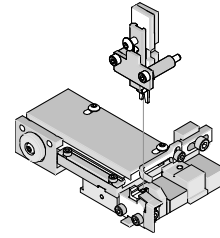


## T2 Terminator Tooling

# molex

## Application Tooling Specification Sheet



Order No. 63912-3800

### FEATURES

- It is ideally suited for mid-volume bench operations
- This terminator can be installed in the TM42 and the TM40 press or Base Unit adapter for 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 cutoff tab length
- T2 Terminator has standardized tooling with the Molex FineAdjust Applicator which will reduce your inventory requirements

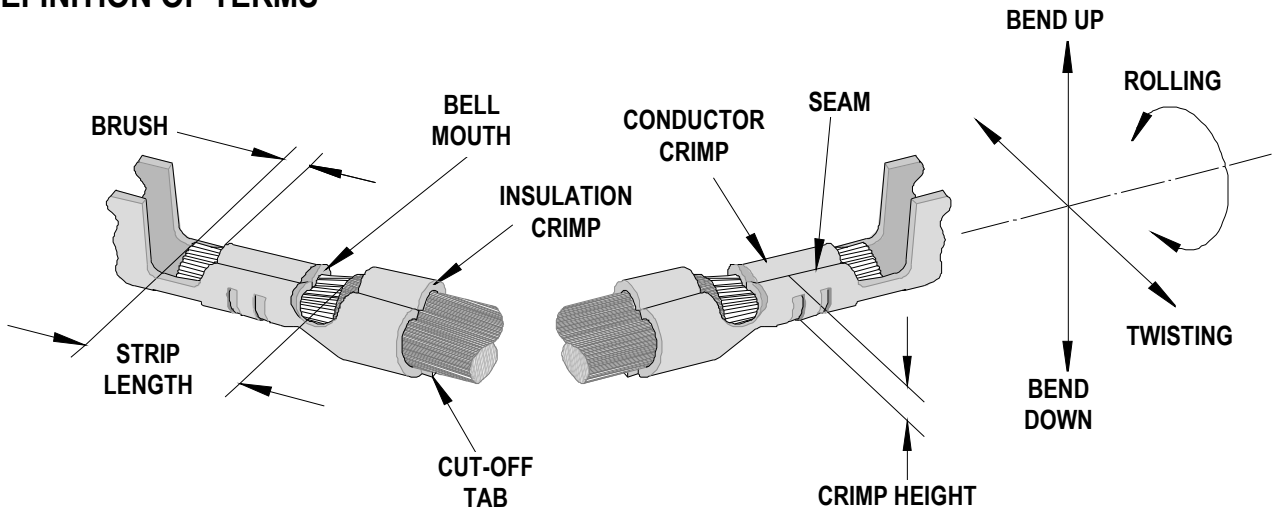
### SCOPE

Products: Mini-Fit Jr.™ Crimp Terminal 22-28 AWG.

Terminal Series No.	Terminal Order No.			Wire Size		Insulation Diameter				Strip Length	
						IPC/WHMA-A620(1)		Terminal(2)			
						AWG	mm <sup>2</sup>	mm	In.		
5556	39-00-0046	39-00-0139	39-00-0196	22-28	0.35-0.08	0.95-1.08	.037-.043	0.90-1.80	.035-.071	2.80-3.30	.110-.130
	39-00-0065	39-00-0155	39-00-0202								
	39-00-0085	39-00-0165	39-00-0209								
	39-00-0091	39-00-0171	39-00-0215								
	39-00-0110	39-00-0177	39-00-0231								
	39-00-0116	39-00-0183	39-00-0434								
5558	39-00-0048	39-00-0128	40-01-0854	22-28	0.35-0.08	0.95-1.08	.037-.043	0.90-1.80	.035-.071	2.80-3.30	.110-.130
	39-00-0067	39-00-0145	98-00-0175								
	39-00-0087	39-00-0221									
	39-00-0097	39-00-0432									
44485	44485-2211	44485-2311	44485-2411	22-28	0.35-0.08	0.95-1.08	.037-.043	0.90-1.80	.035-.071	2.80-3.30	.110-.130
45750	45750-2211			22-24	0.35-0.20	0.95-1.08	.037-.043	1.80 Max.	.071 Max.	2.80-3.30	.110-.130
46018	46018-2541			22-24	0.35-0.20	0.95-1.08	.037-.043	1.80 Max.	.071 Max.	2.80-3.30	.110-.130
46083	46083-2111	46083-2211		22-24	0.35-0.20	0.95-1.08	.037-.043	1.80 Max.	.071 Max.	2.80-3.30	.110-.130
	46083-2121	46083-2221									
46134	46134-2111	46134-2211		22-24	0.35-0.20	0.95-1.08	.037-.043	1.80 Max.	.071 Max.	2.80-3.30	.110-.130
	46134-2121	46134-2221									

