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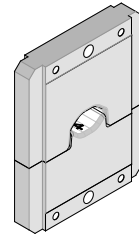
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**Modular Crimp Tooling Kit**

**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**

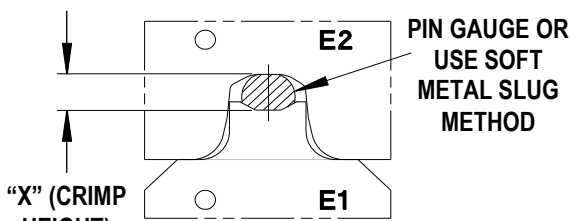
The tensile test or pull test is a means of evaluating the mechanical properties of the crimped connections. The following charts show the UL specifications for various wire sizes. The tensile strength is shown in pounds and indicates the minimum acceptable force to break or separate the terminal from 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        | mm <sup>2</sup> | 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](http://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<br>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   |
|-------------|-------------------|---|------------|
|             | <b>64003-7770</b> | <b>Crimp Tooling Kit – 6 AWG Un-insulated</b> | <b>REF</b> |
| 1           | 64003-7701        | Anvil   | 1          |
| 2           | 64003-7702        | Punch   | 1          |

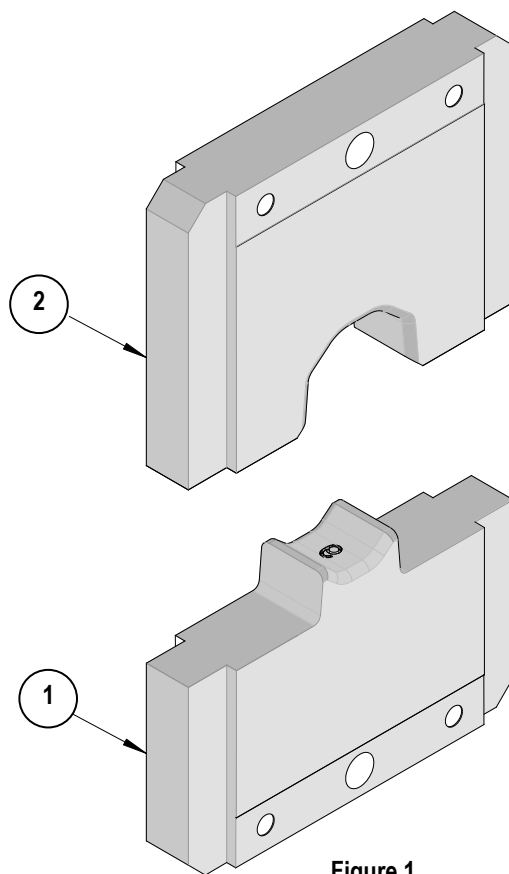


Figure 1

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