

HHL Tooling Kit

Application Tooling Specification Sheet

Order No. 19290-0010
Eng. No. HHL-G-140

SCOPE

Tooling: HHL Tooling Kits are used with Hydraulic Head Crimper with Air/Hydraulic Pump (19286-0117) or Hydraulic Head Crimper with Electric Hydraulic Pump (19286-1300). Refer to the appropriate tool instruction manual for installation and operation information.

Products: BCL and VersaKrimp™ Ring Tongue Terminals and Splices 2 AWG. Refer to the Product part number charts on this sheet for terminals with the barrel and tongue styles listed above.

Testing

Mechanical

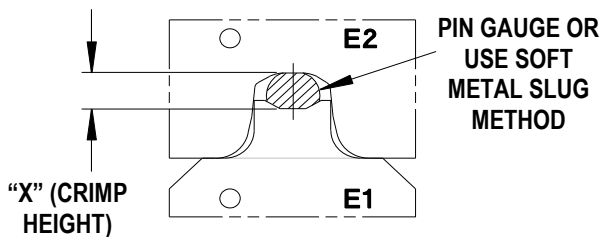
The tensile test or pull test is a means of evaluating the mechanical properties of the crimped connections. The following charts show the UL Specifications for various wire sizes. The tensile strength is shown in pounds and indicates the minimum acceptable force to break or separate terminal from the conductor.

Color Code	Wire Size (AWG)	*UL - 486 A	*UL - 486 C	**MIL-T-7928
Red	2	180	---	550

*UL - 486 A - Terminals (Copper Conductors only)

*UL - 486 C – Butt Splices, Parallel Splices, and Closed end Connectors. Use 486 A values.

**MIL-T-7928 - Military Approved Terminals only as listed.



CRIMP PROFILE

Use gauge pins or soft metal slug (solder) method to measure the “X” dimension. Verify tooling crimp height calibration by referring to the Go/No Go dimensions shown in the chart below.

Molex does not sell gauge pins contact your local industrial supplier.

Wire Range		“X” Dimension Conductor Crimp						Crimp Inspection Marking
		Mean		Go		No Go		
AWG	mm ²	In	mm	In	mm	In	mm	
2	26.6-42.4	.275	6.99	.269	6.83	.281	7.14	2

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.

Wire Size: 2 AWG 26.6-42.4mm ² CMA 52,600-83,700			
Terminal No.	Terminal Eng No. (REF)	Wire Strip Length	
		In	mm
19193-0297	G-374-14	.578	14.68
19193-0298	G-374-38	.578	14.68
19193-0299	G-374-56	.578	14.68
19193-0301	G-374-58	.578	14.68
19193-0306	G-375-14R90	.578	14.68
19193-0308	G-375-38R90	.578	14.68
19193-0310	G-375-56R90	.578	14.68
19193-0311	G-375-76	.578	14.68
19193-0312	G-376-12	.578	14.68
19193-0313	G-376-14	.578	14.68
19193-0314	G-376-38	.578	14.68
19193-0315	G-376-56	.578	14.68
19193-0316	G-376-58	.578	14.68
19193-0317	G-376-76	.578	14.68
19193-0318	G-377-12	.578	14.68
19193-0319	G-377-14	.578	14.68
19193-0320	G-377-34	.578	14.68
19193-0321	G-377-38	.578	14.68
19193-0322	G-377-56	.578	14.68
19193-0324	G-377-76	.578	14.68
19193-0611	G-377-58	.578	14.68
19193-0626	G-374-56R90	.578	14.68
19205-0008	G-373	.578	14.68
19215-0046	G-372	.531	13.49
19215-0062	BCL-2	.594	15.09

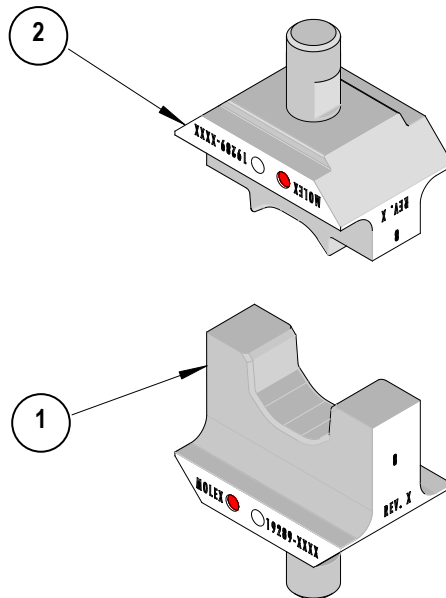
Wire Size: 2 AWG 26.6-42.4mm ² CMA 52,600-83,700			
Terminal No.	Terminal Eng No. (REF)	Wire Strip Length	
		In	mm
19221-0233	BCL-2516-PL	.594	15.09
19221-0235	BCL-238-PL	.594	15.09
19221-0236	BCL-212-PL	.594	15.09
19221-0380	BCL-238	.594	15.09
19221-0399	BCL-212	.594	15.09
19221-0400	BCL-2516	.594	15.09
19221-0418	BCL-214-PL	.594	15.09
19221-0419	BCL-214	.594	15.09
19221-0564	BCL-238-WP	.594	15.09
19221-0565	BCL-238-WP-PL	.594	15.09
19231-0001	BCL-238-SH	.594	15.09
19231-0002	BCL-238-SH-PL	.594	15.09
19231-0003	BCL-238-WP-SH	.594	15.09
19231-0004	BCL-212-WP-SH-PL	.594	15.09

MILITARY			
Wire Size: 2 AWG 26.6-42.4mm ² CMA 52,600-83,700			
Terminal No.	Terminal Eng No. (REF)	Wire Strip Length	
		In	mm
19193-0296	G-374-12	.578	14.68
19193-0302	G-374-76	.578	14.68
19193-0303	G-375-10	.578	14.68
19193-0305	G-375-14	.578	14.68
19193-0307	G-375-38	.578	14.68
19193-0309	G-375-56	.578	14.68

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

Parts List

Item	Order No.	Engineering No.	Description	Qty
	19290-0010	HHL-G-140	HHL Tooling Kit	REF
1	19290-0021	HHL-G-140-E2	Conductor Punch	1
2	19290-0020	HHL-G-140-E1	Conductor Anvil	1



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