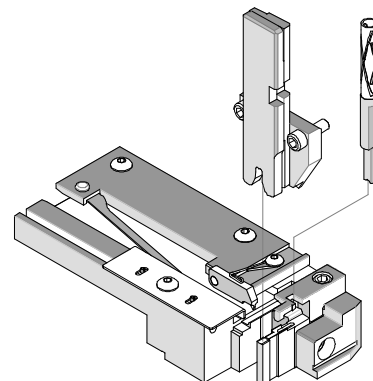




T-Style Terminator Tooling Specification Sheet

Order No. 11-40-2020
Engineering No. T8300E



FEATURES

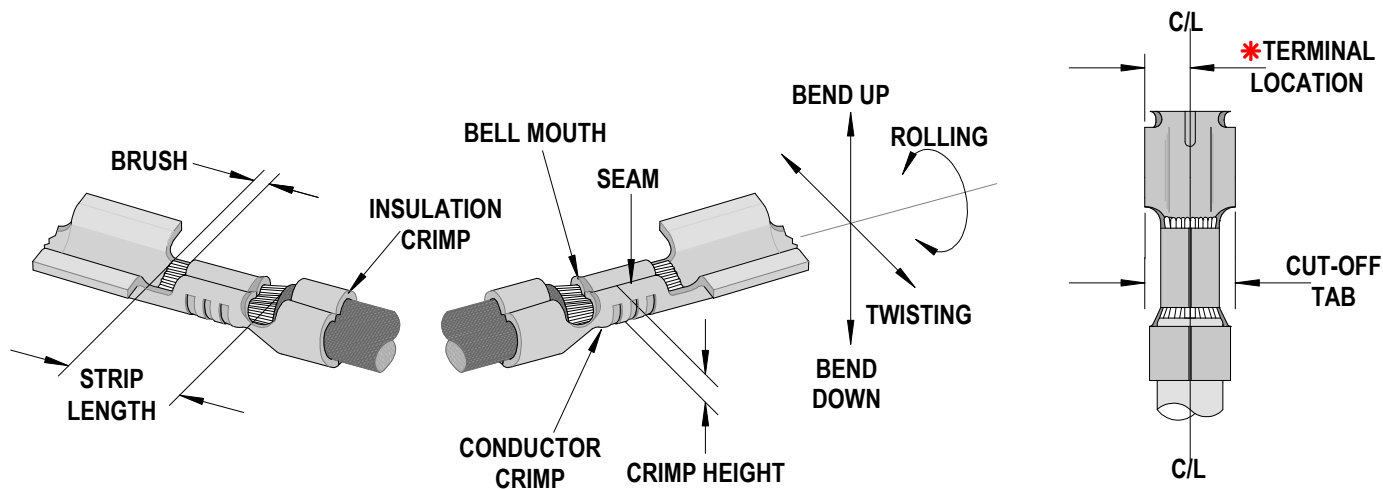
- It is ideally suited for mid-volume bench operations
- This terminator can be installed in the TM40, TM42 and Base Unit adapter for 3BF press
- Quick punch removal with the push of a button for fast and easy tooling change
- Flexible and inexpensive

SCOPE

Products: 2.36mm (.093") Diameter, Standard .093" Pin and Socket Crimp Terminal, 22-24 AWG.

Terminal Series No.	Terminal Series No.		Wire Size		Insulation Diameter Maximum		Strip Length	
			AWG	mm ²	mm	In.	mm	In.
2870	02-09-2136	02-09-2138	22-24	0.20-0.35	1.78	.070	3.96-5.54	.156-.218
2871	02-09-1136	02-09-1138	22-24	0.20-0.35	1.78	.070	3.96-5.54	.156-.218

DEFINITION OF TERMS



* Terminal is to be centrally located between the two (2) cut-off tab edges by one half of the total cut-off tab tolerance.

This illustration is a generic terminal representation and not an exact image of any terminal listed in the scope.

CRIMP SPECIFICATIONS

Terminal Series No.	Bell mouth		*Cut-off Tab		Conductor Brush	
	mm	In.	mm	In.	mm	In.
2870			3.53-3.69	.139-.145		
2871			3.53-3.69	.139-.145		

Terminal Series No.	Bend up	Bend down	Twist	Roll	Punch Width (Ref)				Seam Seam shall not be open and no wire allowed out of the crimping area
					Conductor		Insulation		
	Degree		Degree		mm	In.	mm	In.	
2870					1.42	.056	2.31	.091	
2871					1.42	.056	2.31	.091	

NOTE: Some of the specifications in these charts above are intentionally left blank due to the fact that the information does not currently exist.

After crimping, the conductor profile should measure the following.

