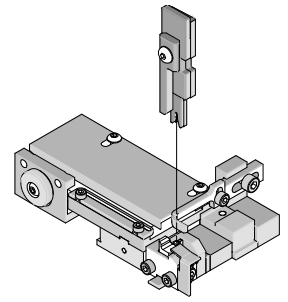


**Order Number**  
**63914-1400**

**molex**<sup>®</sup>

**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 16 AWG with large insulation ODs.

Terminal Series No.	Terminal Order No.			Wire Size		Insulation Diameter				Strip Length	
						IPC/WHMA-A-620 (1)		Terminal (2)			
						mm	In.	mm	In.		
5556	39-00-0077	39-00-0079	39-00-0089	16	1.31	2.60-3.10	.102-.122	1.80-3.10	.071-.122	3.00-3.50	.118-.138
	39-00-0093	39-00-0112	39-00-0118								
	39-00-0141	39-00-0157	39-00-0167								
	39-00-0173	39-00-0179	39-00-0185								
	39-00-0198	39-00-0204	39-00-0211								
	39-00-0217	39-00-0447									
5558	39-00-0081	39-00-0083	39-00-0095	16	1.31	2.60-3.10	.102-.122	1.80-3.10	.071-.122	3.00-3.50	.118-.138
	39-00-0099	39-00-0124	39-00-0130								
	39-00-0147	39-00-0223	39-00-0449								
	98-00-0176	40-01-0855									
44476	44476-3111	44476-3211		16	1.31	2.60-3.10	.102-.122	1.80-3.10	.071-.122	3.00-3.50	.118-.138
44478	44478-3111	44478-3211		16	1.31	2.60-3.10	.102-.122	1.80-3.10	.071-.122	3.00-3.50	.118-.138
44485	44485-3211	44485-3311	44485-3411	16	1.31	2.60-3.10	.102-.122	1.80-3.10	.071-.122	3.00-3.50	.118-.138
45750	45750-3111	45750-3211		16	1.31	2.60-3.15	.102-.122	1.80-3.15	.071-.124	3.00-3.50	.118-.138
46012	46012-3111	46012-3141	46012-3151	16	1.31	2.60-3.10	.102-.122	1.80-3.10	.071-.122	3.00-3.50	.118-.138
	46012-3211	46012-3241	46012-3251								
46018	46018-3541			16	1.31	2.60-3.10	.102-.122	1.80-3.10	.071-.122	3.00-3.50	.118-.138
46083	46083-3111	46083-3121	46083-3211	16	1.31	2.60-3.10	.102-.122	1.80-3.10	.071-.122	3.00-3.50	.118-.138
	46083-3221										
46098	46098-3541			16	1.31	2.60-3.10	.102-.122	1.80-3.10	.071-.122	3.00-3.50	.118-.138
46134	46134-3111	46134-3121	46134-3211	16	1.31	2.60-3.10	.102-.122	1.80-3.10	.071-.122	3.00-3.50	.118-.138
	46134-3221										

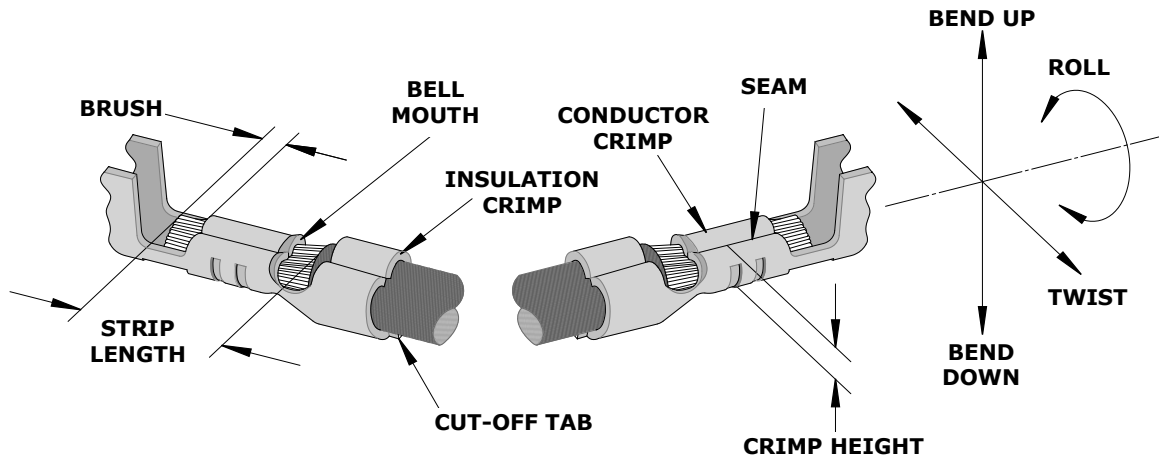
(1) To achieve optimum IPC/WHMA-A-620 insulation crimps, use this insulation OD range.