(1)To achieve optimum IPC-A620 insulation crimps, use this insulation OD range.  
(2)Overall insulation OD specification for terminal.  
Terminator 63912-0200 should be used for insulation OD 1.10-1.30mm.  
Terminator 63910-2700 should be used for insulation OD 1.30-1.50mm.

### 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
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
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
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	17	1.40	.055	1.40	.055	Seam shall not be open And no wire allowed out of the crimping area
5558	5	2	5	17	1.40	.055	1.40	.055	
44485	5	2	5	17	1.40	.055	1.40	.055	
45750	5	2	5	17	1.40	.055	1.40	.055	
46018	5	2	5	17	1.40	.055	1.40	.055	
46083	5	2	5	17	1.40	.055	1.40	.055	
46134	5	2	5	17	1.40	.055	1.40	.055	

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	22	0.35	0.76-0.83	.030-.033			39.1	8.80
	24	0.20	0.70-0.77	.028-.030			29.3	6.60
	26	0.12	0.66-0.72	.026-.028			19.6	4.40
	28	0.08	0.63-0.69	.025-.027			9.8	2.20
5558	22	0.35	0.76-0.83	.030-.033			39.1	8.80
	24	0.20	0.70-0.77	.028-.030			29.3	6.60
	26	0.12	0.66-0.72	.026-.028			19.6	4.40
	28	0.08	0.63-0.69	.025-.027			9.8	2.20
44485	22	0.35	0.76-0.83	.030-.033			39.1	8.80
	24	0.20	0.70-0.77	.028-.030			29.3	6.60
	26	0.12	0.66-0.72	.026-.028			19.6	4.40
	28	0.08	0.63-0.69	.025-.027			9.8	2.20
45750	22	0.35	0.76-0.83	.030-.033			39.1	8.80
	24	0.20	0.70-0.77	.028-.030			29.3	6.60
46018	22	0.35	0.76-0.83	.030-.033			39.1	8.80
	24	0.20	0.70-0.77	.028-.030			29.3	6.60
46083	22	0.35	0.76-0.83	.030-.033			39.1	8.80
	24	0.20	0.70-0.77	.028-.030			29.3	6.60
46134	22	0.35	0.76-0.83	.030-.033			39.1	8.80
	24	0.20	0.70-0.77	.028-.030			29.3	6.60

\* 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>Terminator 63912-3800</b>				
<b>Item</b>	<b>Order No</b>	<b>Engineering No.</b>	<b>Description</b>	<b>Quantity</b>
<b>Perishable Tooling</b>				
	63912-3870	63912-3870	Tool Kit (All "Y" Items)	REF
1	63444-1421	63444-1421	Conductor Punch	1 Y
2	63445-1441	63445-1441	Conductor Anvil	1 Y
3	63446-1418	63446-1418	Insulation Punch	1 Y
4	63445-1424	63445-1424	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	11-18-4083	60707-8	Feed Guide	1
8	11-24-1067	4996-4	Cut-off Plunger Spring	1
9	63443-0009	63443-0009	Front Scrape Chute	1
10	63443-0024	63443-0024	Key	1
11	63443-0085	63443-0085	Wire Stop L-Bracket	1
12	63443-0090	63443-0090	Wire Stop	1
13	63443-1717	63443-1717	Height Spacer (18.70mm)	1
14	63443-2216	63443-2216	Coarse Spacer (16.00mm)	1
15	63443-2302	63443-2302	Fine Spacer (3.10mm)	1
16	63443-2802	63443-2802	Front Plunger Striker	1
17	63443-2908	63443-2908	Wire Hold Down Plunger	1
18	63443-6003	63443-6003	Rear Cover	1
19	63443-7201	63443-7201	Spring Cover	1
20	63600-0021	63600-0021	Compression Spring	1
21	63600-2972	63600-2972	Collar	2
<b>Frame</b>				
22	63800-8500	63800-8500	T2 Terminator	1
<b>Hardware</b>				
23	N/A	N/A	M3 by 6 Long SHCS	2**
24	N/A	N/A	M3 by 6 Long FHCS	1**
25	N/A	N/A	M4 by 6 Long SHCS	2**
26	N/A	N/A	M4 by 12 Long BHCS	2**
27	N/A	N/A	M4 by 14 Long SHCS	2**
28	N/A	N/A	M4 by 30 Long SHCS	2**
29	N/A	N/A	M4 by 50 Long SHCS	2**
30	N/A	N/A	M5 by 12 Long SHCS	1**
31	N/A	N/A	#10-32 by 3/8" Long BHCS	1**
** Available from an industrial supply company such as MSC (1-800-645-7270).				

