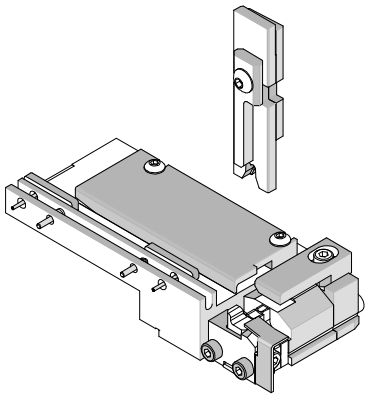
# T Style Terminator Tooling Specification Sheet Part No. 63840-4200



## FEATURES

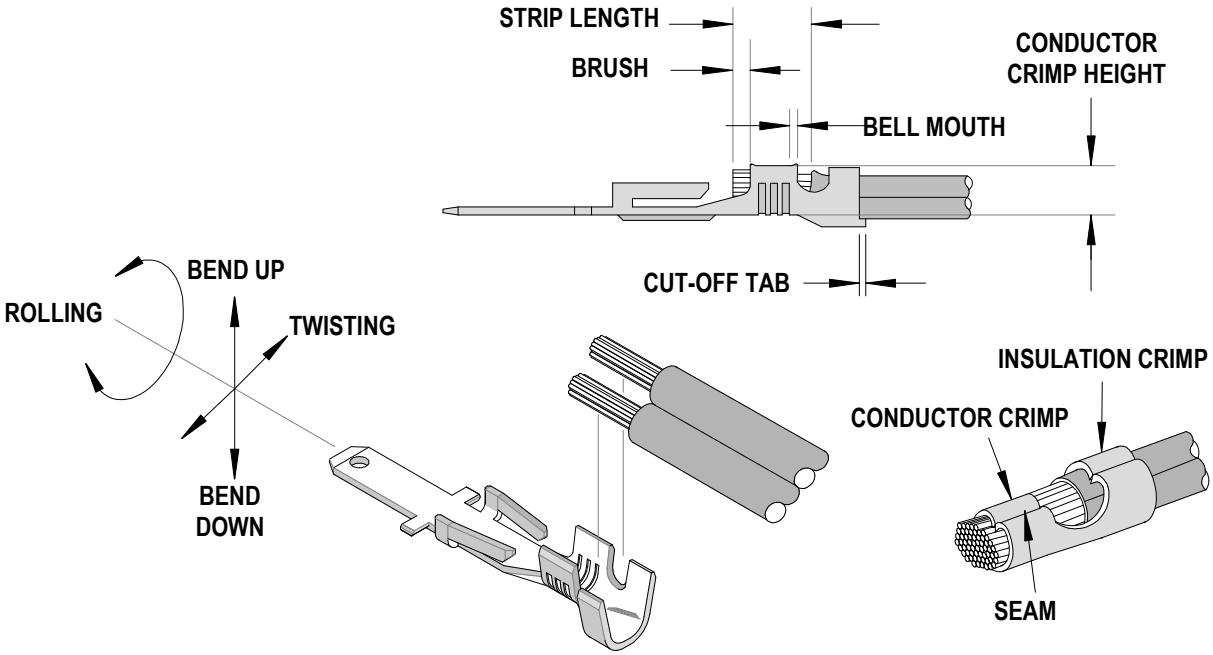
- It is ideally suited for mid-volume bench operations
- This terminator can be installed in the TM42 and Base Unit adapter for 3BF press
- Quick punch removal with the push of a button for fast and easy tooling change
- Flexible and inexpensive

