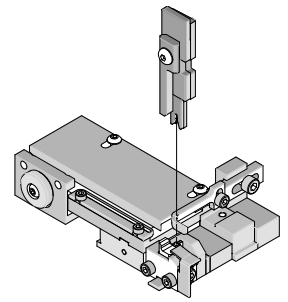


Order Number
63914-8000



Application Tooling Specification



FEATURES

- Ideally suited for mid-volume bench operations
- This terminator can be installed in the TM42 and TM40 presses or Base Unit adapter for the 3BF press
- Quick punch removal with the push of a button for fast and easy tooling change
- Track adjustment capabilities in the T2 terminators for improved control of the bell mouth size and cut-off tab length
- T2 terminator has standardized tooling with the Molex FineAdjust applicator, which will reduce your inventory requirements

SCOPE

Products: Mini-Fit Jr., Mini-Fit HCS, and Mini-Fit Plus HCS Crimp Terminal, 18-24 AWG with smaller insulation ODs.

Terminal Series No.	Terminal Order No.		Wire Size		Insulation Diameter				Strip Length	
					IPC/WHMA-A-620 (1)		Terminal (2)			
			AWG	mm ²	mm	In.	mm	In.	mm	In.
5556	39-00-0038	39-00-0055	18-24	0.80-0.20	1.65-2.05	.065-.085	1.30-3.10	.051-.122	3.00-3.50	.118-.138
	39-00-0059	39-00-0073								
	39-00-0108	39-00-0114								
	39-00-0153	39-00-0163								
	39-00-0169	39-00-0175								
	39-00-0181	39-00-0194								
	39-00-0200	39-00-0207								
	39-00-0213	39-00-0405								
	39-00-0407	39-00-0410								
	39-00-0419	39-00-0425								
	39-00-0428	39-00-0436								
	39-00-0440	40-13-0851								
5558	39-00-0040	39-00-0053	18-24	0.80-0.20	1.65-2.05	.065-.085	1.30-3.10	.051-.122	3.00-3.50	.118-.138
	39-00-0061	39-00-0075								
	39-00-0120	39-00-0121								
	39-00-0126	39-00-0219								
	39-00-0411	39-00-0420								
	39-00-0426	39-00-0427								
	39-00-0430	39-00-0437								
	40-01-0853	40-13-0853								
30490	30490-0002	30490-1002	18-24	0.80-0.20	1.65-2.05	.065-.085	1.30-3.10	.051-.122	3.00-3.50	.118-.138
	30490-2002									
44476	44476-1111	44476-1211	18-20	0.80-0.50	1.65-2.05	.065-.085	1.30-3.10	.051-.122	3.00-3.50	.118-.138
44478	44478-1111	44478-1211	18-20	0.80-0.50	1.65-2.05	.065-.085	1.30-3.10	.051-.122	3.00-3.50	.118-.138
44485	44485-1211	44485-1311	18-24	0.80-0.20	1.65-2.05	.065-.085	1.30-3.10	.051-.122	3.00-3.50	.118-.138
	44485-1411									
45750	45750-1111	45750-1211	18-20	0.80-0.50	1.65-2.05	.065-.085	1.65-2.95	.065-.116	3.00-3.50	.118-.138
46012	46012-1111	46012-1141	18-20	0.80-0.50	1.65-2.05	.065-.085	1.65-2.95	.065-.116	3.00-3.50	.118-.138
	46012-1211	46012-1241								
46018	46018-1541		18-20	0.80-0.50	1.65-2.05	.065-.085	1.65-2.95	.065-.116	3.00-3.50	.118-.138

Terminal Series No.	Terminal Order No.		Wire Size		Insulation Diameter				Strip Length	
					IPC/WHMA-A-620 (1)		Terminal (2)			
	AWG	mm ²	mm	In.	mm	In.	mm	In.		
46083	46083-1111	46083-1121	18-20	0.80-0.50	1.65-2.05	.065-.085	1.65-2.95	.065-.116	3.00-3.50	.118-.138
	46083-1211	46083-1221								
46098	46098-1541		18-20	0.80-0.50	1.65-2.05	.065-.085	1.65-2.95	.065-.116	3.00-3.50	.118-.138
46134	46134-1111	46134-1121	18-20	0.80-0.50	1.65-2.05	.065-.085	1.65-2.95	.065-.116	3.00-3.50	.118-.138
	46134-1211	46134-1221								

(1) To achieve optimum IPC-A620 insulation crimps, use this insulation OD range.

(2) Overall insulation OD specification for terminal.

