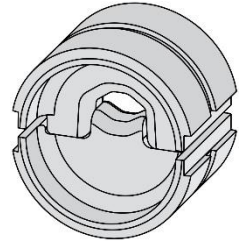# Order Number 219382-0120

molex

Application Tooling Specification

TOOLING

- The U-style die set can be used with any C-head compression tool that accepts U-style dies.
- Molex does not sell a C-head compression tool, but we recommend the three Huskie tools listed below:
    - **S7L-MK510:** 12-ton C-head compression tool, handle-forward design
    - **REC-MK7510:** 12-ton C-head compression tool, pistol design
    - **SL-MKC7510:** 12-ton C-head compression tool, inline design
        - The above Huskie tools <u>must be set to 13 tons by Huskie Tools</u> to crimp the terminal listed for this die set. Compression tools cannot be set by the customer.
        - A C-head is required for fast and easy terminal placement and extraction from the die set.
- Other compression tools can be used; however, they must meet the following requirements:
    - Accept U-style industry-standard die sets
    - C-shaped head for terminal removal
    - 13-ton minimum compression
- Refer to the appropriate crimper instruction manual for installation and operation information.

SCOPE

Products: 11mm SideWize R/A WTB Terminal for 4/0 AWG Wire.

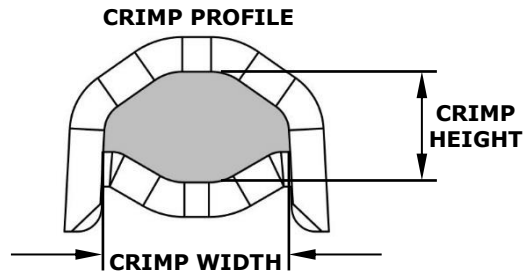| Terminal Series No.	Terminal Assembly Order No.	Wire Size		Strip Length	
		AWG	mm²	mm	In.
218231	218231-1000	4/0	—	20	.787
	218231-1001				

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 newtons and pounds, and it indicates the minimum acceptable force to break or separate the terminal from the conductor.

Wire Size (AWG)	Minimum Pull (UL486)	
	N	Lb.
4/0	3,892	450

CRIMP MEASUREMENT

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

Terminal Series No.	Wire Size	Wire Size	Crimp Height (Ref)		Crimp Width (Ref)	
	AWG	mm²	mm	In.	mm	In.
218231	4/0	—	10.67-10.83	.420-.426	19.50-19.70	.767-.776

CRIMP PROFILE

CRIMP HEIGHT

CRIMP WIDTH

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

PARTS LIST

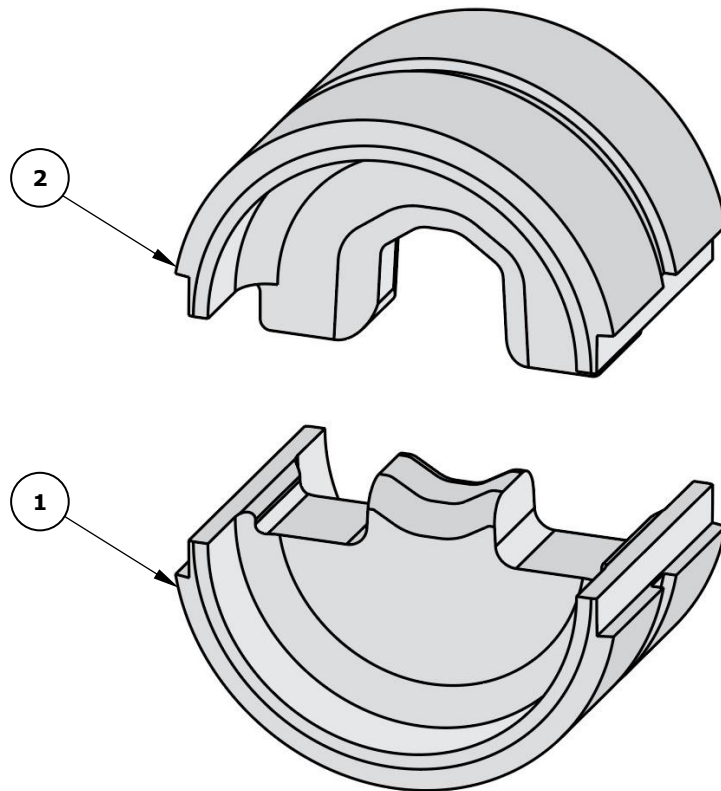| Item Number	Order Number	Description	Quantity
	219382-0120	**Crimp Tooling Kit – 4/0 AWG**	**REF**
1	219382-0121	Conductor Anvil	1
2	219382-0122	Conductor Punch	1

Figure 1

Application Tooling Support

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E-Mail: toolingsupport@molex.com
Website: www.molex.com/applicationtooling