## SCOPE

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

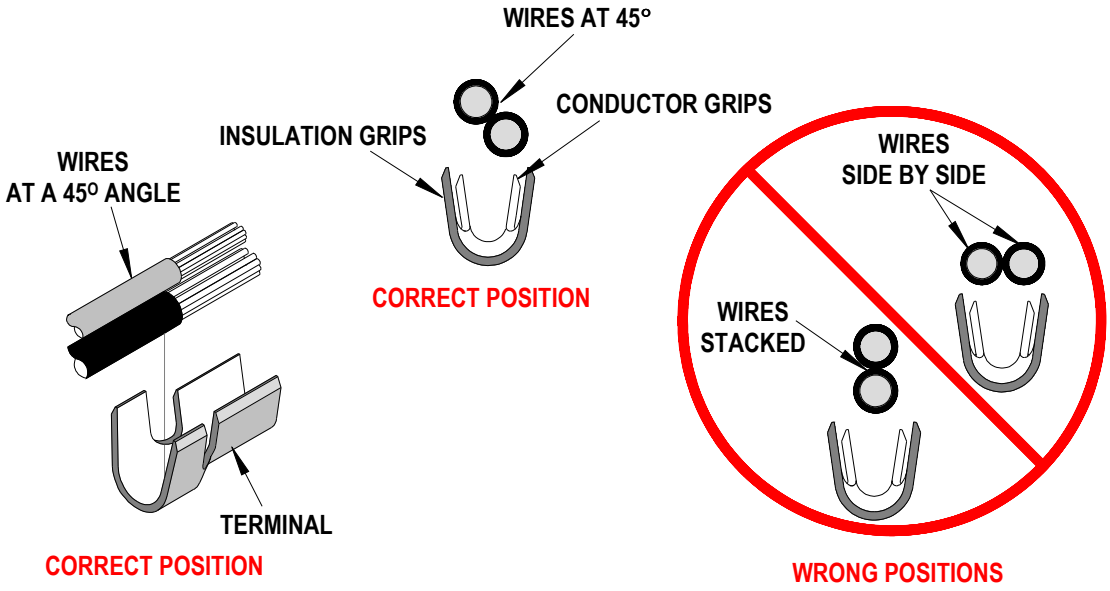
| Terminal Series No. | Terminal Order No. | | Wire Size | | Insulation Diameter | | Strip Length | |
|---|---|---|---|---|---|---|---|---|
| | | | AWG | mm² | mm | In. | mm | In. |
| 43178 | 43178-2001 | 43178-6001 | 14-18 | 2.00-0.80 | 3.03-4.57 | .119-.180 | 3.96-5.54 | .156-.218 |
| | 43178-2002 | 43178-6002 | | | | | | |
| | 43178-2001 | 43178-6001 | ✳18 (2) Vertical | 0.80 (2) | 3.03-4.57 | .119-.180 | 3.96-5.54 | .156-.218 |
| | 43178-2002 | 43178-6002 | | | | | | |
| ✳ See Wire Orientation on next page. | | | | | | | | |

## DEFINITION OF TERMS



## Wire Feeding Orientation

This Terminator and crimp was developed for (2) 18 AWG wires placed at a 45º 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 mouth | | Cut-off Tab Maximum | | Conductor Brush | |
|---|---|---|---|---|---|---|
| | mm | In. | mm | In. | mm | In. |
| 43178 | 0.25-1.00 | .010-.039 | 0.50 | .019 | 1.50 | .059 |

| Terminal Series No. | Bend up | Bend down | Twist | Roll | Punch Width (Ref) | | | | Seam |
|---|---|---|---|---|---|---|---|---|---|
| | | | | | Conductor | | Insulation | | |
| | Degree | | Degree | | mm | In | mm | In | |
| 43178 | 3 | 3 | 4 | 8 | 3.40 | .133 | 4.80 | .189 | Seam shall not be open and no wire allowed out of the crimping area |

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. |
| 43178 | 14 | 0.80 | 1.80-1.90 | .071-.075 | 222.4 | 50.00 |
| | 16 | 1.30 | 1.70-1.80 | .067-.071 | 133.5 | 30.00 |
| | 18 | 0.80 | 1.65-1.75 | .065-.069 | 88.9 | 20.00 |
| | 18 DBL | 0.80 (2) | 1.75-1.85 | .069-.073 | 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.