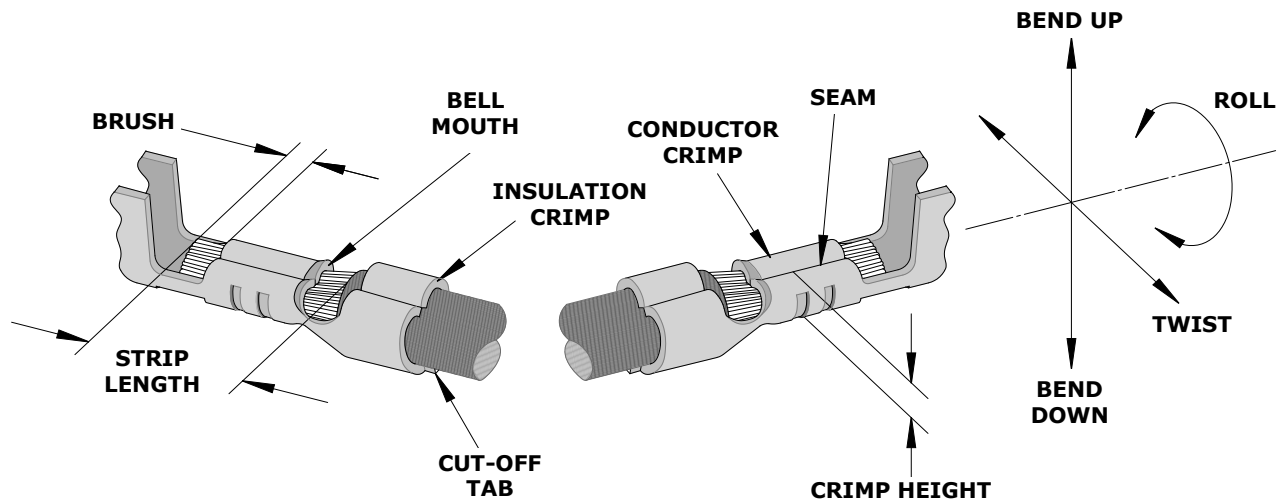
Terminator 63914-7800 should be used for insulation OD 2.50-2.95mm (example UL1015).

Terminator 63911-5600 should be used for insulation OD 1.90-2.30mm (example UL1007).

Terminator 63912-3900 should be used for insulation OD 1.40-1.70mm.

Terminator 63912-4900 should be used for insulation OD 2.30-2.60mm.

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 SPECIFICATION

Terminal Series No.	Bell Mouth		Cut-Off Tab Maximum		Conductor Brush	
	mm	In.	mm	In.	mm	In.
5556 and 5558	0.20-0.50	.008-.020	0.30	.012	0.00-1.00	.000-.039
30490	0.20-0.50	.008-.020	0.30	.012	0.00-1.00	.000-.039
44476, 44478 and 44485	0.20-0.50	.008-.020	0.30	.012	0.00-1.00	.000-.039
45750	0.20-0.50	.008-.020	0.30	.012	0.00-1.00	.000-.039
46012 and 46018	0.20-0.50	.008-.020	0.30	.012	0.00-1.00	.000-.039
46083	0.20-0.50	.008-.020	0.30	.012	0.00-1.00	.000-.039
46098	0.20-0.50	.008-.020	0.30	.012	0.00-1.00	.000-.039
46134	0.20-0.50	.008-.020	0.30	.012	0.00-1.00	.000-.039

T2 Terminator for Mini-Fit Crimp Terminals

Terminal Series No.	Bend Up	Bend Down	Twist	Roll	Punch Width (Ref)				Seam
					Conductor		Insulation		
	Degree	Degree	mm	In.	mm	In.			
5556 and 5558	5	2	5	15	1.60	.063	2.00	.079	Seam shall not be open and no wire allowed out of the crimping area
30490	5	2	5	15	1.60	.063	2.00	.079	
44476, 44478 and 44485	5	2	5	15	1.60	.063	2.00	.079	
45750	5	2	5	15	1.60	.063	2.00	.079	
46012 and 46018	5	2	5	15	1.60	.063	2.00	.079	
46083	5	2	5	15	1.60	.063	2.00	.079	
46098	5	2	5	15	1.60	.063	2.00	.079	
46134	5	2	5	15	1.60	.063	2.00	.079	

After crimping, the crimp profiles should measure the following:

