GUIDELINES FOR MINI-FIT JR. DUAL-WIRE TERMINATION

1. SCOPE

This Application Specification covers application guidelines for the MINI-FIT JR. 4.20 mm (.165 inch) centerline (pitch) wire to board and wire to wire connector system with tin or 30µ" gold plating dual-terminated with combinations of 18 to 22 AWG stranded copper wire using crimp technology.

2. PRODUCT DESCRIPTION

<table>
<thead>
<tr>
<th>Description</th>
<th>Series Number</th>
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<tbody>
<tr>
<td>Female Crimp Terminal</td>
<td>5556</td>
</tr>
<tr>
<td>Male Crimp Terminal</td>
<td>5558</td>
</tr>
</tbody>
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3. REFERENCE DOCUMENTS

Mini-Fit Jr. Product Specification PS-5556-001
Mini-Fit Jr. Dual-Wire Termination Test Summary 55560010-TS
Mini-Fit Jr. Application Tooling Specification

4. GENERAL APPLICATION NOTES

4.1. CRIMP AND ASSEMBLY REQUIREMENTS

4.1.1. WIRE PREP AND CRIMPING
- Wires must be crimped in a vertical configuration with larger-gage wire farther from the terminal body than the smaller-gage wire.

4.1.2. TERMINAL INSERTION INTO HOUSING
- Ensure complete seating of terminal retention features into housing. Large gage wires with large diameter insulation can increase difficulty in fully inserting terminal into housing.

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1 See referenced product specification for applicable product names, series numbers, and reference documents.
2 See applicable ATS listed under terminal part number on Molex.com for crimping requirements.
4.1.3. WIRE/ HARNESS DRESSING
- Dual-terminated wires exiting a single circuit may be bound together via wire tie, sleeving, shrink-wrap, etc. starting at wire exit from housing.
  - Bindings between wires exiting multiple circuits must respect minimum free length “T” specified in applicable product specification.

4.2. INSPECTION NOTES

4.2.1. INSULATION-TO-HOUSING CONTACT
- Terminals must be allowed to float inside housing pocket. Wire insulation should not limit terminal movement by interfering with the housing.

Clearance Between Insulation & Housing:
Allows for Terminal Float

No Clearance Between Insulation & Housing:
Interference Limits Terminal Float

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3 Inspection notes are not comprehensive. Items listed are for reference only and should be carried out as part of an application-specific inspection plan. Due to significant variations in end-use conditions Molex does not guarantee passing the inspection items listed will always result in acceptable part performance.
4.2.2. DAMAGED STRANDS
- Additional wire volume in conductor crimp can increase the possibility of wire damage during crimping. Inspect wire strands after crimping and before insertion of terminal/wire assembly into housing. Strands should be free of nicks, divots, or any other physical damage as they enter the conductor crimp.

Conductors Intact - Acceptable

Conductors Damaged – Unacceptable

4.2.3. TERMINAL BACKOUT
- Inspect for terminal backout due to incomplete terminal seating. See 4.1.2