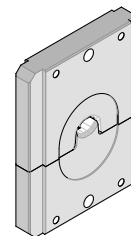


Modular Crimp Tooling Kit



Application Tooling Specification Sheet



Order No. 64003-7670

SCOPE

Tooling: The Square “DIN” style die sets are used with two machines and each machine requires an adapter for the square “DIN” dies. The Molex UP60, order number 63801-8900 will process the square “DIN” style die sets with the 63801-8901 adapter. The Molex 12 ton battery crimp tool, order number 63816-1000 will process the square “DIN” style die sets with the 63816-1100. Refer to the appropriate crimper instruction manual for installation and operation information.

Products: BCL and VersaKrimp™ Un-insulated Ring Tongue Terminals and Splices 8 AWG. Refer to the Product part number charts on this sheet for terminals with the barrel and tongue styles listed above.

TESTING

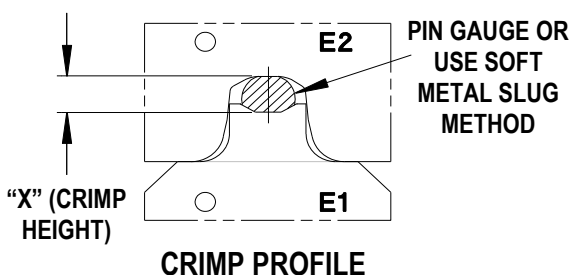
The tensile test or pull test is a means of evaluating the mechanical properties of the crimped connections. The following charts show the UL specifications for various wire sizes. The tensile strength is shown in pounds and indicates the minimum acceptable force to break or separate the terminal from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

Color Code	Wire Size (AWG)	*UL - 486 A	*UL - 486 C	**MIL-T-7928
Red	8	90	45	225

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

*UL - 486 C – Butt Splices, Parallel Splices, and Closed end Connectors

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



Use gauge pins or soft metal slug (solder) method to measure the “X” dimension. Verify the 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	
8	-	.155	3.94	.149	3.78	.161	4.09	Ⓢ

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: 8 AWG			
Terminal No.	Terminal Eng No. (REF)	Wire Strip Length	
		In	mm
19193-0143	D-350-06	.437	11.11
19193-0144	D-350-06R90	.437	11.11
19193-0146	D-350-08	.437	11.11
19193-0147	D-350-08R90	.437	11.11
19193-0149	D-350-10	.437	11.11
19193-0154	D-350-14R90	.437	11.11
19193-0157	D-350-56	.437	11.11
19193-0159	D-351-10	.437	11.11
19193-0160	D-351-10-N	.437	11.11
19193-0163	D-351-14	.437	11.11
19193-0164	D-351-14-N	.437	11.11
19193-0169	D-351-38-N	.437	11.11
19193-0173	D-351-56-N	.437	11.11
19193-0175	D-351-76	.437	11.11
19193-0176	D-351-76-N	.437	11.11
19193-0178	D-352-10	.437	11.11
19193-0182	D-352-14	.437	11.11
19193-0184	D-352-38	.437	11.11
19193-0185	D-352-56	.437	11.11
19193-0186	D-352-58	.437	11.11
19193-0187	D-352-76	.437	11.11
19193-0190	D-353-12	.437	11.11
19193-0191	D-353-14	.437	11.11
19193-0192	D-353-34	.437	11.11
19193-0193	D-353-38	.437	11.11
19193-0194	D-353-56	.437	11.11
19193-0195	D-353-58	.437	11.11
19193-0196	D-353-76	.437	11.11
19193-0198	D-356-06	.437	11.11
19193-0204	D-356-14	.437	11.11
19193-0615	D-350-10T45	.437	11.11
19193-0829	D-350-10R90	.437	11.11
19205-0004	D-355	.312	7.94
19215-0034	D-354	.375	9.53

Wire Size: 8 AWG			
Terminal No.	Terminal Eng No. (REF)	Wire Strip Length	
		In	mm
19215-0037	DC-354	.375	9.53
19215-0059	BCL-8	.437	11.11
19221-0223	BCL-810-PL	.437	11.11
19221-0224	BCL-814-PL	.437	11.11
19221-0225	BCL-8516-PL	.437	11.11
19221-0226	BCL-838-PL	.437	11.11
19221-0408	BCL-810	.437	11.11
19221-0409	BCL-814	.437	11.11
19221-0410	BCL-838-WP	.437	11.11
19221-0411	BCL-8516	.437	11.11
19221-0414	BCL-812-PL	.437	11.11
19221-0415	BCL-812-XWP	.437	11.11
19221-0481	BCL-838-XWP	.437	11.11
19221-0482	BCL-8516-WP	.437	11.11
19221-0483	BCL-8516-WP-PL	.437	11.11
19221-0484	BCL-838-XWP-PL	.437	11.11
19221-0562	BCL-814-WP	.437	11.11
19221-0563	BCL-814-WP-PL	.437	11.11

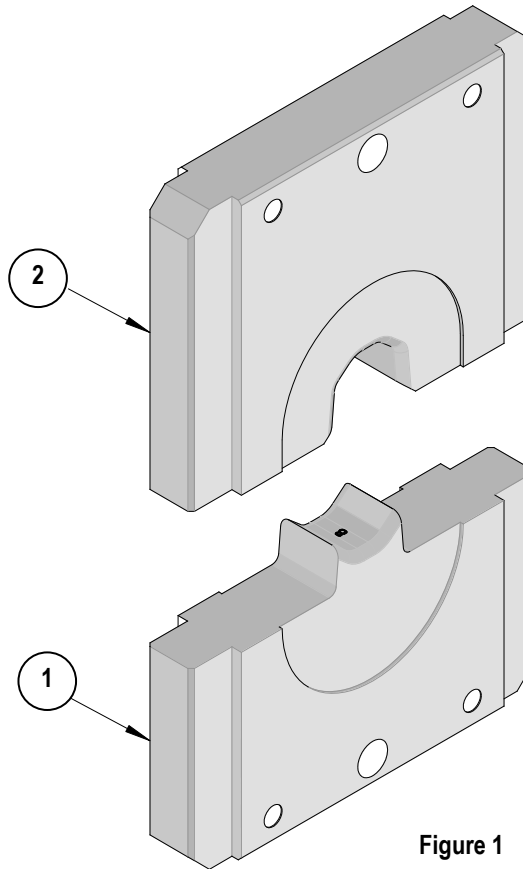
MILITARY Wire Size: 8 AWG			
Terminal No.	Terminal Eng No. (REF)	Wire Strip Length	
		In	mm
19193-0152	D-350-14	.437	11.11
19193-0167	D-351-38	.437	11.11
19193-0171	D-351-56	.437	11.11
19193-0179	D-352-12	.437	11.11
19193-0200	D-356-08	.437	11.11
19193-0202	D-356-10	.437	11.11

CAUTION: Install only Molex terminals listed above with this kit. Do not crimp hardened objects as damage can occur to the tool or die.

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

Crimp Tooling Kit Parts List

Item Number	Order Number	Description	Quantity
	64003-7670	Crimp Tooling Kit – 8 AWG Un-insulated	REF
1	64003-7601	Anvil	1
2	64003-7602	Punch	1



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