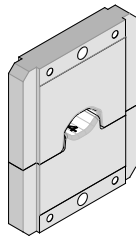
Modular Crimp Tooling Kit	molex **Application Tooling Specification Sheet**	 **Order No. 64003-7770**

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.

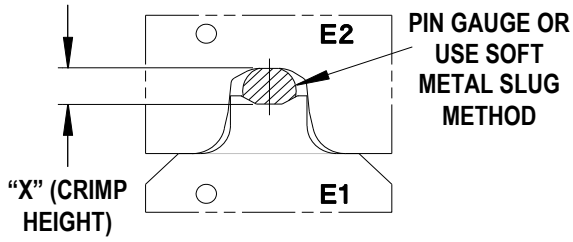
Products: BCL and VersaKrimp™ Un-insulated Ring Tongue Terminals and Splices 6 AWG. Refer to the Product part number charts on this sheet for terminals with the barrel and tongue styles listed above.

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.

Wire Size (AWG)	*UL - 486 A	*UL - 486 C	**MIL-T-7928
6	100	50	300

*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



CRIMP PROFILE

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	mm²	In	mm	In	mm	In	mm	
6	-	.190	4.83	.184	4.67	.196	4.98	6

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			
Terminal No.	Terminal Eng No. (REF)	Wire Strip Length	
		In	mm
19193-0206	E-357-08	.469	11.91
19193-0209	E-357-10	.469	11.91
19193-0210	E-357-10R90	.469	11.91
19193-0212	E-357-14	.469	11.91
19193-0214	E-357-14R90	.469	11.91
19193-0221	E-357-56R90	.469	11.91
19193-0223	E-357-76	.469	11.91
19193-0225	E-358-10	.469	11.91
19193-0229	E-358-14	.469	11.91
19193-0230	E-358-38	.469	11.91
19193-0232	E-358-56	.469	11.91
19193-0233	E-358-58	.469	11.91
19193-0234	E-358-76	.469	11.91
19193-0236	E-359-12	.469	11.91
19193-0237	E-359-14	.469	11.91
19193-0238	E-359-34	.469	11.91
19193-0239	E-359-38	.469	11.91
19193-0240	E-359-56	.469	11.91
19193-0241	E-359-58	.469	11.91
19193-0242	E-359-76	.469	11.91
19193-0243	E-360-08	.469	11.91
19193-0246	E-360-10R90	.469	11.91
19193-0249	E-360-14R90	.469	11.91
19193-0251	E-360-56	.469	11.91
19193-0252	E-360-56R90	.469	11.91
19193-0529	E-357-38R90	.469	11.91
19193-0652	E-360-10 Green	.469	11.91
19205-0006	E-361	.375	9.53
19215-0040	E-362	.438	11.13
19215-0042	ED-362	.438	11.13
19215-0043	ED-362-UP	.438	11.13
19215-0060	BCL-6	.469	11.91

Wire Size: 6 AWG			
Terminal No.	Terminal Eng No. (REF)	Wire Strip Length	
		In	mm
19221-0227	BCL-614-WP-PL	.469	11.91
19221-0228	BCL-6516-WP-PL	.469	11.91
19221-0229	BCL-638-PL	.469	11.91
19221-0384	BCL-638-WP	.469	11.91
19221-0406	BCL-614-WP	.469	11.91
19221-0407	BCL-6516-WP	.469	11.91
19221-0416	BCL-612-XWP-PL	.469	11.91
19221-0417	BCL-612-XWP	.469	11.91
19221-0424	BCL-610-PL	.469	11.91
19221-0425	BCL-610	.469	11.91
19221-0492	BCL-6516-PL	.469	11.91
19221-0493	BCL-6516	.469	11.91
19221-0494	BCL-614	.469	11.91
19221-0495	BCL-614-PL	.469	11.91
19221-0568	BCL-638-XWP-PL	.469	11.91
19221-0569	BCL-638-XWP	.469	11.91

MILITARY Wire Size: 6 AWG			
Terminal No.	Terminal Eng No. (REF)	Wire Strip Length	
		In	mm
19193-0216	E-357-38	.469	11.91
19193-0219	E-357-56	.469	11.91
19193-0226	E-358-12	.469	11.91
19193-0245	E-360-10	.469	11.91
19193-0248	E-360-14	.469	11.91

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
	64003-7770	**Crimp Tooling Kit – 6 AWG Un-insulated**	**REF**
1	64003-7701	Anvil	1
2	64003-7702	Punch	1

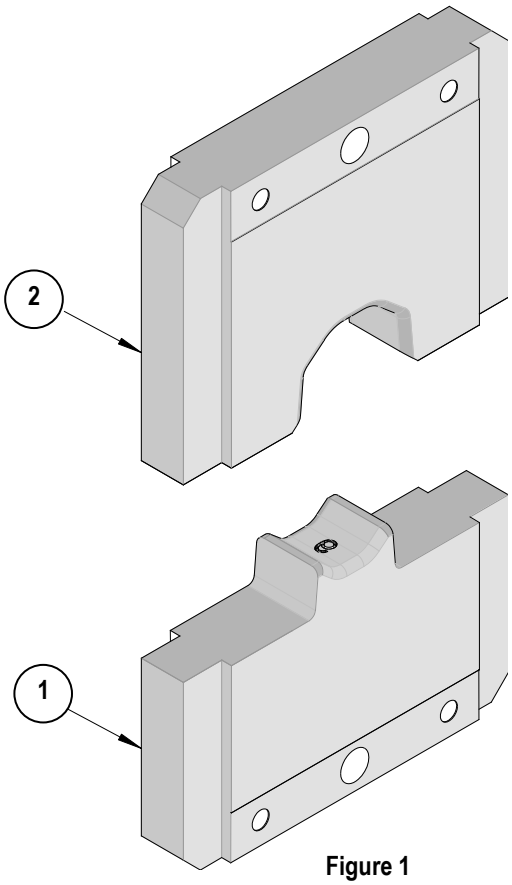


Figure 1

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