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T2 Terminator for Mini-Fit™ Crimp Terminals

<p>T2 Terminator Tooling</p>		
<p>Application Tooling Specification Sheet</p>		<p>Order No. 63912-4800</p>

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.™, Mini-Fit HCS™, and Mini-Fit Plus HCS™ Crimp Terminal 18 AWG ONLY with large insulation OD's.

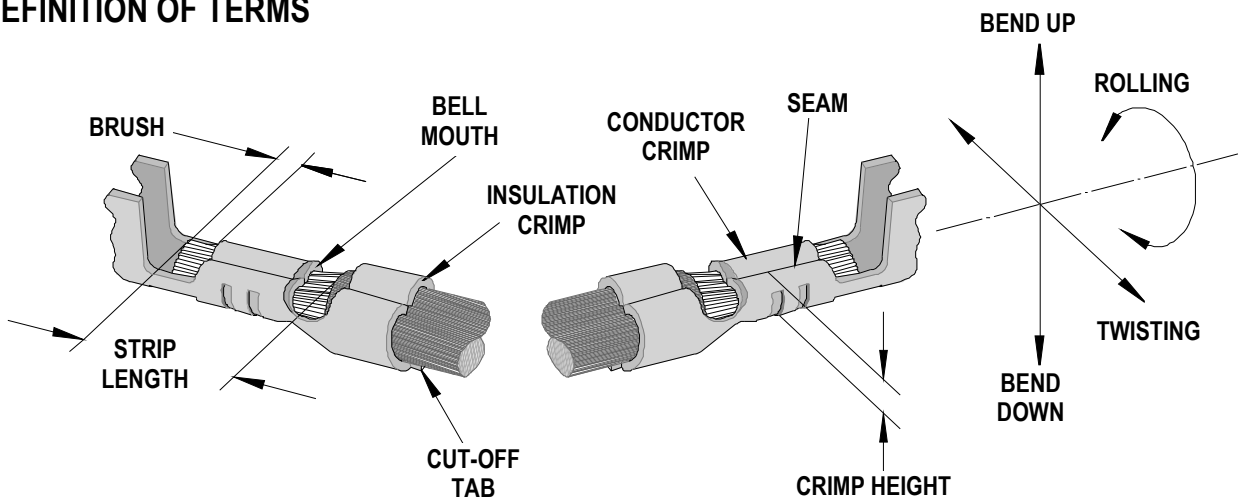
Terminal Series No.	Terminal Order No.		Wire Size		Insulation Diameter				Strip Length	
					IPC/WHMA-A620 (1)		Terminal (2)			
					AWG	mm ²	mm	In.		
5556	39-00-0038	39-00-0055	18	0.80	2.50-2.95	.098-.116	1.30-3.10	.051-.122	3.00-3.50	.118-.138
	39-00-0059	39-00-0073								
	39-00-0108	39-00-0114								
	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								
39-00-0061		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								
98-00-0174										
30490	30490-0002	30490-1002	18	0.80	2.50-2.95	.098-.116	1.30-3.10	.051-.122	3.00-3.50	.118-.138
	30490-2002									
44476	44476-1111	44476-1211	18	0.80	2.50-2.95	.098-.116	1.30-3.10	.051-.122	3.00-3.50	.118-.138
44478	44478-1111	44478-1211	18	0.80	2.50-2.95	.098-.116	1.30-3.10	.051-.122	3.00-3.50	.118-.138
44485	44485-1211	44485-1311	18	0.80	2.50-2.95	.098-.116	1.30-3.10	.051-.122	3.00-3.50	.118-.138
	44485-1411									

