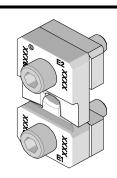


# Crimp Tooling Specification Sheet ATP Tooling Kit No. 19027-0306 Engineering No. 19027-0306



### **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:** Krimptite® Ring Tongue Terminal 18-22 AWG.

Refer to the Product part number charts on this sheet for terminals with the barrel and tongue styles listed above.

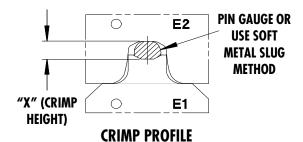
## **Testing**

#### 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						
		Mean		Go		No Go		<b>Crimp Inspection Marking</b>
AWG	mm²	ln	mm	ln	mm	ln	mm	
18 - 22	0.80 - 0.35	.069	1.75	.066	1.67	.076	1.93	N/A

Doc No. ATS-190270306 Release Date: 12-04-03 UNCONTROLLED COPY Page 1 of 3

Revision: A Revision Date: 10-30-06

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 <a href="https://www.molex.com">www.molex.com</a>.

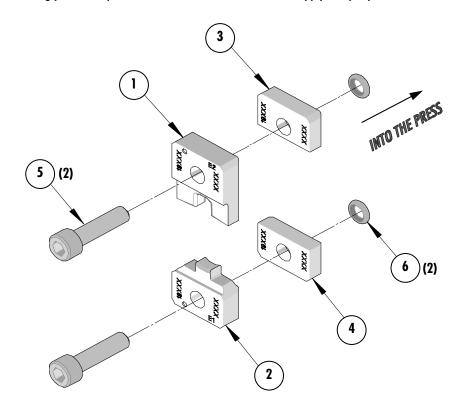
Wire Size: 18 - 22 AWG 0.80 - 0.35mm <sup>2</sup>						
Terminal No.	Terminal	Wire Str	ip Length	Insul. Dia. Max.		
	Eng No. (REF)	In	mm	ln	mm	
19044-0006	A-126-10T	.281	7.14	N/A	N/A	
19044-0007	A-126-38T	.281	7.14	N/A	N/A	
19044-0008	A-126-56T	.281	7.14	N/A	N/A	
19044-0009	A-132-04T	.281	7.14	N/A	N/A	
19044-0010	A-133-10T	.281	7.14	N/A	N/A	
19044-0080	A-126-14T	.281	7.14	N/A	N/A	
19044-0085	A-132-06T	.281	7.14	N/A	N/A	
19044-0087	A-132-08T	.281	7.14	N/A	N/A	

**UNCONTROLLED COPY** Doc No. ATS-190270306 Page 2 of 3 Release Date: 12-04-03 Revision Date: 10-30-06

## **Parts List**

Item	Order No.	Engineering No.	neering No. Description	
	19027-0306	19027-0306	ATP Tooling Kit	REF
1	19027-0028	ATP-A-110-E2	Conductor Punch	1
2	19027-0027	ATP-A-110-E1	Conductor Anvil	1
3	19027-0201	DS-187-UPPER	Die Spacer - Upper (.187")	1
4	19027-0200	DS-187-LOWER	Die Spacer - Lower (.187")	1
5	N/A	N/A	#10-32 by 3/4" Long SHCS	2**
6	N/A	N/A	0-ring 1/16 W by 9/32" OD	2**

<sup>\*\*</sup> The following purchased parts are available from an Industrial supply company such as MSC 1-800-645-7270



**Americas Headquarters** Lisle, Illinois 60532 U.S.A. 1-800-78MOLEX

amerinfo@molex.com

**Far East North Headquarters** Yamato, Kanagawa, Japan 81-462-65-2324 feninfo@molex.com

**Far East South Headquarters** Jurong, Singapore 65-6-268-6868 fesinfo@molex.com

**European Headquarters** Munich, Germany 49-89-413092-0

2222 Wellington Ct. Lisle, IL 60532 U.S.A. eurinfo@molex.com 630-969-4550

Fax: 630-969-1352

**Corporate Headquarters** 

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

Doc No. ATS-190270306 **Revision: A** 

Release Date: 12-04-03 Revision Date: 10-30-06 **UNCONTROLLED COPY**