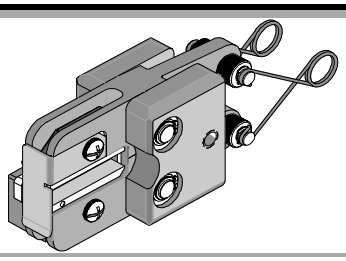
Air Powered Crimp Tool Head Krimptite™

molex

Application Tooling Specification Sheet



Order No. 64007-0400
Engineering No. AT1753

FEATURES

- Quick-change tool head for the 19279-0001 (AT-200)
- Tooling kit is interchangeable with other kits in the 64001,64003, 64005, and 64007 Series
- A precision user-friendly terminal locator wire stop holds terminals in the proper crimping position for each of the three nests
- Pneumatic powered crimp tools help reduce fatigue and discomfort from repetitive manual crimping

SCOPE

Products: Krimptite™ Terminals and Quick Disconnects, 24–26 AWG. This tool head is intended for use in the 19279-0001 (AT-200) either hand held or with optional bench adapter 19078-0307 (ATBA) and foot switch.

Testing

Mechanical

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 - 310
26	3	3
24	5	5

*UL - 486 A - Terminals (Copper conductors only)
*UL – 310 Quick Disconnects, Flags, Couplers

The following is a partial list of the product part numbers and their specifications that this tool is designed to run. We will be adding to this list and an up to date copy is available on www.molex.com.

Wire Size: 24 – 26 AWG 0.20 – 0.12 mm²			
Terminal No.	Terminal Eng. No. (REF)	Wire Strip Length	
		In.	mm
19016-0075	M-1130	0.156	3.969
19016-0098	M-1136	0.156	3.969
190160-099	M-1136-032	0.156	3.969
19016-0112	M-1133	0.156	3.969
19069-0352	M-1113-02	0.156	3.969
19069-0354	M-1113-04	0.156	3.969
19069-0356	M-1113-06	0.156	3.969
19069-0358	M-1114-02	0.156	3.969
19069-0361	M-1118-06	0.156	3.969
19069-0363	M-1118-08	0.156	3.969

Wire Size: 24 – 26 AWG 0.20 – 0.12 mm²			
Terminal No.	Terminal Eng. No. (REF)	Wire Strip Length	
		In.	mm
19069-0365	M-1118-10	0.156	3.969
19069-0367	M-1120-04	0.156	3.969
19069-0369	M-1122-00	0.156	3.969
19069-0370	M-1122-02	0.156	3.969
19069-0441	M-1120-06	0.156	3.969
19087-0169	M-1115-02	0.156	3.969
19087-0171	M-1119-02	0.156	3.969
19087-0173	M-1119-06	0.156	3.969
19087-0175	M-1119-08	0.156	3.969
19087-0177	M-1119-10	0.156	3.969

Wire Size: 24 – 26 AWG 0.20 – 0.12 mm²			
Terminal No.	Terminal Eng. No. (REF)	Wire Strip Length	
		In.	mm
19118-0092	M-1117-02	0.156	3.969
19141-0096	M-1116-02	0.156	3.969
19141-0098	M-1121-04	0.156	3.969

Wire Size: 24 – 26 AWG 0.20 – 0.12 mm²			
Terminal No.	Terminal Eng. No. (REF)	Wire Strip Length	
		In.	mm
19141-0101	M-1123-00	0.156	3.969
19141-0109	M-1116-04	0.156	3.969
19141-0113	M-1116-06	0.156	3.969

Operation

Refer to the instruction manual for the 19279-0001 (AT-200) for mounting this crimp tool head.

Crimping Terminals

1 Adjust the locator up or down until the terminal being run sits flat and straight in the tool.

2 Insert the wire into the terminal. Push up on the locator blade and insert the terminal and wire into the nest with the barrel up and against the locator bar. For Quick Disconnects, center the terminal barrel in the lower tooling visually, the locator will hold it but does not position Quick Disconnects Release the locator blade to hold the terminal in position. See Figure 1. Locator may be raised or lowered so terminal sits flat and straight in tool. The locator must be removed to run splices.

