

Modular Crimp Tooling Kit

Application Tooling Specification Sheet

Order No. 64001-7970

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: InsulKrimp™ and NylaKrimp™ Ring Tongue Terminals and Splices 2 AWG. Refer to the Product part number charts on this sheet for terminals with the barrel and tongue styles listed above.

TESTING

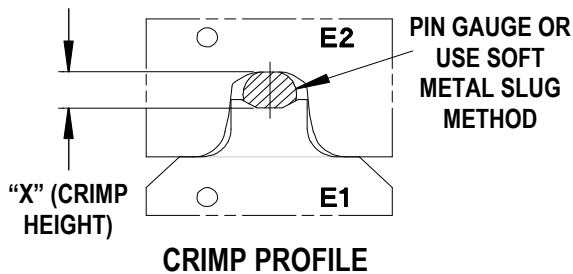
The tensile test or pull test is a means of evaluating the mechanical properties of the crimped connections. The following charts show the UL specifications for various wire sizes. The tensile strength is shown in pounds and indicates the minimum acceptable force to break or separate the terminal from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

Color Code	Wire Size (AWG)	*UL - 486 A	*UL - 486 C	**MIL-T-7928
Red	2	180	---	550

*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	
2	26.6-42.4	.336	8.53	.330	8.38	.342	8.69	②

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: 2 AWG 26.6-42.4mm ² CMA 52,600-83,700					
Terminal No.	Terminal Eng No. (REF)	Wire Strip Length		Insulation Diameter Maximum	
		In	mm	In	mm
19063-0094	G-774-14	.578	14.68	.512	13.00
19063-0095	G-774-38	.578	14.68	.512	13.00
19063-0096	G-774-56	.578	14.68	.512	13.00
19063-0097	G-774-58	.578	14.68	.512	13.00
19063-0098	G-774-76	.578	14.68	.512	13.00
19063-0099	G-775-12	.578	14.68	.512	13.00
19063-0102	G-775-56	.578	14.68	.512	13.00
19063-0103	G-775-58	.578	14.68	.512	13.00
19063-0104	G-775-76	.578	14.68	.512	13.00
19063-0105	G-776-12	.578	14.68	.512	13.00
19063-0106	G-776-14	.578	14.68	.512	13.00
19063-0107	G-776-38	.578	14.68	.512	13.00
19063-0108	G-776-56	.578	14.68	.512	13.00
19063-0109	G-776-58	.578	14.68	.512	13.00
19063-0110	G-776-76	.578	14.68	.512	13.00
19063-0111	G-777-12	.578	14.68	.512	13.00
19063-0112	G-777-14	.578	14.68	.512	13.00
19063-0113	G-777-34	.578	14.68	.512	13.00
19063-0114	G-777-38	.578	14.68	.512	13.00
19063-0115	G-777-56	.578	14.68	.512	13.00
19063-0116	G-777-58	.578	14.68	.512	13.00
19063-0117	G-777-76	.578	14.68	.512	13.00
19063-0170	G-774-76R90	.578	14.68	.605	15.37
19067-0090	G-974-12	.578	14.68	.605	15.37
19067-0091	G-974-14	.578	14.68	.605	15.37
19067-0092	G-974-38	.578	14.68	.605	15.37
19067-0093	G-974-56	.578	14.68	.605	15.37
19067-0094	G-974-76	.578	14.68	.605	15.37
19067-0095	G-975-10	.578	14.68	.600	15.24
19067-0096	G-975-14	.578	14.68	.600	15.24
19067-0097	G-975-38	.578	14.68	.600	15.24
19067-0098	G-975-56	.578	14.68	.600	15.24
19067-0130	G-974-58	.578	14.68	.605	15.37
19067-0169	G-974-14R90	.578	14.68	.605	15.37
19067-0170	G-974-56R90	.578	14.68	.605	15.37
19067-0171	G-974-38R90	.578	14.68	.605	15.37
19067-0172	G-974-12R90	.578	14.68	.605	15.37
19067-0173	G-974-58R90	.578	14.68	.605	15.37
19067-0174	G-974-34R90	.578	14.68	.605	15.37
19067-0175	G-974-78R90	.578	14.68	.605	15.37
19067-0176	G-974-34	.578	14.68	.605	15.37
19067-0177	G-974-78	.578	14.68	.605	15.37
19067-0178	G-974-76R90	.578	14.68	.605	15.37
19067-0312	G-975-14R90	.578	14.68	.600	15.24
19071-0272	G-674-12X	.578	14.68	.650	16.51
19071-0273	G-674-14X	.578	14.68	.650	16.51
19071-0274	G-674-14XR90	.578	14.68	.650	16.51