T2 Terminator for Mini-Fit™ Crimp Terminals

Terminal Series No.	Terminal Order No.		Wire Size		Insulation Diameter				Strip Length	
					IPC/WHMA-A620 (1)		Terminal (2)			
					AWG	mm ²	mm	In.	mm	In.
45750	45750-1111	45750-1211	18	0.80	2.50-2.95	.098-.116	1.65-2.95	.065-.116	3.00-3.50	.118-.138
46012	46012-1111	46012-1141	18	0.80	2.50-2.95	.098-.116	1.65-2.95	.065-.116	3.00-3.50	.118-.138
	46012-1211	46012-1241								
46018	46018-1541		18	0.80	2.50-2.95	.098-.116	1.65-2.95	.065-.116	3.00-3.50	.118-.138
46083	46083-1111	46083-1121	18	0.80	2.50-2.95	.098-.116	1.65-2.95	.065-.116	3.00-3.50	.118-.138
	46083-1211	46083-1221								
46098	46098-1541		18	0.80	2.50-2.95	.098-.116	1.65-2.95	.065-.116	3.00-3.50	.118-.138
46134	46134-1111	46134-1121	18	0.80	2.50-2.95	.098-.116	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 (example UL1015).
(2) Overall insulation OD specification for terminal.

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 and 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 Seam shall not be open And no wire allowed out of the crimping area
					Conductor		Insulation		
	Degree		Degree		mm	In.	mm	In.	
5556 and 5558	5	2	5	15	1.60	.063	3.20	.126	
30490	5	2	5	15	1.60	.063	3.20	.126	
44476, 44478 and 44485	5	2	5	15	1.60	.063	3.20	.126	
45750	5	2	5	15	1.60	.063	3.20	.126	
46012 and 46018	5	2	5	15	1.60	.063	3.20	.126	
46083 and 46098	5	2	5	15	1.60	.063	3.20	.126	
46134	5	2	5	15	1.60	.063	3.20	.126	

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 ²	mm	In.	mm	In.	N	Lb.
5556	18	0.80	0.97-1.07	.038-.042	1.68	.066	88.0	19.8
5558	18	0.80	0.97-1.07	.038-.042	1.68	.066	88.0	19.8
30490	18	0.80	0.97-1.07	.038-.042	1.68	.066	88.0	19.8
44476	18	0.80	0.97-1.07	.038-.042	1.68	.066	68.4	15.4
44478	18	0.80	0.97-1.07	.038-.042	1.68	.066	68.4	15.4
44485	18	0.80	0.97-1.07	.038-.042	1.68	.066	88.0	19.8
45750	18	0.80	0.97-1.07	.038-.042	1.68	.066	68.4	15.4
46012	18	0.80	0.97-1.07	.038-.042	1.68	.066	68.4	15.4
46018	18	0.80	0.97-1.07	.038-.042	1.68	.066	68.4	15.4
46083	18	0.80	0.97-1.07	.038-.042	1.68	.066	68.4	15.4
46098	18	0.80	0.97-1.07	.038-.042	1.68	.066	68.4	15.4
46134	18	0.80	0.97-1.07	.038-.042	1.68	.066	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.

T2 Terminator for Mini-Fit™ Crimp Terminals

PARTS LIST

T2 Terminator 63912-4800				
Item	Order No	Engineering No.	Description	Quantity
Perishable Tooling				
	63912-4870	63912-4870	Tool Kit (All "Y" Items)	REF
1	63444-1609	63444-1609	Conductor Punch	1 Y
2	63445-1746	63445-1746	Conductor Anvil	1 Y
3	63446-3208	63446-3208	Insulation Punch	1 Y
4	63445-3211	63445-3211	Insulation Anvil	1 Y
5	63443-0002	63443-0002	Front Cut-Off Plunger	1 Y
6	63443-0012	63443-0012	Front Plunger Retainer	1 Y
Other Components				
7	11-18-4083	60707-8	Feed Guide	1
8	11-24-1067	4996-4	Cut-Off Plunger Spring	1
9	11-40-4039	8302-5	Plunger Striker	1
10	63443-0009	63443-0009	Front Scrap 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	63443-1719	63443-1719	Height Spacer	1
15	63443-2216	63443-2216	Coarse Spacer (16.00mm)	1
16	63443-2302	63443-2302	Fine Spacer (3.10mm)	1
17	63443-6003	63443-6003	Rear Cover	1
Frame				
18	63800-8500	63800-8500	T2 Terminator	1
Hardware				
19	N/A	N/A	M3 by 6 Long SHCS	2**
20	N/A	N/A	M3 by 6 Long FHCS	1**
21	N/A	N/A	M4 by 6 Long SHCS	2**
22	N/A	N/A	M4 by 12 Long BHCS	2**
23	N/A	N/A	M4 by 14 Long SHCS	2**
24	N/A	N/A	M4 by 50 Long SHCS	2**
25	N/A	N/A	M5 by 12 Long SHCS	1**
26	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).