Terminal Series No.	Wire Size		Conductor				Pull Force Minimum	
	AWG	mm ²	Crimp Height		Crimp Width (Ref)		N	Lb.
			mm	In.	mm	In.		
5556	18	0.80	0.97-1.07	.038-.042	1.68	.066	88.0	19.8
	20	0.50	0.95-1.04	.037-.041	1.66	.065	58.7	13.2
	22	0.35	0.85-0.94	.033-.037	1.65	.065	39.1	8.8
	24	0.20	0.79-0.87	.031-.034	1.63	.064	29.3	6.6
5558	18	0.80	0.97-1.07	.038-.042	1.68	.066	88.0	19.8
	20	0.50	0.95-1.04	.037-.041	1.66	.065	58.7	13.2
	22	0.35	0.85-0.94	.033-.037	1.65	.065	39.1	8.8
	24	0.20	0.79-0.87	.031-.034	1.63	.064	29.3	6.6
30490	18	0.80	0.97-1.07	.038-.042	1.68	.066	88.0	19.8
	20	0.50	0.95-1.04	.037-.041	1.66	.065	58.7	13.2
	22	0.35	0.85-0.94	.033-.037	1.65	.065	39.1	8.8
	24	0.20	0.79-0.87	.031-.034	1.63	.064	29.3	6.6
44476	18	0.80	0.97-1.07	.038-.042	1.68	.066	68.4	15.4
	20	0.50	0.95-1.04	.037-.041	1.66	.065	58.7	13.2
44478	18	0.80	0.97-1.07	.038-.042	1.68	.066	68.4	15.4
	20	0.50	0.95-1.04	.037-.041	1.66	.065	58.7	13.2
44485	18	0.80	0.97-1.07	.038-.042	1.68	.066	88.0	19.8
	20	0.50	0.95-1.04	.037-.041	1.66	.065	58.7	13.2
	22	0.35	0.85-0.94	.033-.037	1.65	.065	39.1	8.8
	24	0.20	0.79-0.87	.031-.034	1.63	.064	29.3	6.6
45750	18	0.80	0.97-1.07	.038-.042	1.68	.066	68.4	15.4
	20	0.50	0.84-0.94	.033-.037	1.66	.065	58.7	13.2
46012	18	0.80	0.97-1.07	.038-.042	1.68	.066	68.4	15.4
	20	0.50	0.84-0.94	.033-.037	1.66	.065	58.7	13.2
46018	18	0.80	0.97-1.07	.038-.042	1.68	.066	68.4	15.4
	20	0.50	0.84-0.94	.033-.037	1.66	.065	58.7	13.2
46083	18	0.80	0.97-1.07	.038-.042	1.68	.066	68.4	15.4
	20	0.50	0.84-0.94	.033-.037	1.66	.065	58.7	13.2
46098	18	0.80	0.97-1.07	.038-.042	1.68	.066	68.4	15.4
	20	0.50	0.84-0.94	.033-.037	1.66	.065	58.7	13.2
46134	18	0.80	0.97-1.07	.038-.042	1.68	.066	68.4	15.4
	20	0.50	0.84-0.94	.033-.037	1.66	.065	58.7	13.2

