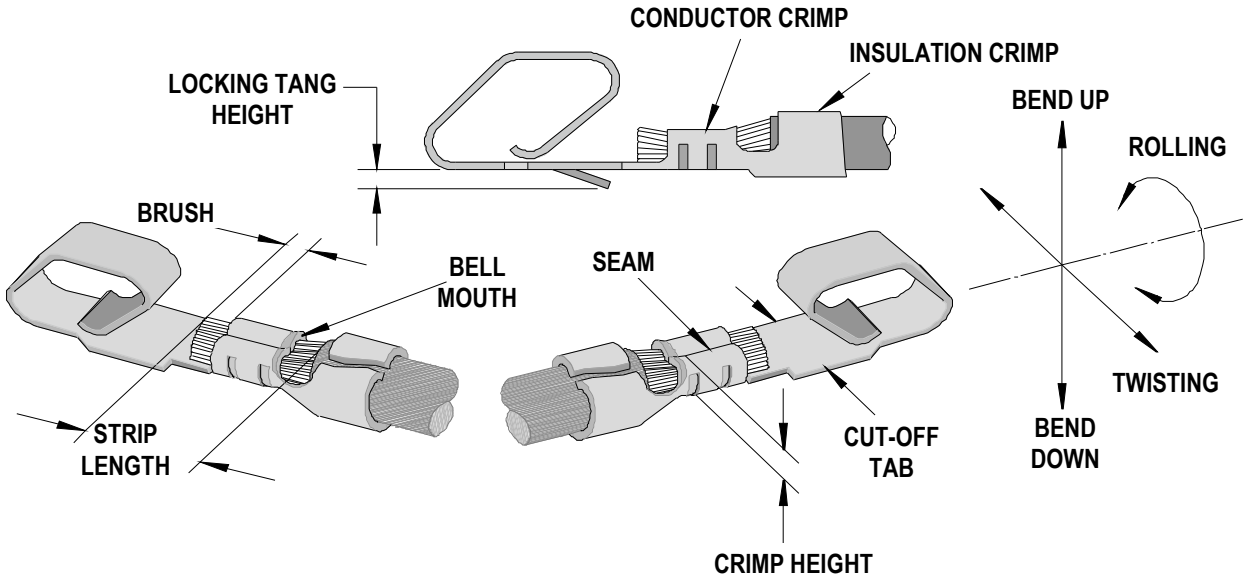
SCOPE

Products: K® Crimp Terminals, Trifurcon™ Crimp Terminals, and Crimp Terminals for Industry Standard Power Supply for 18 to 24 AWG.

Terminal Series No.	Terminal Order No.				Wire Size		Insulation Diameter Maximum		Strip Length	
					AWG	mm²	mm	In.	mm	In.
2477	08-50-0109	08-56-0113	40-01-1179		18-24	0.20-0.80	• 2.79	• .110	2.54-3.18	.100-.125
2478	08-50-0001	08-50-0014	08-50-0015	08-50-0047	18-24	0.20-0.80	• 2.79	• .110	2.54-3.18	.100-.125
	08-50-0063	08-50-0073	08-50-0091	08-50-0105						
	08-50-0119	08-50-0146	08-50-0271	08-50-0281						
	08-51-0001	08-52-0023	08-52-0027	08-52-0044						
	08-52-0046	08-52-0071	08-52-0073	08-52-0114						
	08-52-0811	08-53-0004	08-53-0811	08-55-0103						
	08-55-0133	08-56-0105	08-56-0153	08-58-0103						
	08-58-0114	08-58-0121	08-65-0114	39-00-0103						
	39-00-0133	39-00-0286	39-00-0343	39-00-0345						
	39-00-0347	39-00-0349	40-01-1118	50-29-1689						
2878	08-50-0115	08-51-0109	08-52-0126	08-53-0814	18-20	0.50-0.80	2.79	.110	2.54-3.18	.100-.125
	08-58-0127	08-55-0138	08-65-0118							
4838	08-50-0131	08-55-0125	08-55-0139	08-55-0142	18-22	0.32-0.80	2.41	.095	2.54-3.18	.100-.125
	08-55-0144	08-55-0145	08-55-0147	08-55-0149						
6438	08-50-0164	08-51-0801	08-52-0813	05-53-0813	18-24	0.20-0.80	2.41	.095	2.54-3.18	.100-.125
	08-56-0135	08-56-0137								
6838	08-50-0024	08-50-0026	08-50-0028	08-50-0187	18-20	0.50-0.80	2.79	.110	2.54-3.18	.100-.125
	08-50-0275	08-51-0106	08-52-0112	08-53-1101						
	08-58-0102	08-58-0105	08-58-0108	08-58-0110						
	08-58-0118	08-58-0131	08-58-0187	08-60-0001						
8993	08-50-0011	08-50-0277			18-24	0.20-0.80	2.79	.110	2.54-3.18	.100-.125
172160	172160-1801	172160-1802	172160-1803	172160-1804	18-20	0.50-0.80	2.79	.110	2.54-3.18	.100-.125
	172160-1805	172160-1806								

• 2.54mm (.100 in.) Maximum Insulation Diameter when used with 2139 connectors

CRIMPED TERMINAL



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

CRIMP SPECIFICATIONS

After crimping, the conductor profiles should measure the following (See Figure 1).

