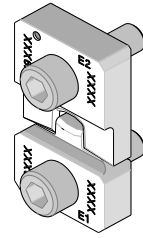


**ATP
Tooling Kit**



**Application Tooling
Specification Sheet**



Order No. 19808-2030

SCOPE

Tooling: ATP Tooling Kits used with Molex Air Tape Press: (ATP 100 and 300 series) or a Molex Mylar Tape Applicator (MTA series). Refer to the appropriate tool instruction manual for installation and operation information.

Products: Perma-Seal™ Ring Tongue Terminals 18-22 AWG. Refer to the Product part number charts on this sheet for terminals with the barrel and tongue styles listed above.

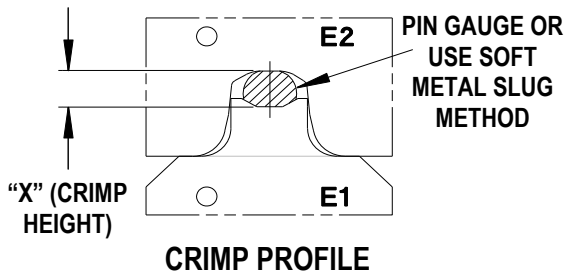
Testing

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
Red	18	20
Red	20	13
Red	22	8

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



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	
18-22	NA	.094	2.39	.091	2.31	.101	2.57	N/A

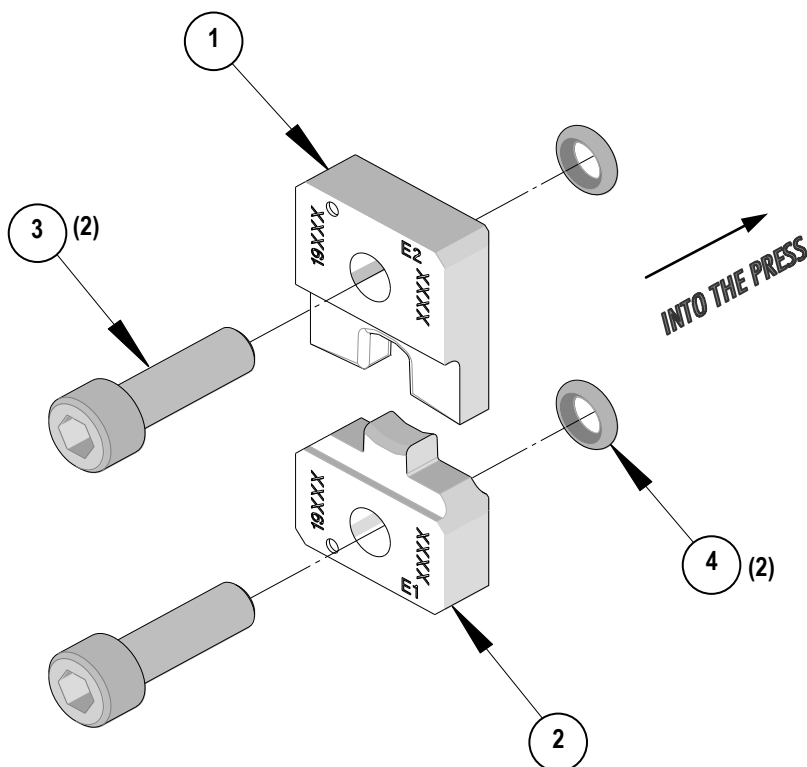
The following is a Partial List of the Product Part Numbers and their specifications that this tooling is designed to crimp. We will be adding to this list and an up to date copy is available on www.molex.com.

Wire Size: 18 – 22 AWG					
Terminal No.	Terminal	Wire Strip Length		Insulation Diameter Maximum	
	Eng No. (REF)	In.	mm	In.	mm
19164-1155	SA-235-06T	.281	7.14	.215	5.46
19164-1156	SA-235-08T	.281	7.14	.215	5.46
19164-1157	SA-235-10T	.281	7.14	.215	5.46

Parts List

Item	Order No.	Engineering No.	Description	Qty
	19808-2030	19808-2030	ATP Tooling Kit	REF
1	19808-2031	19808-2031	Conductor Punch	1
2	19808-2032	19808-2032	Conductor Anvil	1
3	N/A	N/A	#10-32 by 1/2" SHCS -Low Head	2**
4	N/A	N/A	O-ring 1/16 W. by 9/32" O.D.	2**

** Available from an Industrial supply company such as MSC 1-800-645-7270.



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