### Assembly Drawing

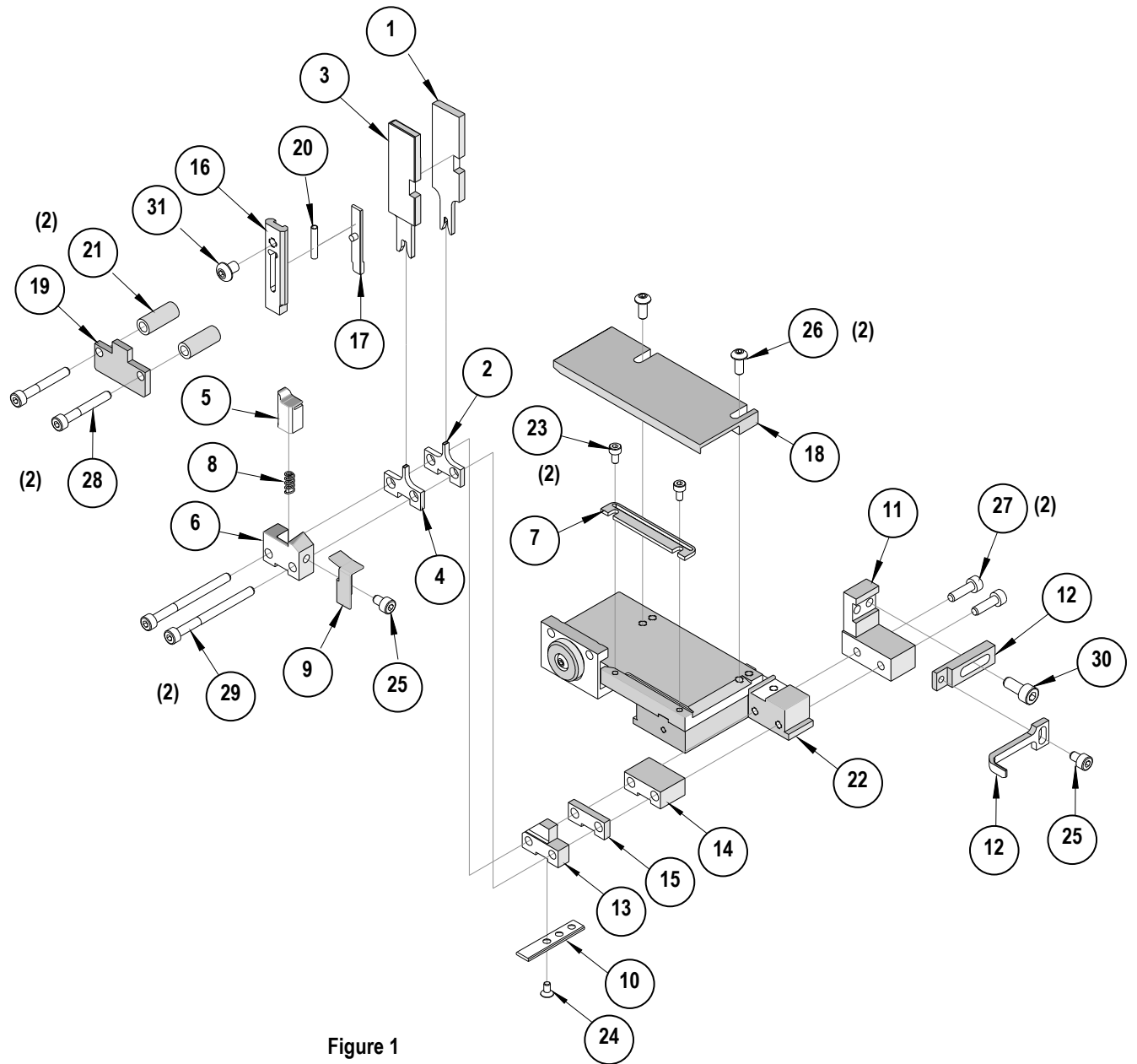


Figure 1

## NOTES

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

1. To remove the existing feed finger assembly loosens the M4 x 10 mm set screw in the feed lever.
2. Select T2 Feed finger assembly from 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 TM42 (11-40-5307) or (11-40-0123) for TM40 /Base Unit into the feed lever and to the left of the feed arm spring.
5. Release the feed arm spring.
6. Position feed finger for selected product. (Refer to Figure 5.1 in the T2 Manual).

