

## T Style Terminator Tooling Specification Sheet Part No. 63840-4200

### **FEATURES**

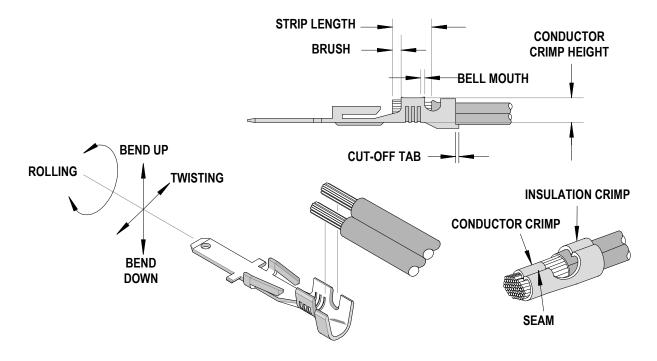
- It is ideally suited for mid-volume bench operations
- This terminator can be installed in the TM42 and Base Unit adapter for 3BF press
- Quick punch removal with the push of a button for fast and easy tooling change
- Flexible and inexpensive

### **SCOPE**

<u>Products:</u> Sabre™ Crimp Terminal 14-18 AWG and Double 18 AWG wires placed vertically-<u>Full Radius Insulation</u> <u>Crimp</u>.

Terminal Series No.	Terminal Order No.		Wire Siz	Insulation	Diameter	Strip Length		
			AWG	mm²	mm	ln.	mm	ln.
	43178-2001	43178-6001	14-18	2.00-0.80	3.03-4.57	.119180	3.96-5.54	.156218
43178	43178-2002	43178-6002	14-10					
	43178-2001	43178-6001	*18 (2) Vertical	0.80 (2)	3.03-4.57	.119180	3.96-5.54	.156218
	43178-2002	43178-6002	* 10 (2) Vertical					
* See Wire Orientation on next page.								

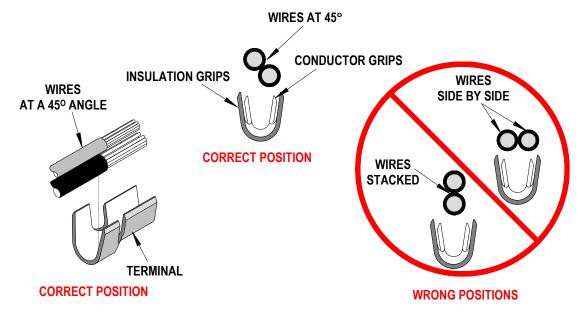
### **DEFINITION OF TERMS**



Doc No: ATS-638404200 Release Date: 02-19-99 Revision: B Revision Date: 10-27-06

# **Wire Feeding Orientation**

This Terminator and crimp was developed for (2) 18 AWG wires placed at a 45° angle orientation from one another. Wires must be positioned as shown, to capture all wire strands in crimp. See the following illustrations below.



### **CRIMP SPECIFICATIONS**

	Terminal Series No.	Bell n	nouth	Cut-off Tak	Maximum	<b>Conductor Brush</b>	
Terminal Series No.		mm	ln.	mm	ln.	mm	ln.
	43178	0.25-1.00	.010039	0.50	.019	1.50	.059

	Bend up Bend down		Twist	Roll	Punch Width (Ref)			lef)	Seam	
Terminal Series No.	Della up	Della dowli	i wist	Koli	Cond	uctor	Insul	ation	Seam shall not be open	
	Degree		Degree		mm	ln	mm	ln	and no wire allowed out	
43178	3	3	4	8	3.40	.133	4.80	.189	of the crimping area	

After crimping, the conductor profile should measure the following.

Terminal Series No.	Wire Size		Crimp	Height	Pull Force Minimum		
Terminal Series No.	AWG	mm²	mm	ln.	N	Lb.	
	14	0.80	1.80-1.90	.071075	222.4	50.00	
43178	16	1.30	1.70-1.80	.067071	133.5	30.00	
43170	18	0.80	1.65-1.75	.065069	88.9	20.00	
	18 DBL	0.80 (2)	1.75-1.85	.069073	88.9	20.00	

