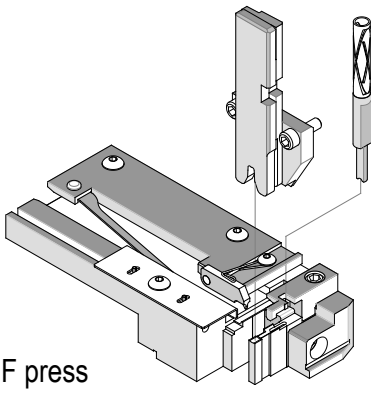
T-Style Terminator Tooling Specification Sheet Part No. 11-40-2002 Engineering No. T8300B



FEATURES

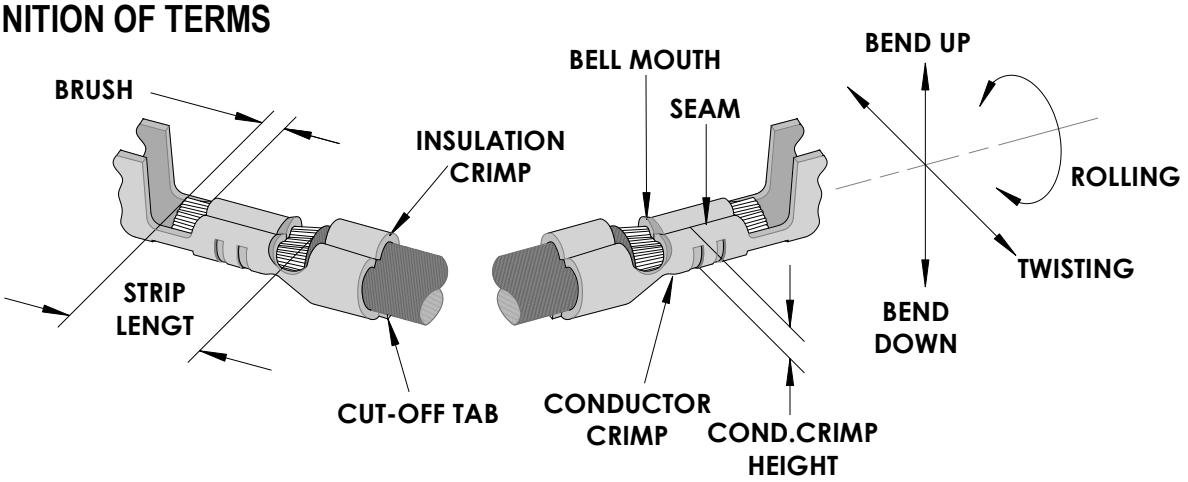
- It is ideally suited for mid-volume bench operations
- This terminator can be installed in the TM40, TM42 and Base Unit adapter for 3BF press
- Quick punch removal with the push of a button for fast and easy tooling change
- Flexible and inexpensive

SCOPE

Products: 2.36mm (.093") Diameter, Standard .093" Pin and Socket Crimp Terminal, 16-24 AWG

Terminal Series No.	Terminal Order No.			Wire Size	Insulation Diameter		Strip Length	
				AWG	mm	In.	mm	In.
1380	02-09-2116	02-09-6122	39-00-0303	16-24 and 22(2)	3.05 max.	.120 max.	3.96-5.54	.156-.218
	02-09-2117	02-09-6125	39-00-0305					
	02-09-2127	39-00-0283	40-01-1139					
1381	02-09-1115	02-09-5130	39-00-0309	16-24 and 22(2)	3.05 max.	.120 max.	3.96-5.54	.156-.218
	02-09-1116	02-09-5143	39-00-0311					
	02-09-1117	39-00-0284	39-00-0312					
	02-09-1129	39-00-0285	40-01-1192					
2151	02-09-1201	02-09-1203	02-09-5203	16-24 and 22(2)	3.05 max.	.120 max.	3.96-5.54	.156-.218
2152	02-09-2201	02-09-3202	02-09-6203	16-24 and 22(2)	3.05 max.	.120 max.	3.96-5.54	.156-.218
2273	02-09-1122	02-09-1135		16-24 and 22(2)	3.05 max.	.120 max.	3.96-5.54	.156-.218
4272	02-09-1151			16-24 and 22(2)	3.05 max.	.120 max.	3.96-5.54	.156-.218
6271	02-09-1208			16-24 and 22(2)	3.05 max.	.120 max.	3.96-5.54	.156-.218

