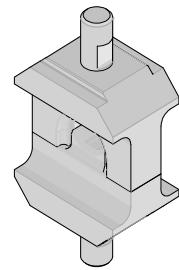




**Crimp Tool Kit  
For Imperium  
and Imperium Plus**

**Application Tooling  
Specification Sheet**



**Order No. 19290-0100**

**SCOPE**

**Tooling:** Crimp Tool Kits are used with the Hydraulic Head Crimper with the Air/Hydraulic Pump (19286-1000). Refer to the appropriate tool instruction manual for installation and operation information.

**Products:** Imperium and Imperium Plus Terminals to 1 AWG bare and pre-tinned copper wire. Refer to the Product part number charts on this sheet for terminals.

**Testing**

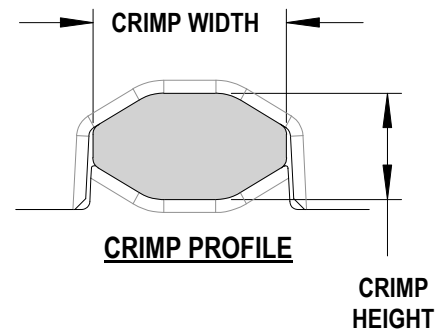
The tensile test or pull test is a means of evaluating the mechanical properties of the crimped connections. The following chart shows the specifications for the wire size. The tensile strength is shown in Newton and (pounds) and indicates the minimum acceptable force to break or separate the terminal from the conductor.

| Wire Size (AWG) | Minimum Pull (UL 486) |
|-----------------|-----------------------|
| 1               | 890N (200 lbs.)       |

**Crimp measurement**

After crimping, the terminal crimp profiles should measure the following:

| Terminal Series | Wire Size |                           | Crimp Height (Ref) |           | Crimp Width (Ref) |           |
|-----------------|-----------|---------------------------|--------------------|-----------|-------------------|-----------|
|                 | AWG       | Wire Style                | mm                 | In.       | mm                | In.       |
| 171423 / 171562 | 1         | Bare copper<br>Pre-Tinned | 6.90-7.10          | .272-.280 | 11.95-12.15       | .470-.478 |
| 31561           | 1         | Bare copper<br>Pre-Tinned | 6.85-7.05          | .270-.278 | 11.90-12.10       | .469-.476 |



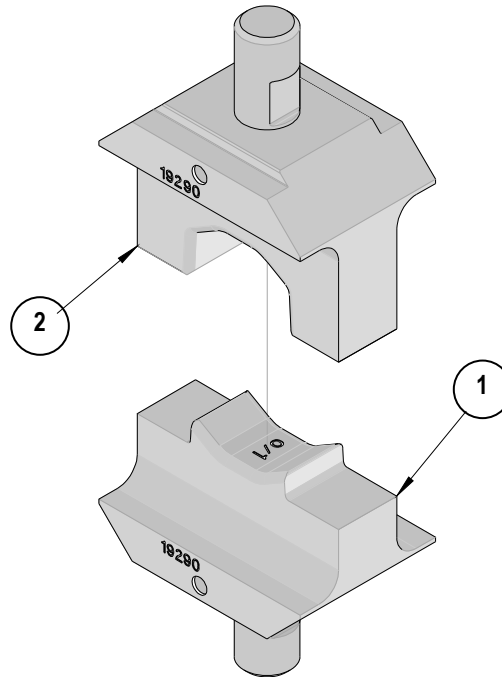
The following is a Partial List of the Product Part Numbers and their specifications that this tooling is designed to crimp. We will be adding to this list and an up to date copy is available on [www.molex.com](http://www.molex.com).

| Terminal Series | Terminal No. | Wire Size (AWG) | Wire Strands / AWG   | Wire Strip Length |      |
|-----------------|--------------|-----------------|----------------------|-------------------|------|
|                 |              |                 |                      | In                | mm   |
| 171423          | 171423-1402  | 1               | 779 / 30<br>817 / 30 | 0.87              | 22.0 |
| 171562          | 171562-7004  |                 |                      |                   |      |
| 31561           | 31561-7001   |                 |                      |                   |      |

**CAUTION:** Molex crimp specifications are valid only when used with Molex terminals and tooling.

## Parts List

| Item | Order No.         | Description              | Qty        |
|------|-------------------|--------------------------|------------|
|      | <b>19290-0100</b> | <b>Crimp Tooling Kit</b> | <b>REF</b> |
| 1    | 19290-0101        | Conductor Anvil          | 1          |
| 2    | 19290-0102        | Conductor Punch          | 1          |



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