Wire Size: 2 AWG 26.6-42.4mm ² CMA 52,600-83,700					
Terminal No.	Terminal Eng No. (REF)	Wire Strip Length		Insulation Diameter Maximum	
		In	mm	In	mm
19071-0275	G-674-38X	.578	14.68	.650	16.51
19071-0276	G-674-56X	.578	14.68	.650	16.51
19071-0277	G-674-58X	.578	14.68	.650	16.51
19071-0278	G-674-76X	.578	14.68	.650	16.51
19071-0279	G-675-10X	.578	14.68	.650	16.51
19071-0280	G-675-10XR90	.578	14.68	.650	16.51
19071-0281	G-675-14X	.578	14.68	.650	16.51
19071-0282	G-675-14XR90	.578	14.68	.650	16.51
19071-0283	G-675-38X	.578	14.68	.650	16.51
19071-0284	G-675-38XR90	.578	14.68	.650	16.51
19071-0285	G-675-56X	.578	14.68	.650	16.51
19071-0286	G-675-56XR90	.578	14.68	.650	16.51
19071-0287	G-675-76X	.578	14.68	.650	16.51
19071-0288	G-675-76XR90	.578	14.68	.650	16.51
19071-0289	G-676-12X	.578	14.68	.650	16.51
19071-0290	G-676-14X	.578	14.68	.650	16.51
19071-0291	G-676-38X	.578	14.68	.650	16.51
19071-0292	G-676-56X	.578	14.68	.650	16.51
19071-0293	G-676-58X	.578	14.68	.650	16.51
19071-0294	G-676-76X	.578	14.68	.650	16.51
19071-0295	G-677-12X	.578	14.68	.650	16.51
19071-0296	G-677-14X	.578	14.68	.650	16.51
19071-0297	G-677-34X	.578	14.68	.650	16.51
19071-0298	G-677-38X	.578	14.68	.650	16.51
19071-0299	G-677-56X	.578	14.68	.650	16.51
19071-0300	G-677-58X	.578	14.68	.650	16.51
19071-0301	G-677-76X	.578	14.68	.650	16.51
19154-0049	G-672X	.687	17.45	.650	16.51
19202-0057	G-772	.687	17.45	.509	12.93

MILITARY					
Wire Size: 2 AWG 26.6-42.4mm ² CMA 52,600-83,700					
Terminal No.	Terminal Eng No. (REF)	Wire Strip Length		Insulation Diameter Maximum	
		In	mm	In	mm
19063-0093	G-774-12	.578	14.68	.512	13.00
19063-0100	G-775-14	.578	14.68	.512	13.00
19063-0101	G-775-38	.578	14.68	.512	13.00

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

Crimp Tooling Kit Parts List

Item Number	Order Number	Description	Quantity
	64001-7970	Crimp Tooling Kit – 2 AWG Insulated	REF
1	64001-7901	Anvil	1
2	64001-7902	Punch	1

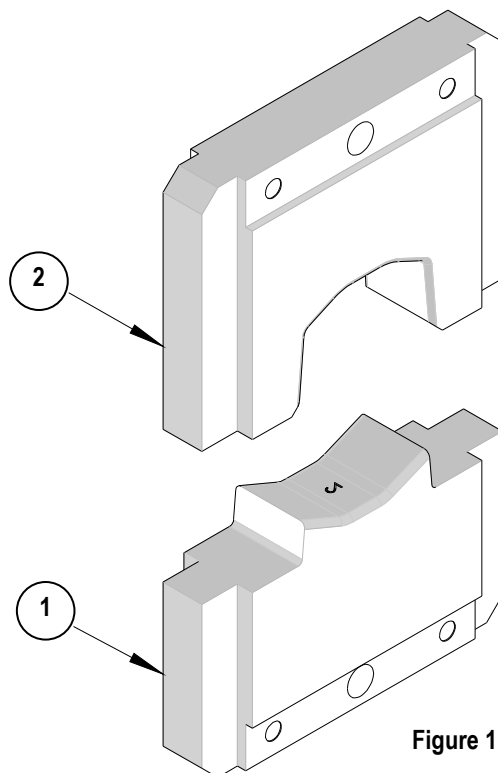


Figure 1

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