T2 Terminator for Mini-Fit™ Crimp Terminals

Assembly Drawing

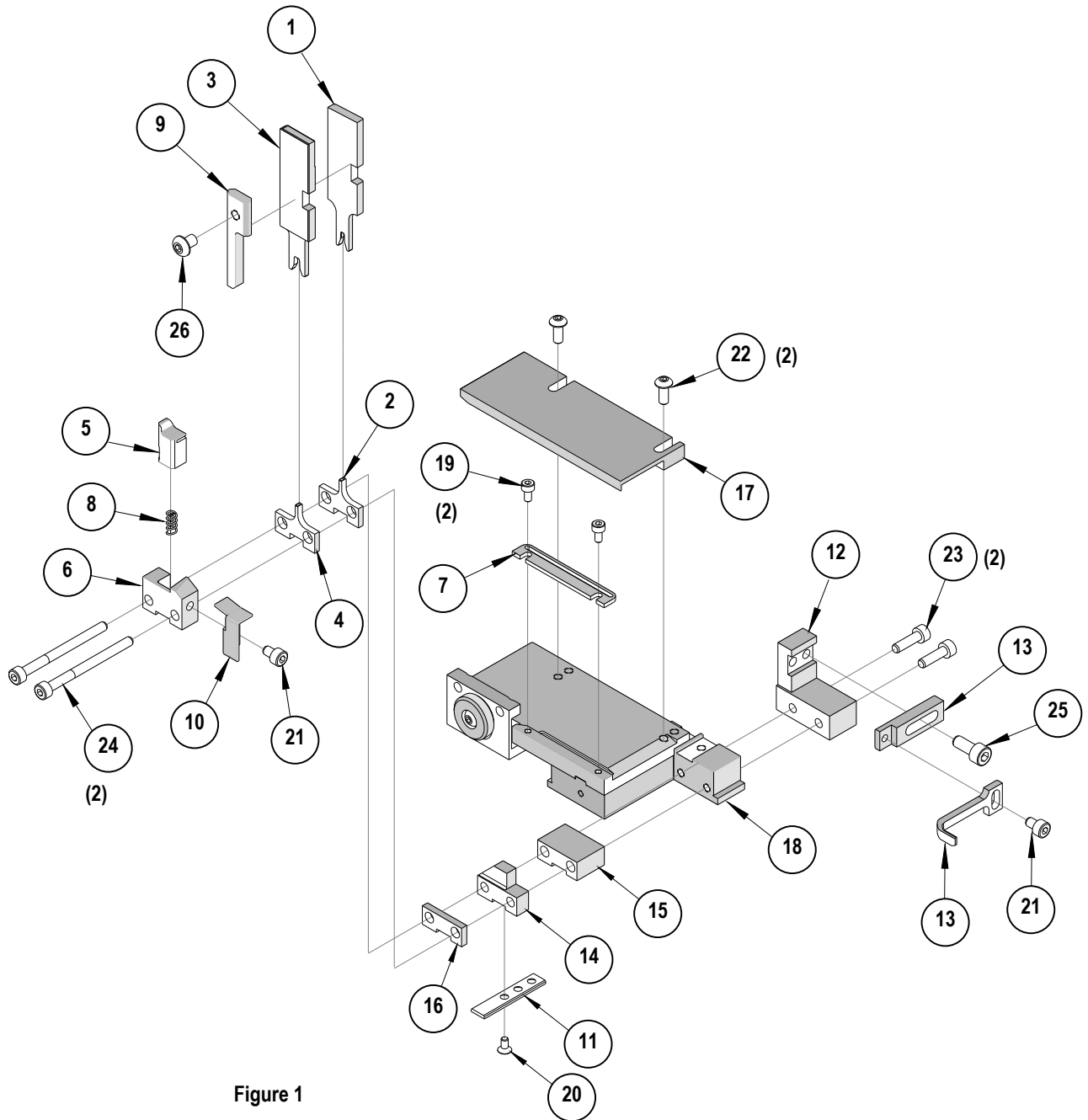


Figure 1

T2 Terminator for Mini-Fit™ Crimp Terminals

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).