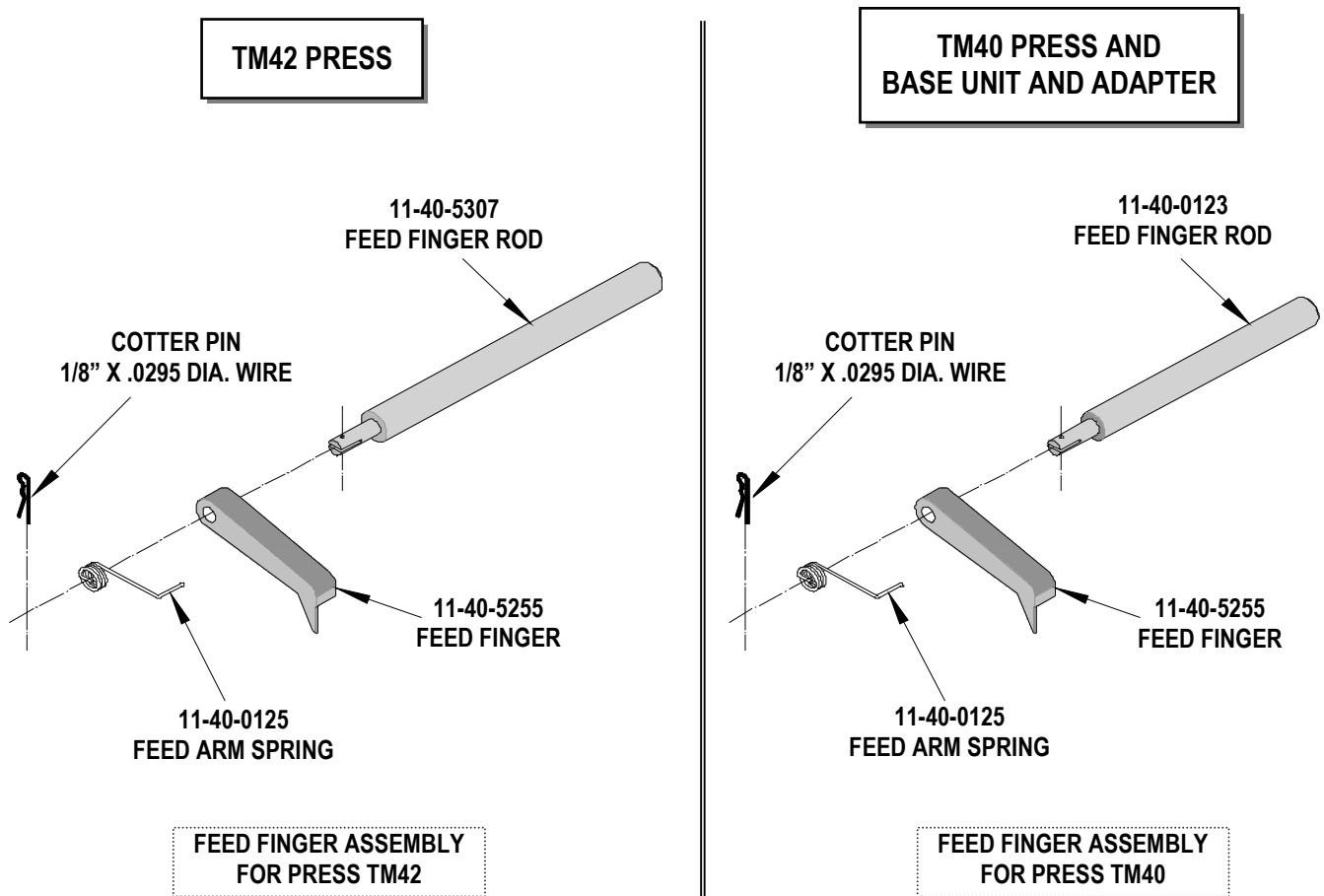


Figure 2

## 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, terminators and tooling.

Visit our Web site at <http://www.molex.com>