Tool Qualification Notes

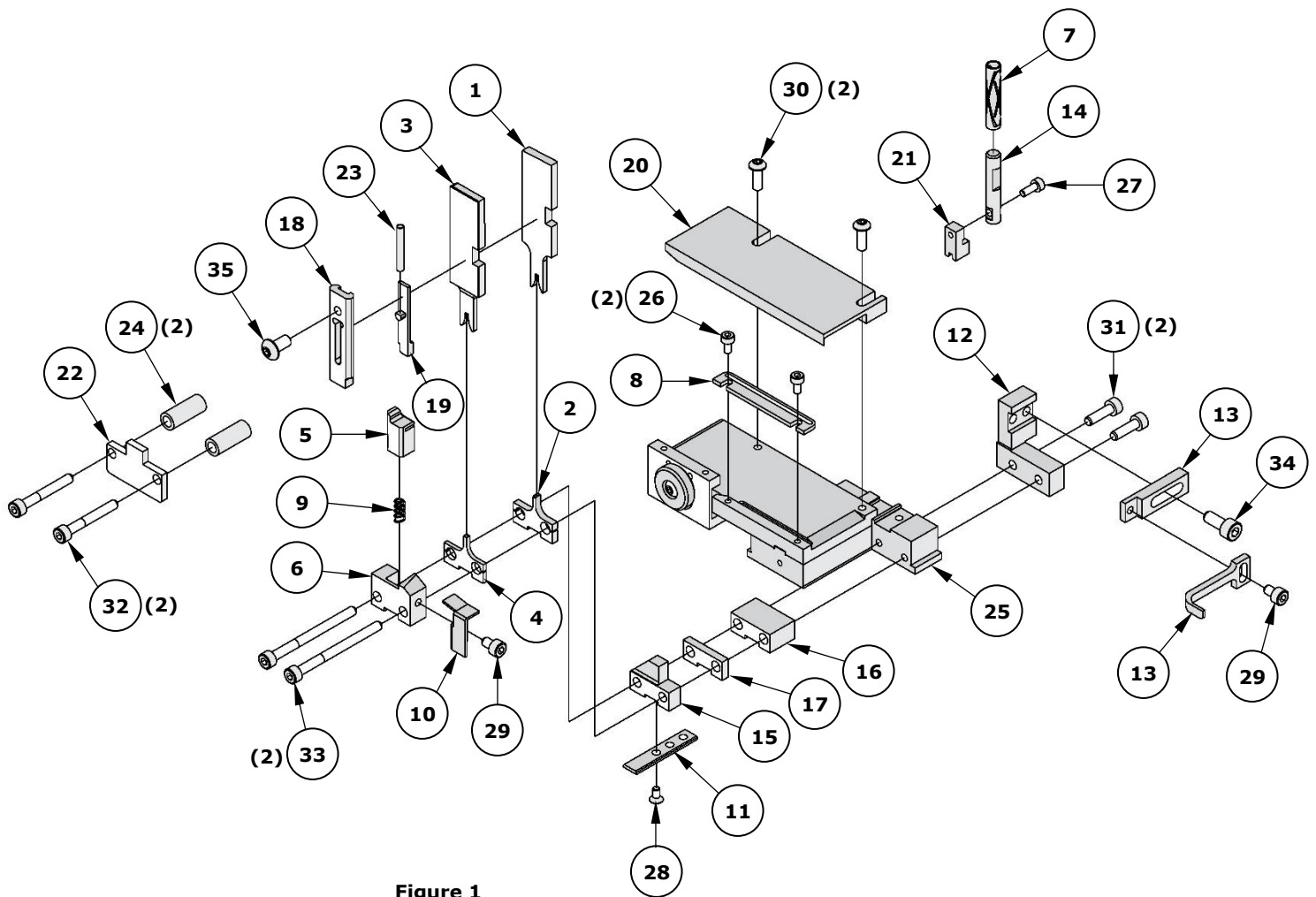
1. Pull force should be measured with no influence from the insulation crimp.
2. The above specifications are guidelines to an optimum crimp.

PARTS LIST

Terminator 63914-8000				
Item	Order No.	Engineering No.	Description	Quantity
Perishable Tooling				
	63914-8070	63914-8070	Tool Kit (All "Y" Items)	REF
1	63444-1609	63444-1609	Conductor Punch	1 Y
2	63455-1607	63455-1607	Conductor Anvil	1 Y
3	63446-2001	63446-2001	Insulation Punch	1 Y
4	63456-2003	63456-2003	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	11-17-0022	1739-21	Hold Down Spring	1
8	11-18-4083	60707-8	Feed Guide	1
9	11-24-1067	4996-4	Cut-off Plunger Spring	1
10	63443-0009	63443-0009	Front Scrape Chute	1
11	63443-0024	63443-0024	Key	1
12	63443-0085	63443-0085	Wire Stop L-Bracket	1
13	63443-0090	63443-0090	Wire Stop	1
14	63443-0093	63443-0093	Hold Down Shank	1
15	63443-1717	63443-1717	Height Spacer	1
16	63443-2215	63443-2215	Coarse Spacer (15.00mm)	1
17	63443-2314	63443-2314	Fine Spacer (3.70mm)	1
18	63443-2802	63443-2802	Front Plunger Striker	1
19	63443-2907	63443-2907	Wire Hold Down Plunger	1
20	63443-6003	63443-6003	Rear Cover	1
21	63443-7114	63443-7114	Terminal Hold Down	1
22	63443-7201	63443-7201	Spring Cover	1
23	63600-0021	63600-0021	Compression Spring	1
24	63600-2972	63600-2972	Collar	2
Frame				
25	63800-8500	63800-8500	T2 Track Assembly	1
Hardware				
26	—	—	M3 by 6 Long SHCS	2*
27	—	—	M3 by 8 Long SHCS	1*
28	—	—	M4 by 6 Long FHCS	1*
29	—	—	M4 by 6 Long SHCS	2*
30	—	—	M4 by 12 Long BHCS	2*
31	—	—	M4 by 14 Long SHCS	2*
32	—	—	M4 by 30 Long SHCS	2*
33	—	—	M4 by 50 Long SHCS	2*
34	—	—	M5 by 12 Long SHCS	1*
35	—	—	#10-32 by 3/8" Long BHCS	1*

* Available from an industrial supply company.