(2) Overall insulation OD specification for terminal.

See the Molex website for other applicator part numbers to crimp the following insulation diameters:

- 2.20-2.45mm (example UL1007)
- 1.80-2.20mm (example UL1429)

**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	0.20-0.50	.008-.020	0.30	.012	0.00-1.00	.000-.039
5558	0.20-0.50	.008-.020	0.30	.012	0.00-1.00	.000-.039
44476	0.20-0.50	.008-.020	0.30	.012	0.00-1.00	.000-.039
44478	0.20-0.50	.008-.020	0.30	.012	0.00-1.00	.000-.039
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	0.20-0.50	.008-.020	0.30	.012	0.00-1.00	.000-.039
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

Terminal Series No.	Bend Up	Bend Down	Twist	Roll	Punch Width (Ref)				Seam
					Conductor		Insulation		
	Degree		Degree		mm	In.	mm	In.	
5556	5	2	5	15	1.90	.075	3.20	.126	Seam shall not be open and no wire allowed out of the crimping area
5558	5	2	5	15	1.90	.075	3.20	.126	
44476	5	2	5	15	1.90	.075	3.20	.126	
44478	5	2	5	15	1.90	.075	3.20	.126	
44485	5	2	5	15	1.90	.075	3.20	.126	
45750	5	2	5	15	1.90	.075	3.20	.126	
46012	5	2	5	15	1.90	.075	3.20	.126	
46018	5	2	5	15	1.90	.075	3.20	.126	
46083	5	2	5	15	1.90	.075	3.20	.126	
46098	5	2	5	15	1.90	.075	3.20	.126	
46134	5	2	5	15	1.90	.075	3.20	.126	

## T2 Terminator Tooling for Mini-Fit Crimp Terminals

After crimping, the crimp profiles should measure the following:

Terminal Series No.	Wire Size		Conductor				Pull Force Minimum	
			Crimp Height		Crimp Width (Ref)			
	AWG	mm <sup>2</sup>	mm	In.	mm	In.	N	Lb.
5556	16	1.31	1.14-1.24	.045-.049	1.97	.078	68.4	15.4
5558	16	1.31	1.14-1.24	.045-.049	1.97	.078	68.4	15.4
44476	16	1.31	1.14-1.24	.045-.049	1.97	.078	68.4	15.4
44478	16	1.31	1.14-1.24	.045-.049	1.97	.078	68.4	15.4
44485	16	1.31	1.14-1.24	.045-.049	1.97	.078	68.4	15.4
45750	16	1.31	1.14-1.24	.045-.049	1.97	.078	68.4	15.4
46012	16	1.31	1.14-1.24	.045-.049	1.97	.078	68.4	15.4
46018	16	1.31	1.14-1.24	.045-.049	1.97	.078	68.4	15.4
46083	16	1.31	1.14-1.24	.045-.049	1.97	.078	68.4	15.4
46098	16	1.31	1.14-1.24	.045-.049	1.97	.078	68.4	15.4
46134	16	1.31	1.14-1.24	.045-.049	1.97	.078	68.4	15.4

