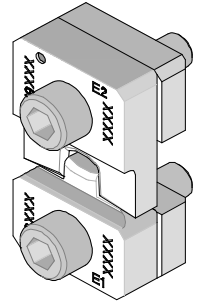




Crimp Tooling Specification Sheet
ATP Tooling Kit No. 19027-0305
Engineering No. 19027-0305



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: Versakrimp® Ring Tongue Terminals 6 AWG.

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

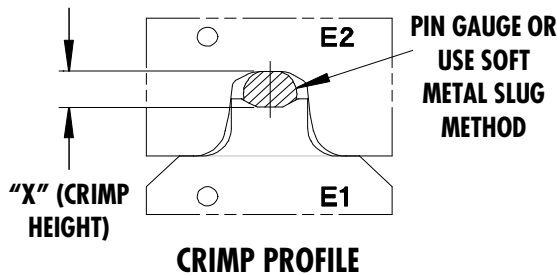
Testing

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
Blue	6	100

*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	
6	16.0	.224	5.69	.221	5.61	.231	5.86	N/A

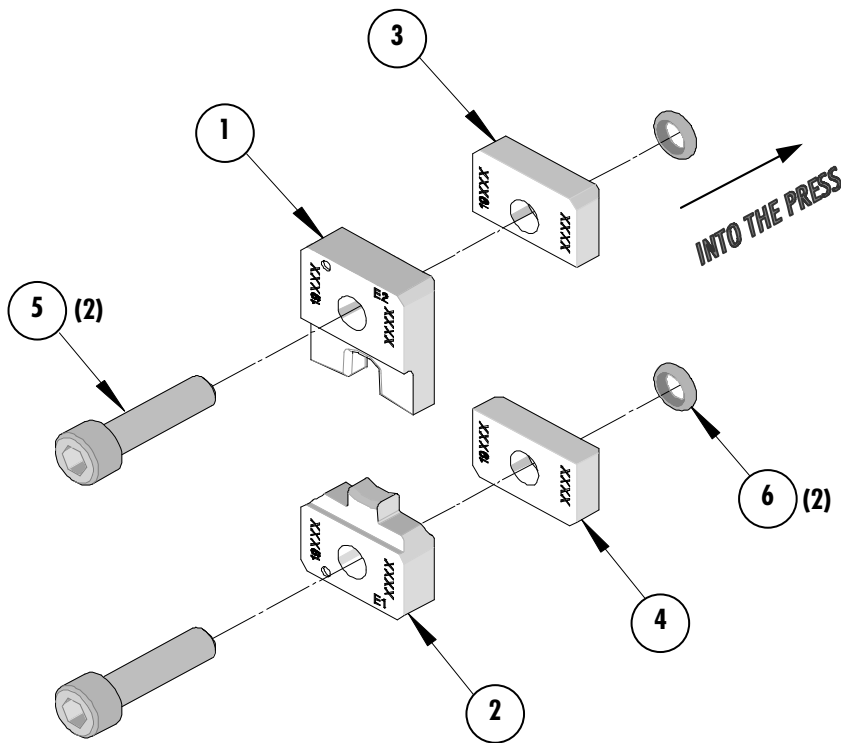
The following is a Partial List of the Product Part Numbers and their specifications that this tooling is designed to crimp. We will be adding to this list and an up to date copy is available on www.molex.com.

Wire Size: 6 AWG 16.0mm ²					
Terminal No.	Terminal Eng No. (REF)	Wire Strip Length		Insul. Dia. Max.	
		In	mm	In	mm
19193-0228	E-358-12T	.468	11.90	N/A	N/A
19193-0231	E-358-38T	.468	11.90	N/A	N/A

Parts List

Item	Order No.	Engineering No.	Description	Qty
	19027-0305	19027-0305	ATP Tooling Kit	REF
1	19027-0147	ATP-E-152-E2	Conductor Punch	1
2	19027-0146	ATP-E-152-E1	Conductor Anvil	1
3	19027-0202	DS-300-UPPER	Die Spacer - Upper (.300")	1
4	19027-0203	DS-300-LOWER	Die Spacer - Lower (.300")	1
5	N/A	N/A	#10-32 by 1" Long SHCS	2**
6	N/A	N/A	O-ring 1/16 W by 9/32" OD	2**

** 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
 eurinfo@molex.com

Corporate Headquarters
 2222 Wellington Ct.
 Lisle, IL 60532 U.S.A.
 630-969-4550
 Fax: 630-969-1352

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