## 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 |
| **Other 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 | 1 |
| 11 | 11-40-4069 | 8302-103 | Pivot Pin | 2 |
| 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 | Terminal Track | 1 |
| **Hardware** | | | | |
| 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 | N/A | N/A | 3/64" Diameter Spirol Pin | 2** |
| ** Available from an industrial supply company such as MSC (1-800-645-7270). | | | | |

## Assembly Drawing

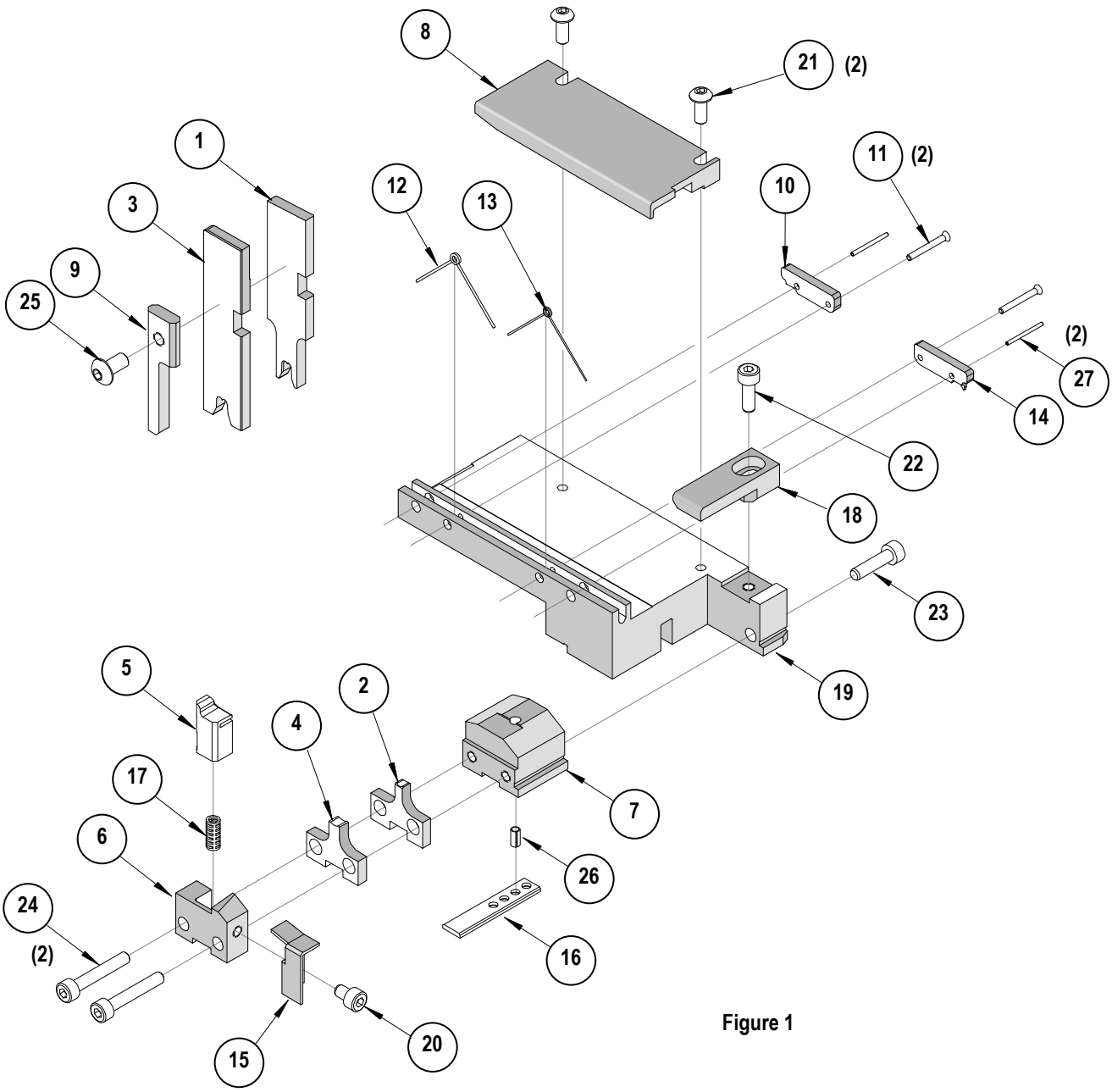



Figure 1

## 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 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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