### Tool Qualification Notes

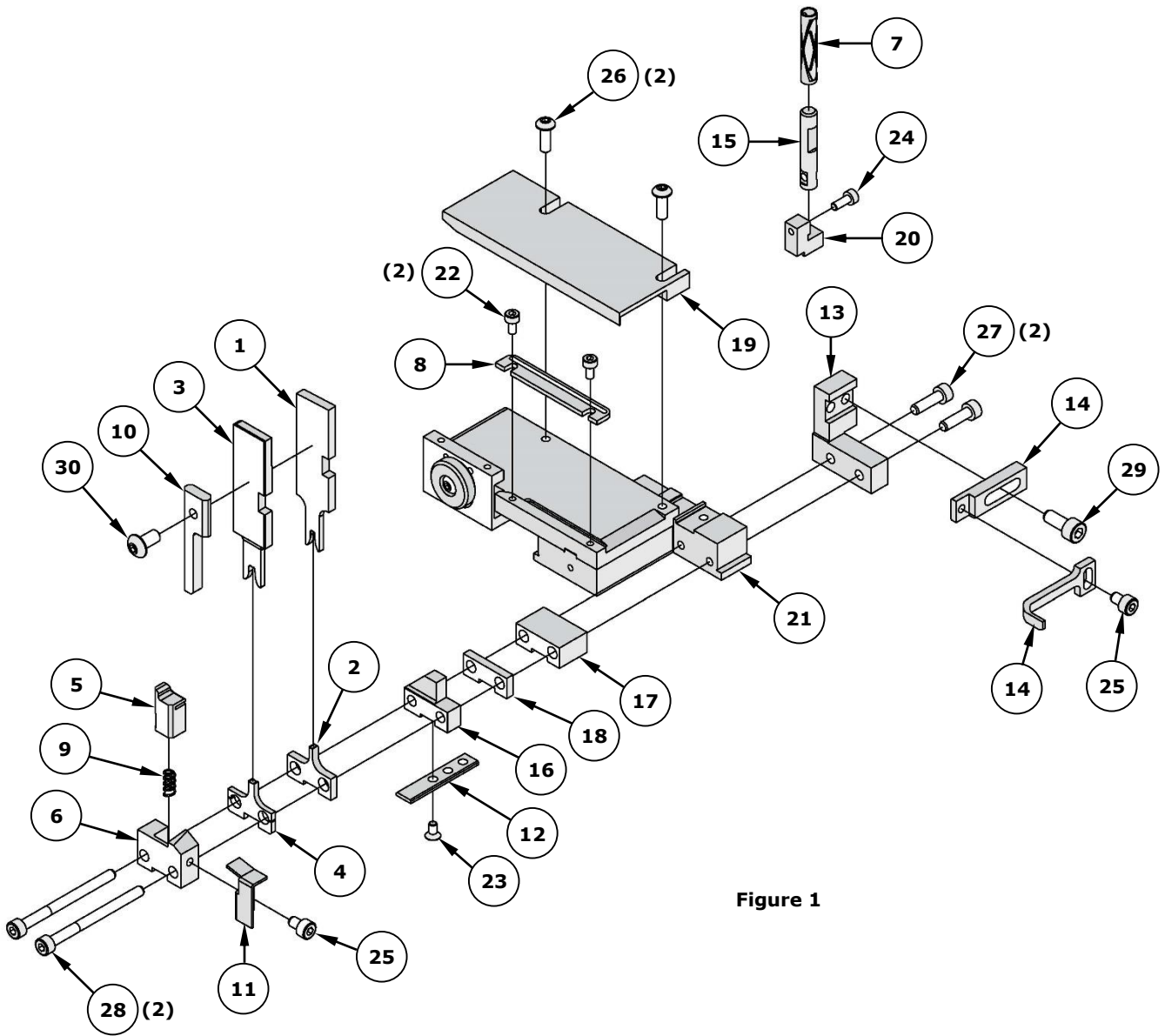
1. Pull force should be measured with no influence from the insulation crimp.
2. The above specifications are guidelines to an optimum crimp.

**PARTS LIST**

<b>T2 Terminator 63914-1400</b>				
<b>Item</b>	<b>Order No.</b>	<b>Engineering No.</b>	<b>Description</b>	<b>Quantity</b>
<b>Perishable Tooling</b>				
	63914-1470	63914-1470	Tool Kit (All "Y" Items)	REF
1	63444-1909	63444-1909	Conductor Punch	1 Y
2	63455-0147	63455-0147	Conductor Anvil	1 Y
3	63446-3208	63446-3208	Insulation Punch	1 Y
4	63445-3217	63445-3217	Insulation Anvil	1 Y
5	63443-0002	63443-0002	Cut-Off Plunger	1 Y
6	63443-0012	63443-0012	Front Plunger Retainer	1 Y
<b>Other Components</b>				
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	11-40-4039	8302-5	Plunger Striker	1
11	63443-0009	63443-0009	Front Scrap Chute	1
12	63443-0024	63443-0024	Key	1
13	63443-0085	63443-0085	Wire Stop L-Bracket	1
14	63443-0090	63443-0090	Wire Stop	1
15	63443-0093	63443-0093	Shank	1
16	63443-1720	63443-1720	Height Spacer (19.00mm)	1
17	63443-2215	63443-2215	Coarse Spacer (15.00mm)	1
18	63443-2310	63443-2310	Fine Spacer (3.50mm)	1
19	63443-6003	63443-6003	Rear Cover	1
20	63443-7132	63443-7132	Terminal Hold Down	1
<b>Frame</b>				
21	63800-8500	63800-8500	T2 Terminator	1
<b>Hardware</b>				
22	—	—	M3 by 6 Long SHCS	2*
23	—	—	M3 by 6 Long FHCS	1*
24	—	—	M3 by 8 Long SHCS	1*
25	—	—	M4 by 6 Long SHCS	2*
26	—	—	M4 by 12 Long BHCS	2*
27	—	—	M4 by 14 Long SHCS	2*
28	—	—	M4 by 50 Long SHCS	2*
29	—	—	M5 by 12 Long SHCS	1*
30	—	—	#10-32 by 3/8" Long BHCS	1*

\* Available from an industrial supply company.