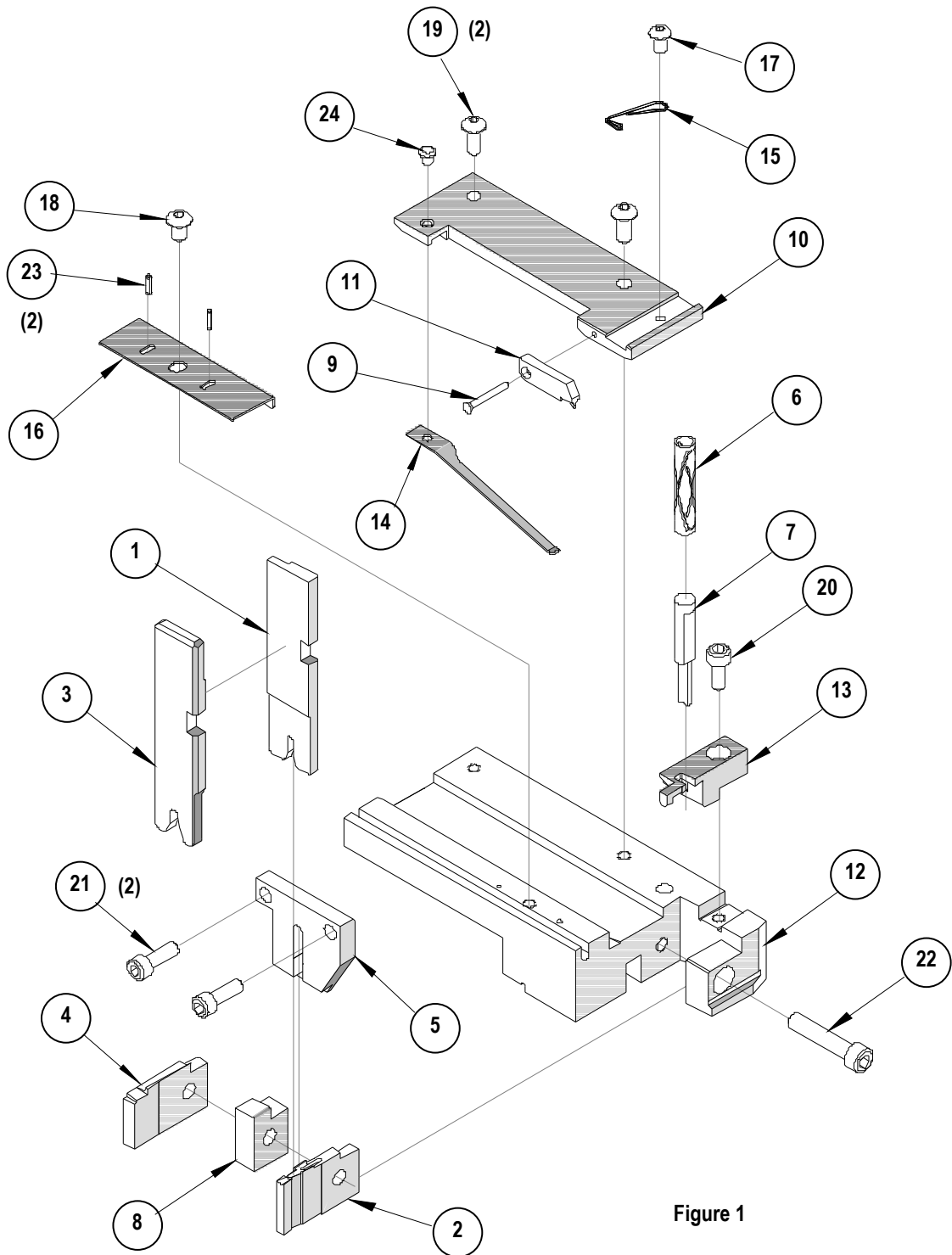
Terminal Series No.	Wire Size		Conductor		Pull Force Minimum	
			Crimp Height			
	AWG	mm ²	mm	In.	N	Lb.
2870	22	0.35	1.06-1.11	.042-.044	62.3	14.00
	24	0.20	1.01-1.06	.040-.042	35.6	8.00
2871	22	0.35	1.06-1.11	.042-.044	62.3	14.00
	24	0.20	1.01-1.06	.040-.042	35.6	8.00

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 11-40-2020 (T8300E)				
Item	Order No	Engineering No.	Description	Quantity
Perishable Tooling				
	11-40-3020	K8300E	Tool Kit (All "Y" Items)	REF
1	11-40-4049	8300-9	Conductor Punch	1 Y
2	11-24-1364	4994-34	Combination Anvil	1 Y
3	11-40-4050	8300-10	Insulation Punch	1 Y
4	11-24-1017	4994-15	Cut-Off Punch	1 Y
5	11-24-1021	4994-3	Cut-off Die Blade	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	11-40-4081	8300-14	Terminator Base and Track	1
13	11-40-4082	8300-15	Wire Stop and Stripper	1
14	11-40-4087	8301-12	Terminal Drag Spring	1
15	11-40-4687	8300-32	Stop Finger Spring	1
16	11-40-4891	8300-36	Terminal Guide Rail	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



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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