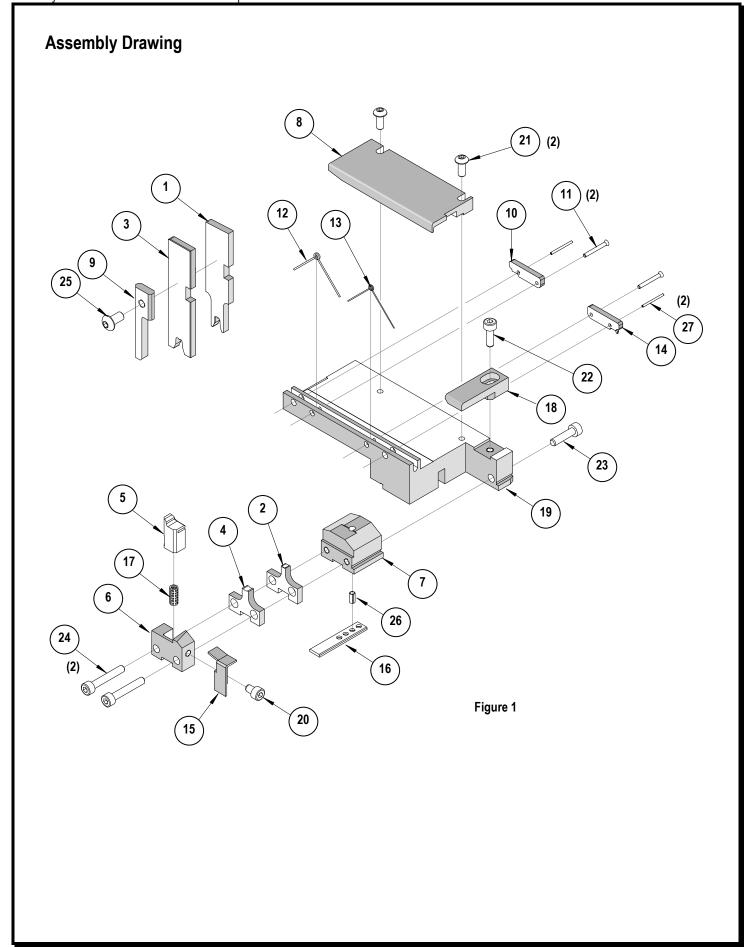
Pull Force should be measured with no influence from the insulation crimp. The above specifications are guidelines to an optimum crimp.

Doc No: ATS-638404200 Release Date: 02-19-99 **UNCONTROLLED COPY** Page 2 of 5 Revision: B Revision Date: 10-27-06

## **PARTS LIST**

T-Style Terminator 63840-4200									
Item	Order No	Engineering No.	Description	Quantity					
Perishable Tooling									
	63840-4270	63840-4270	Tool Kit (All "Y" Items)	REF					
1	63444-3409	63444-3409	Conductor Punch	1 Y					
2	63445-3443	63445-3443	Conductor Anvil	1 Y					
3	63446-4865	63446-4865	Insulation Punch (Non-Tip)	1 Y					
4	63445-4817	63445-4817	Insulation Anvil	1 Y					
5	63443-0002	63443-0002	Cut-Off Plunger	1 Y					
6	63443-0012	63443-0012	Front Plunger Retainer	1 Y					
			Components						
7	11-18-5415	60842A111	Anvil Mount	1					
8	11-18-5440	60842A117	Rear Cover	1					
9	11-40-4039	8302-5	Front Plunger Striker	1					
10	11-40-4068	8302-102	Drag Finger						
11	11-40-4069	8302-103							
12	11-40-4144	8302-110	Torsion Spring	1					
13	11-40-4145	8302-111	Torsion Spring (Stop Finger)	1					
14	11-40-4231	8329-10	Stop Finger	1					
15	63443-0009	63443-0009	Scrap Chute	1					
16	63443-0021	63443-0021	Mounting Key	1					
17	63700-0539	63700-0539	Heavy Duty Cut-Off Plunger Spring	1					
18	63840-6011	63840-6011	Wire Stop	1					
19	63840-6020	63840-6020 63840-6020 Terminal Track		1					
			ardware						
20	N/A	N/A	M4 by 6 Long SHCS	1**					
21	N/A	N/A	M4 by 10 Long BHCS	2**					
22	N/A	N/A	M4 by 12 Long SHCS	1**					
23	N/A	N/A	M4 by 16 Long SHCS	1**					
24	N/A	N/A	M4 by 24 Long SHCS	2**					
25	N/A	N/A	#10-32 by 3/8" Long BHCS	1**					
26	N/A	N/A	3mm by 6 Long Roll Pin	1**					
27									
	** Available from an industrial supply company such as MSC (1-800-645-7270).								

Doc No: ATS-638404200 Release Date: 02-19-99 Revision: B Revision Date: 10-27-06



Doc No: ATS-638404200 Release Date: 02-19-99 Revision: B Revision Date: 10-27-06

#### **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
- 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.

Americas Headquarters Lisle, Illinois 60532 U.S.A. 1-800-78MOLEX amerinfo@molex.com

Far East North Headquarters Yamato, Kanagawa, Japan 81-462-65-2324 feninfo@molex.com

Far East South Headquarters Jurong, Singapore 65-6-268-6868 fesinfo@molex.com

**European Headquarters** Munich, Germany 49-89-413092-0 eurinfo@molex.com

**Corporate Headquarters** 2222 Wellington Ct. Lisle, IL 60532 U.S.A. 630-969-4550 Fax: 630-969-1352

Visit our Web site at http://www.molex.com

**UNCONTROLLED COPY** Doc No: ATS-638404200 Release Date: 02-19-99 Page 5 of 5 Revision Date: 10-27-06 Revision: B