**ASSEMBLY DRAWING**



**Figure 1**

**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.)

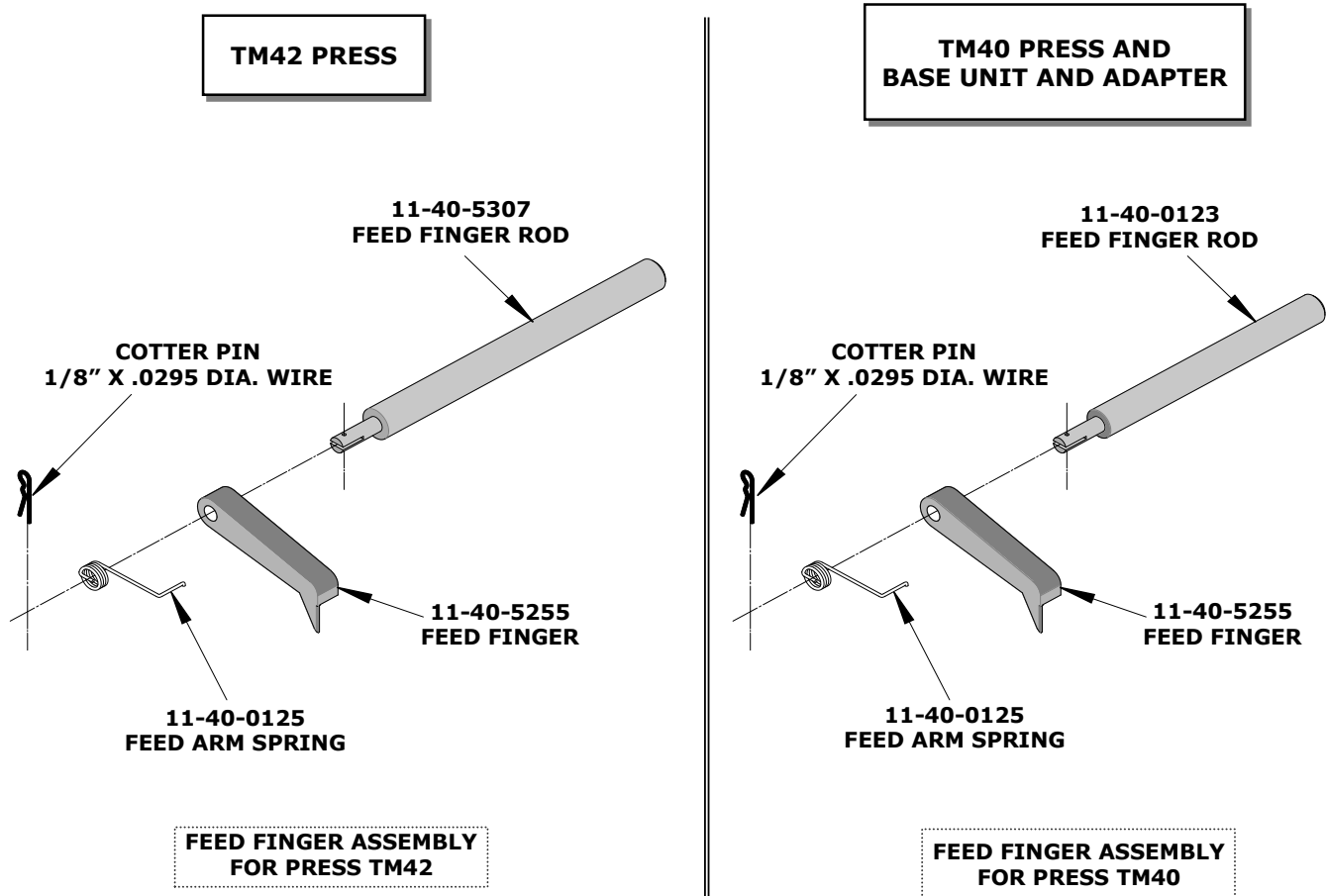


Figure 2

## NOTES

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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

**Phone:** (402) 458-TOOL (8665)

**E-Mail:** [applicationtooling@molex.com](mailto:applicationtooling@molex.com)

**Website:** [www.molex.com/applicationtooling](http://www.molex.com/applicationtooling)

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