ASSEMBLY DRAWING



NOTES

Depending on the press vintage, a feed finger assembly is supplied with the T2 Terminator.

1. To remove the existing feed finger assembly, loosen the M4 x 10mm set screw in the feed lever.
2. Select T2 feed finger assembly from the terminator box.
3. Insert a screwdriver into the slot behind the feed lever, and force the feed arm spring to the right.
4. Slide the T2 feed finger shaft for the TM42 (11-40-5307) or for the TM40 (11-40-0123) or Base Unit into the feed lever and to the left of the feed arm spring.
5. Release the feed arm spring.
6. Position the feed finger for the selected product. (Refer to Figure 5.1 in the T2 Manual.)

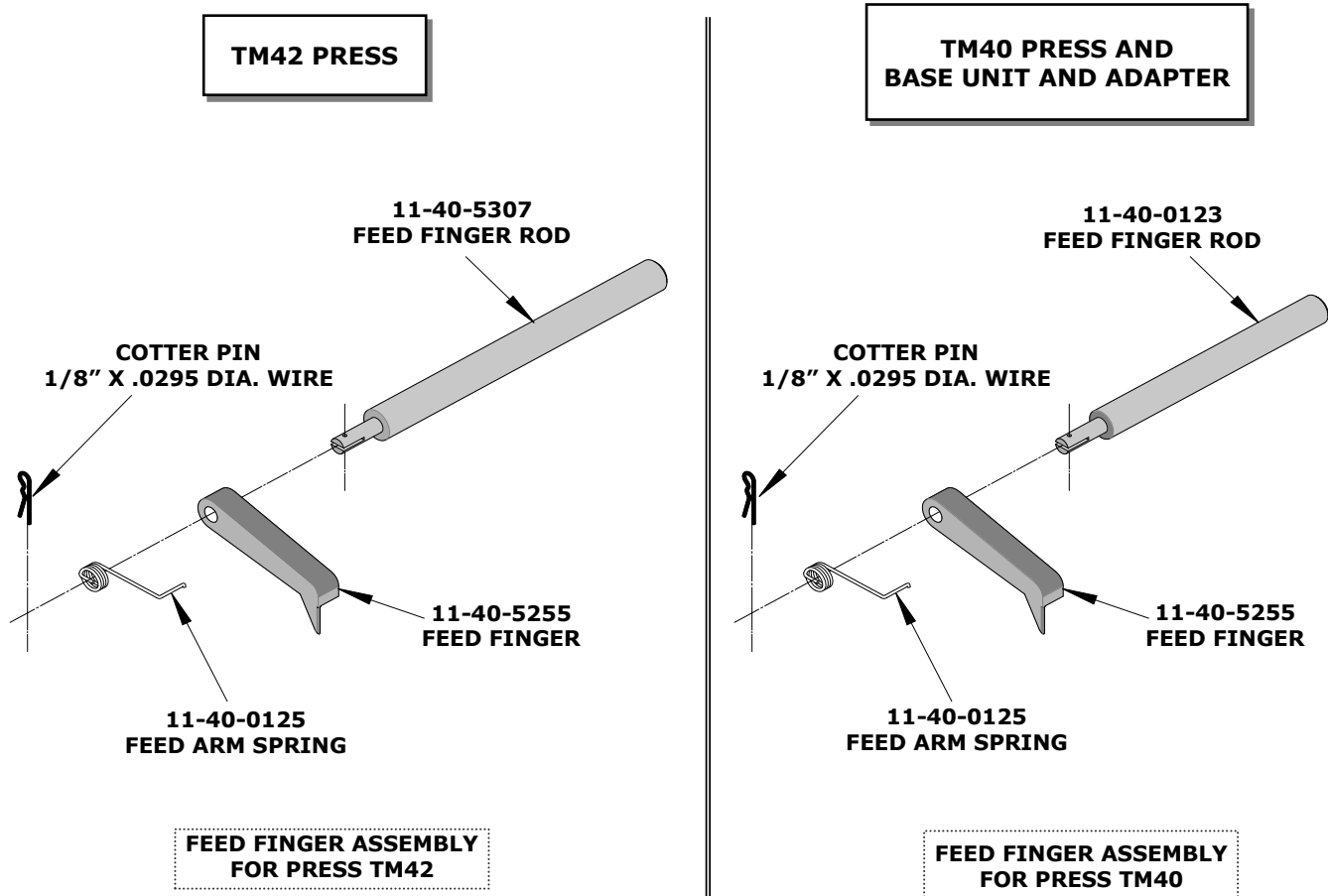


Figure 2

NOTES

1. Molex recommends that 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 the 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 and 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.

Application Tooling Support

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