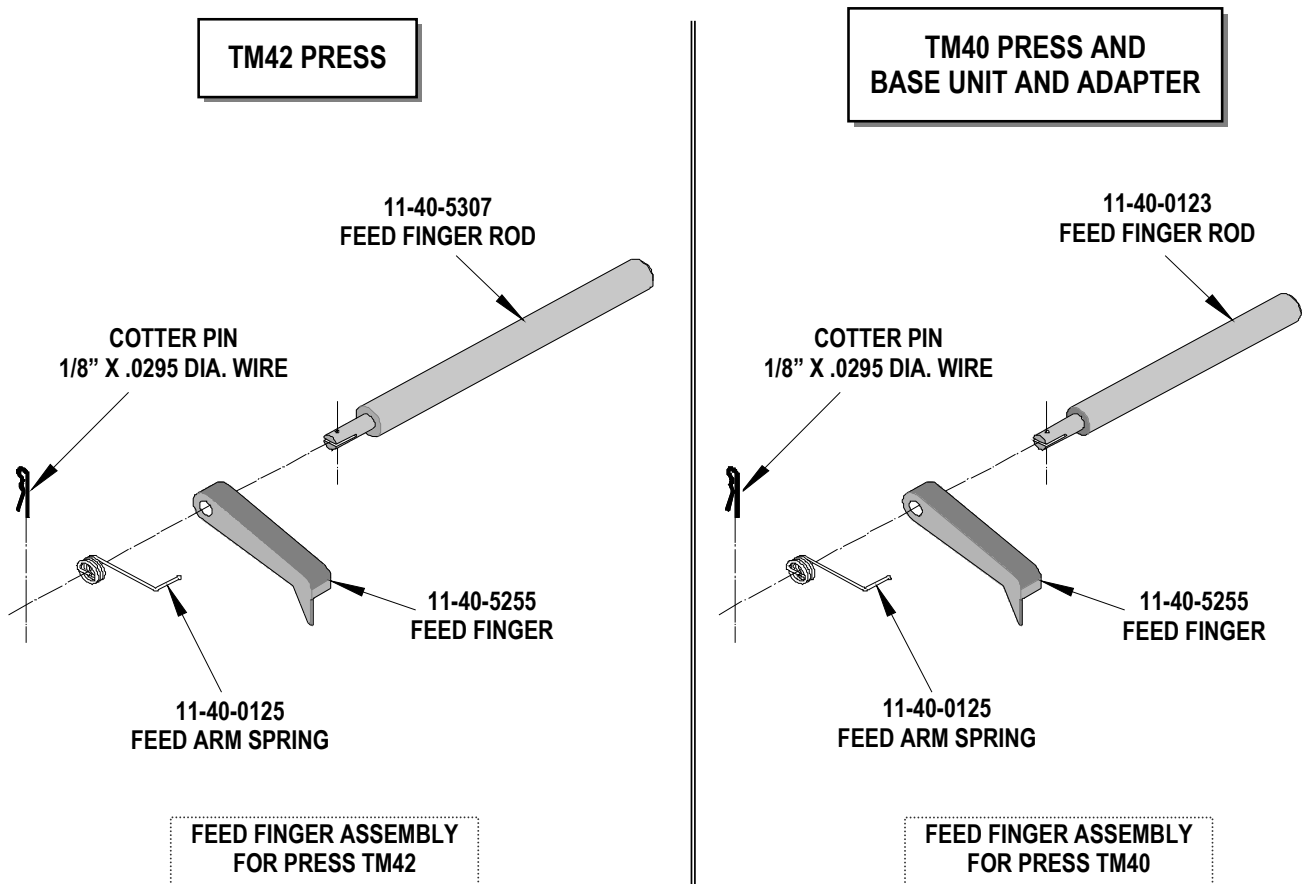


Figure 2

T2 Terminator for Mini-Fit™ Crimp Terminals

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.

<http://www.molex.com>