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 SPECIFICATIONS

Terminal Series No.	Punch Width (Ref)				Seam
	Conductor		Insulation		
	mm	In.	mm	In.	
1380	1.91	.075	3.12	.123	Seam shall not be open and no wire allowed out of the crimping area
1381	1.91	.075	3.12	.123	
2151	1.91	.075	3.12	.123	
2152	1.91	.075	3.12	.123	
2273	1.91	.075	3.12	.123	
4272	1.91	.075	3.12	.123	
6271	1.91	.075	3.12	.123	

After crimping, the conductor profile should measure the following

Terminal Series No.	Wire Size	Crimp Height		Pull Force Min.	
	AWG	mm	In.	N	Lb.
1380	16	1.42-1.47	.056-.058	133.4	30.0
	18	1.37-1.42	.054-.056	111.2	25.0
	20	1.32-1.37	.052-.054	66.7	15.0
	22	1.29-1.35	.051-.053	44.5	10.0
	24	1.24-1.29	.049-.051	35.6	8.0
	22(2)	1.39-1.44	.055-.057	44.5	10.0
1381	16	1.42-1.47	.056-.058	133.4	30.0
	18	1.37-1.42	.054-.056	111.2	25.0
	20	1.32-1.37	.052-.054	66.7	15.0
	22	1.29-1.35	.051-.053	44.5	10.0
	24	1.24-1.29	.049-.051	35.6	8.0
	22(2)	1.39-1.44	.055-.057	44.5	10.0
2151	18	1.37-1.42	.054-.056	107.9	24.3
	20	1.32-1.37	.052-.054	58.9	13.2
	22	1.29-1.35	.051-.053	39.2	8.8
	24	1.24-1.29	.049-.051	29.4	6.6
	22(2)	1.39-1.44	.055-.057	39.2	8.8
2152	18	1.37-1.42	.054-.056	107.9	24.3
	20	1.32-1.37	.052-.054	58.9	13.2
	22	1.29-1.35	.051-.053	39.2	8.8
	24	1.24-1.29	.049-.051	29.4	6.6
	22(2)	1.39-1.44	.055-.057	39.2	8.8
2273	16	1.42-1.47	.056-.058	133.4	30.0

Terminal Series No.	Wire Size	Crimp Height		Pull Force Min.	
	AWG	mm	In.	N	Lb.
2273	18	1.37-1.42	.054-.056	111.2	25.0
	20	1.32-1.37	.052-.054	66.7	15.0
	22	1.29-1.35	.051-.053	44.5	10.0
	24	1.24-1.29	.049-.051	35.6	8.0
	22(2)	1.39-1.44	.055-.057	44.5	10.0
4272	16	1.42-1.47	.056-.058	133.4	30.0
	18	1.37-1.42	.054-.056	111.2	25.0
	20	1.32-1.37	.052-.054	66.7	15.0
	22	1.29-1.35	.051-.053	44.5	10.0
	24	1.24-1.29	.049-.051	35.6	8.0
	22(2)	1.39-1.44	.055-.057	44.5	10.0
6271	16	1.42-1.47	.056-.058	133.4	30.0
	18	1.37-1.42	.054-.056	111.2	25.0
	20	1.32-1.37	.052-.054	66.7	15.0
	22	1.29-1.35	.051-.053	44.5	10.0
	24	1.24-1.29	.049-.051	35.6	8.0
	22(2)	1.39-1.44	.055-.057	44.5	10.0

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 11-40-2002 (T8300B)				
Item	**Order No**	**Engineering No.**	**Description**	**Quantity**
Perishable Tooling				
	11-40-3002	K8300B	Tool Kit (All “Y” Items)	REF
1	11-40-4004	8300-4	Conductor Punch	1 Y
2	11-24-1087	4994-25	Combination Anvil	1 Y
3	11-40-4003	8300-3	Insulation Punch	1 Y
4	11-24-1021	4994-3	Cut-off Die Blade	1 Y
5	11-24-1017	4994-15	Cut-Off Punch	1 Y
Other Components				
6	11-17-0022	1739-21	Terminal Hold Down Spring	1
7	11-24-1016	4994-16	Pressure Pad (Terminal Hold Down Pin)	1
8	11-24-1035	4994-20	Die Blade and Anvil Spacer	1
9	11-40-4069	8302-103	Pivot Pin	1
10	11-40-4077	8300-11	Rear Cover	1
11	11-40-4078	8300-12	Stop Finger	1
12	11-40-4079	8300-13	Terminal Guide Rail	1
13	11-40-4081	8300-14	Terminator Base and Track	1
14	11-40-4082	8300-15	Wire Stop and Stripper	1
15	11-40-4087	8301-12	Terminal Drag Spring	1
16	11-40-4687	8300-32	Stop Finger Spring	1
Hardware				
17	N/A	N/A	#6-32 by 1/4”Long BHCS	1**
18	N/A	N/A	#8-32 by 1/4”Long BHCS	1**
19	N/A	N/A	#8-32 by 3/8”Long BHCS	2**
20	N/A	N/A	#8-32 by 3/8”Long SHCS	1**
21	N/A	N/A	#8-32 by 1/2”Long SHCS	2**
22	N/A	N/A	#10-32 by 1.0”Long SHCS	1**
23	N/A	N/A	1/16 Diameter by 1/4”Long Roll Pin	2**
24	N/A	N/A	1/8 Dia. by 1/8” Long Tubular Rivet	1**
** Available from an industrial supply company such as MSC (1-800-645-7270).				

