Chipsmall Limited consists of a professional team with an average of over 10 year of expertise in the distribution of electronic components. Based in Hongkong, we have already established firm and mutual-benefit business relationships with customers from,Europe,America and south Asia,supplying obsolete and hard-to-find components to meet their specific needs.

With the principle of "Quality Parts,Customers Priority,Honest Operation,and Considerate Service",our business mainly focus on the distribution of electronic components. Line cards we deal with include Microchip,ALPS,ROHM,Xilinx,Pulse,ON,Everlight and Freescale. Main products comprise IC,Modules,Potentiometer,IC Socket,Relay,Connector.Our parts cover such applications as commercial,industrial, and automotives areas.

We are looking forward to setting up business relationship with you and hope to provide you with the best service and solution. Let us make a better world for our industry!

Contact us

**Modular Crimp
Tooling Kit
Compression Lug
(Tool code 14)**

molex®

**Application Tooling
Specification Sheet**
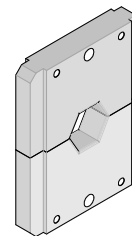
Order No. 64008-0670

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 adapter. Refer to the appropriate crimper instruction manual for installation and operation information.

Products: Metric Compression Lug Terminals and Splices 50mm² (1 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 chart shows the UL specifications for the equivalent AWG wire size. The tensile strength is shown in Newtons and (pounds) and indicates the minimum acceptable force to break or separate the terminal from the conductor.

Wire Size (mm²)	Wire Size (AWG)	Tensile (UL - 486 A)
50	1	890 (200)

*UL - 486 A – Lugs (to AWG wire) (Copper Conductors only)

"X" (CRIMP HEIGHT)

PIN GAUGE OR USE SOFT METAL SLUG METHOD
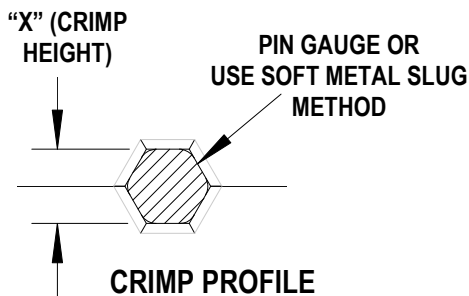
Use gauge pins or soft metal slug (solder) method to measure the "X" dimension. Verify the tooling crimp height calibration by referring to the Go/No Go dimensions shown in the chart below.

CRIMP PROFILE

Molex does not sell gauge pins. Contact your local industrial supplier.

Tool Code	Wire Range		"X" Dimension Conductor Crimp					
			Mean		Go		No Go	
	mm²	AWG	In	mm	In	mm	In	mm
14	50	1	.433	11.00	.429	10.90	.437	11.10

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.
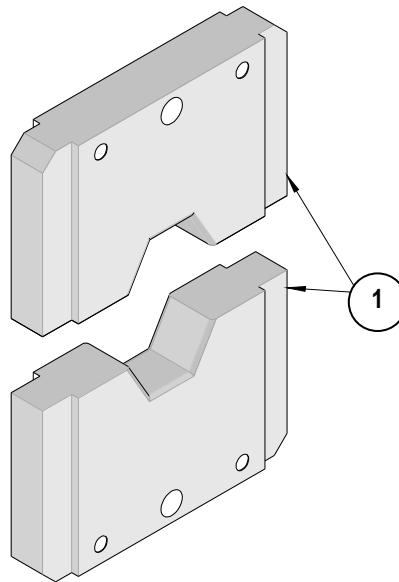
Wire Size:50mm² (1AWG)			
Terminal No.	Terminal Eng No. (REF)	Wire Strip Length (Minimum)	
		In	mm
19322-0015	BCLM-8-50-PL	1.10	28.0
19322-0048	BCLM-8-50-PLS	1.10	28.0
19322-0016	BCLM-10-50-PL	1.10	28.0
19322-0049	BCLM-10-50-PLS	1.10	28.0
19322-0017	BCLM-12-50-PL	1.10	28.0
19322-0050	BCLM-12-50-PLS	1.10	28.0
19322-0018	BCLM-16-50-PL	1.10	28.0
19322-0051	BCLM-16-50-PLS	1.10	28.0

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.

PARTS LIST

Item Number	Order Number	Description	Quantity
	64008-0670	**Crimp Tooling Kit – 50mm² Un-insulated**	**REF**
1	64008-0601	Hex Crimp Die (matched pair)	2

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