Terminal Series No.				Bell mouth		✖Cut-off Tab		Conductor Brush	
				mm	In.	mm	In.	mm	In.
2477	2878	6438	6838	0.20-0.50	.008-.020	2.72±.08	.107±.003	0.13-0.64	.005-.025
2478	4838	8993	172160						

Terminal Series No.			Locking Tang Height		Bend up Bend down		Twist Roll		Punch Width (Ref)				Seam
			mm	In	Degree		Degree		Conductor		Insulation		
									mm	In	mm	In	
2477	2478	2878	0.57±.13	.022±.005	3	3	4	8	1.95	.077	2.46	.097	Seam shall not be open and no wire allowed out of the crimping area
4838	6438	6838											
8993	172160												

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.
2477	18	0.80	1.09-1.14	.043-.045	89.0	20.0
	20	0.50	1.02-1.09	.040-.043	66.7	15.0
	22	0.35	0.96-1.02	.038-.040	44.5	10.0
	24	0.20	0.91-0.96	.036-.038	35.6	8.0
2478	18	0.80	1.09-1.14	.043-.045	89.0	20.0
	20	0.50	1.02-1.09	.040-.043	66.7	15.0
	22	0.35	0.96-1.02	.038-.040	44.5	10.0
	24	0.20	0.91-0.96	.036-.038	35.6	8.0
2878	18	0.80	1.09-1.14	.043-.045	89.0	20.0
	20	0.50	1.02-1.09	.040-.043	66.7	15.0
4838	18	0.80	1.09-1.14	.043-.045	89.0	20.0
	20	0.50	1.02-1.09	.040-.043	66.7	15.0
	22	0.35	0.96-1.02	.038-.040	44.5	10.0
6438	18	0.80	1.09-1.14	.043-.045	89.0	20.0
	20	0.50	1.02-1.09	.040-.043	66.7	15.0
	22	0.35	0.96-1.02	.038-.040	44.5	10.0
	24	0.20	0.91-0.96	.036-.038	35.6	8.0
6838	18	0.80	1.09-1.14	.043-.045	89.0	20.0
	20	0.50	1.02-1.09	.040-.043	66.7	15.0
8993	18	0.80	1.09-1.14	.043-.045	89.0	20.0
	20	0.50	1.02-1.09	.040-.043	66.7	15.0
	22	0.35	0.96-1.02	.038-.040	44.5	10.0
	24	0.20	0.91-0.96	.036-.038	35.6	8.0
172160	18	0.80	1.09-1.14	.043-.045	89.0	20.0
	20	0.50	1.02-1.09	.040-.043	66.7	15.0

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

T2 Terminator 11-40-2096 (T8301AX)				
Item	**Order No**	**Engineering No.**	**Description**	**Quantity**
Perishable Tooling				
	11-40-3096	K8301AX	Tool Kit (All “Y” Items)	REF
1	11-40-4008	8301-2	Conductor Punch	1 Y
2	11-24-1008	4995-12	Conductor Anvil	1 Y
3	11-40-4007	8301-1	Insulation Punch	1 Y
4	11-24-1009	4995-13	Insulation Anvil	1 Y
5	11-40-4420	8301-22	Cut-Off Punch	1 Y
6	11-24-1007	4995-10	Cut-off Insert	1 Y
Other Components				
7	11-17-0109	1837-9	Terminal Drag Spring	1
8	11-40-4069	8302-103	Pivot Pin	1
9	11-40-4085	8301-10	Terminal Stop and Scrap Shield	1
10	11-40-4086	8301-11	Cover Plate	1
11	11-40-4087	8301-12	Terminal Drag Spring	1
12	11-40-4346	8301-8A	Terminal Locating Pin	1
13	11-40-4405	8301-21	Wire Stop Block	1
14	11-40-4406	8301-21A	Wire Stop Blade	1
15	11-40-4419	8301-6A	Cut-Off Punch and Guide Pin Block	1
16	11-40-4421	8571	Cut Off Punch Retainer Plate	1
17	11-40-4458	8301-23	Stop Finger	1
18	11-40-4459	8301-24	Stop Finger Block	1
19	11-40-5142	8394-27	Cover Plate Extension	1
Frame				
20	11-40-4084	8301-9	Terminal Base and Track	1
Hardware				
21	N/A	N/A	#2-56 by 1/4 Long SSS	1**
22	N/A	N/A	#2-56 by 1/4 Long SHCS	2**
23	N/A	N/A	#5-40 by 3/16 Long BHCS	1**
24	N/A	N/A	#6-32 by 1/4 Long BHCS	1**
25	N/A	N/A	#8-32 by 3/8 Long BHCS	1**
26	N/A	N/A	#8-32 by 5/8 Long BHCS	1**
27	N/A	N/A	#8-32 by 1/2 Long SHCS	3**
28	N/A	N/A	#10-32 by 1.0 Long SHCS	1**
29	N/A	N/A	1/8 Diameter by 1/8 Long Tubular Rivet	1**
** Available from an industrial supply company such as MSC (1-800-645-7270).				