Assembly Drawing

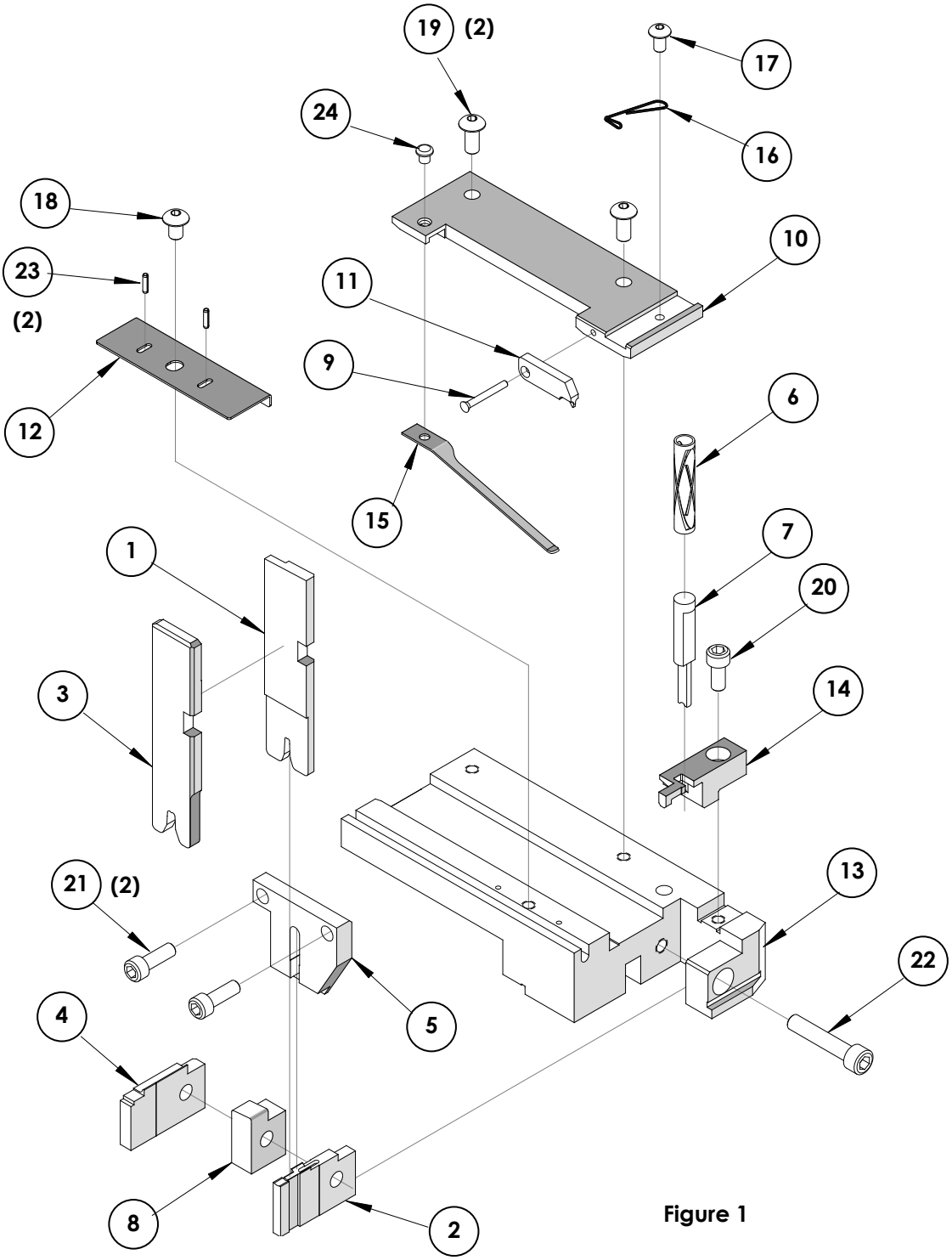


Figure 1

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 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.

Application Tooling Support

Phone: (402) 458-TOOL (8665)
E-Mail: applicationtooling@molex.com
Website: www.molex.com/applicationtooling