Assembly Drawing

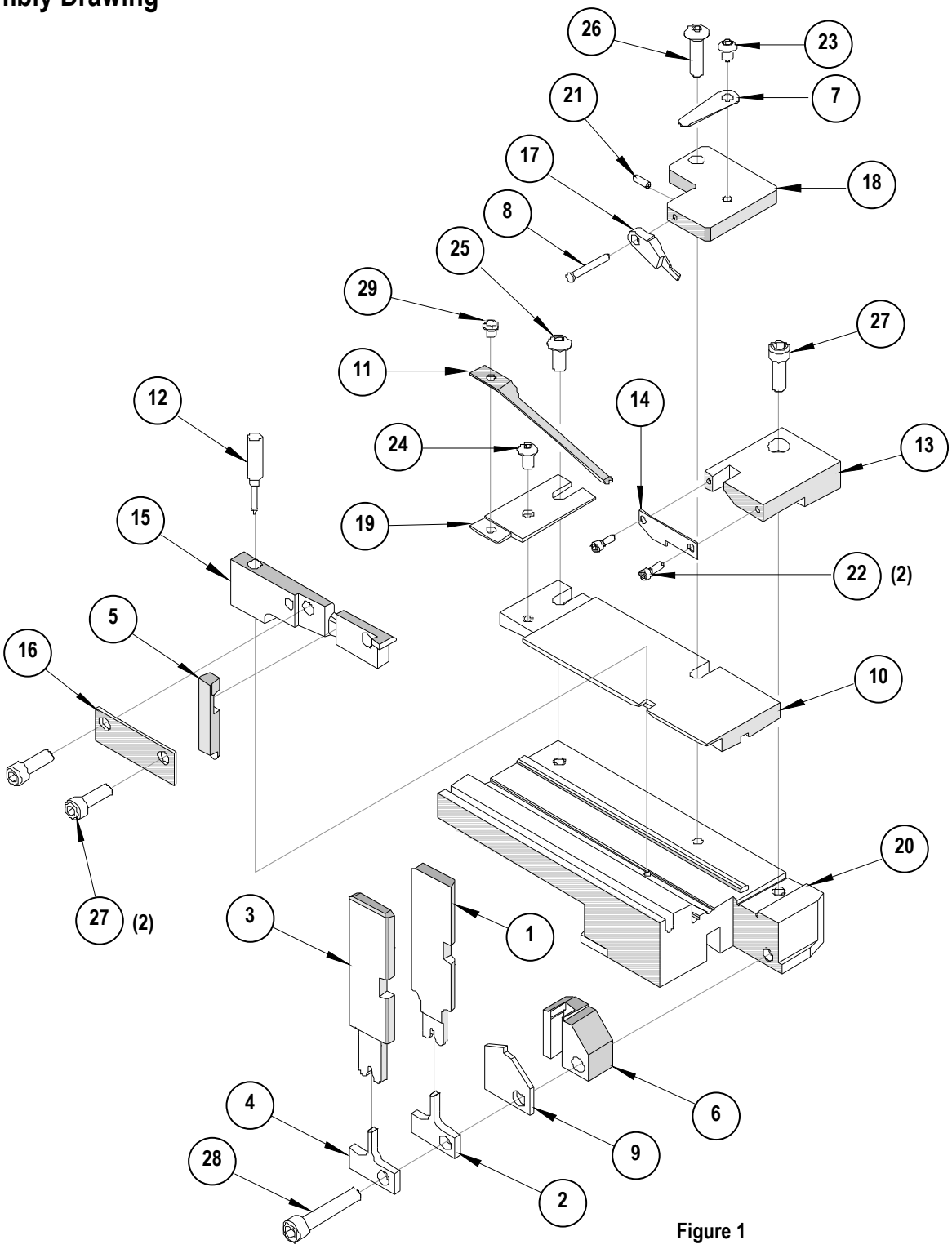


Figure 1

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 only be 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 instruction manual.

CAUTION: Molex crimp specifications are valid only when used with Molex terminals, applicators and tooling.

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