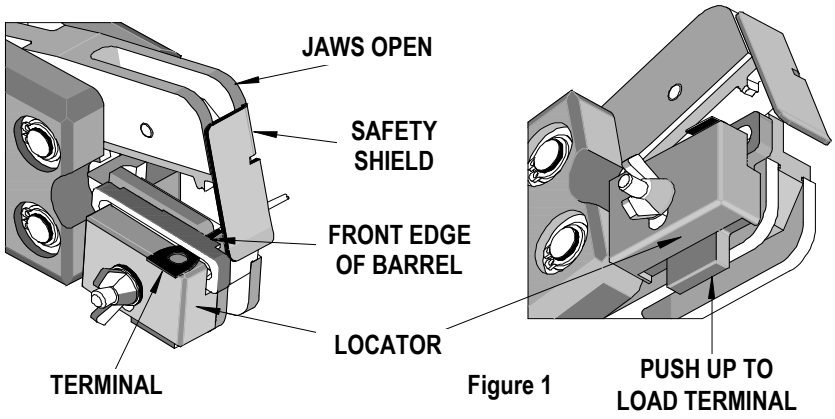


Figure 1

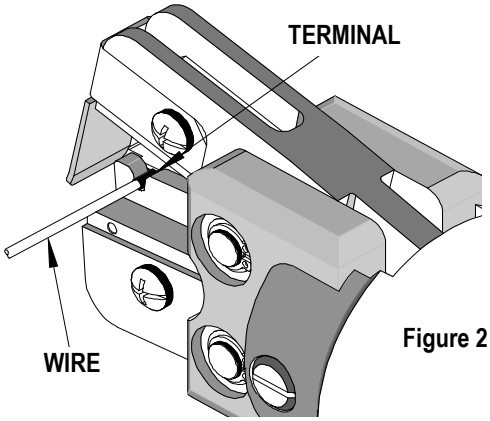


Figure 2

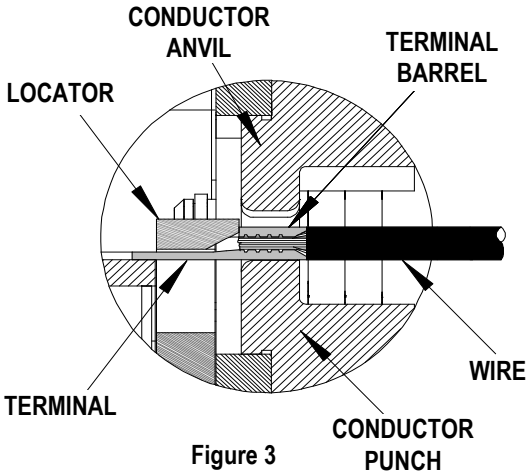


Figure 3

Caution: Never operate this tool without the supplied safety shield in place. Never place fingers in the tool nests.

3 Push on the wire to assure it is fully seated in the terminal. See Figure 2 and 3. The wires end should butt against the wire stop position of the locator. Cycle the tool.

4 Lift the locator blade or wire stop and remove the crimped terminal. Inspect for proper crimp location. Locator is adjustable up and down to keep terminals straight after crimping.

Note: Whenever crimping without the locator, make sure the seam of the terminal is oriented up or down in the tool if using unbrazed product, as this will provide higher pull force values.

Maintenance

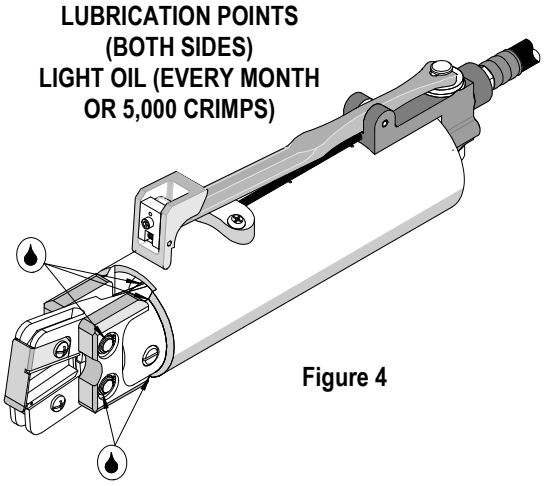


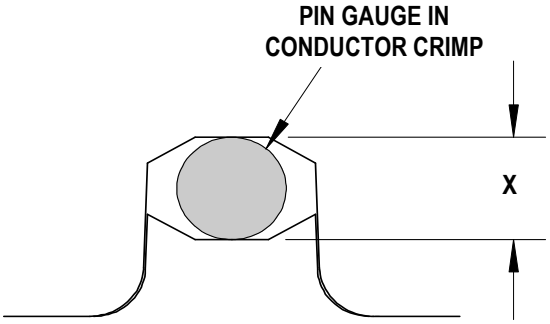
Figure 4

It is recommended that each operator of the tool be made aware of, and responsible for, the following maintenance steps:

1 Remove dust, moisture and other contaminants with a clean brush, or soft, lint-free cloth.
2 Do not use any abrasive materials that could damage the tool.
3 Make certain all pins, pivot points and bearing surfaces are protected with a thin coat of high quality machine oil. Do not oil excessively. This tool was engineered for durability, but like any fine piece of equipment it needs cleaning and lubrication for a maximum service life of trouble-free crimping. Use a light oil such as 30 weight automotive oil at the oil points shown in Figure 4, every 5,000 crimps or monthly will significantly enhance the tool life and ensure a stable calibration.
4 When tool is not in use store the tool in a clean, dry area.

Tool Calibration

A Certificate of Calibration (see last page) was supplied with the tool. To recalibrate this tool, measurements should be taken from each conductor nest and compared to this chart. The tool should be lubricated prior to recalibration to ensure consistent measurements.



" Confining " Crimp

Nest Color Code	WireRange		"X" Dimension Conductor Crimp		
	AWG	mm²	Mean	Go	No Go
Yellow	24 - 26	0.12 - 0.20	.042	.039	.050

Warranty

This tool is for electrical terminal crimping purposes only. This tool is made of the best quality materials. All vital components are long life tested. All tools are warranted to be free of manufacturing defects for a period of 30 days. Should such a defect occur, we would repair or exchange the tool free of charge. This repair or exchange will not be applicable to altered, misused or damaged tools.

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

PARTS LIST

Item	Order No	Description	Quantity
	64007-0400	**Crimp Tool Head**	**Figure 5**
1	64005-0000	Basic Air Tool Head	1
2	64007-0375	Locator Assembly	1
3	64003-0470	Tooling Kit	1
Tooling Kit Only			
4	64003-0402	Conductor Anvil	1
5	64003-0401	Conductor Punch	1

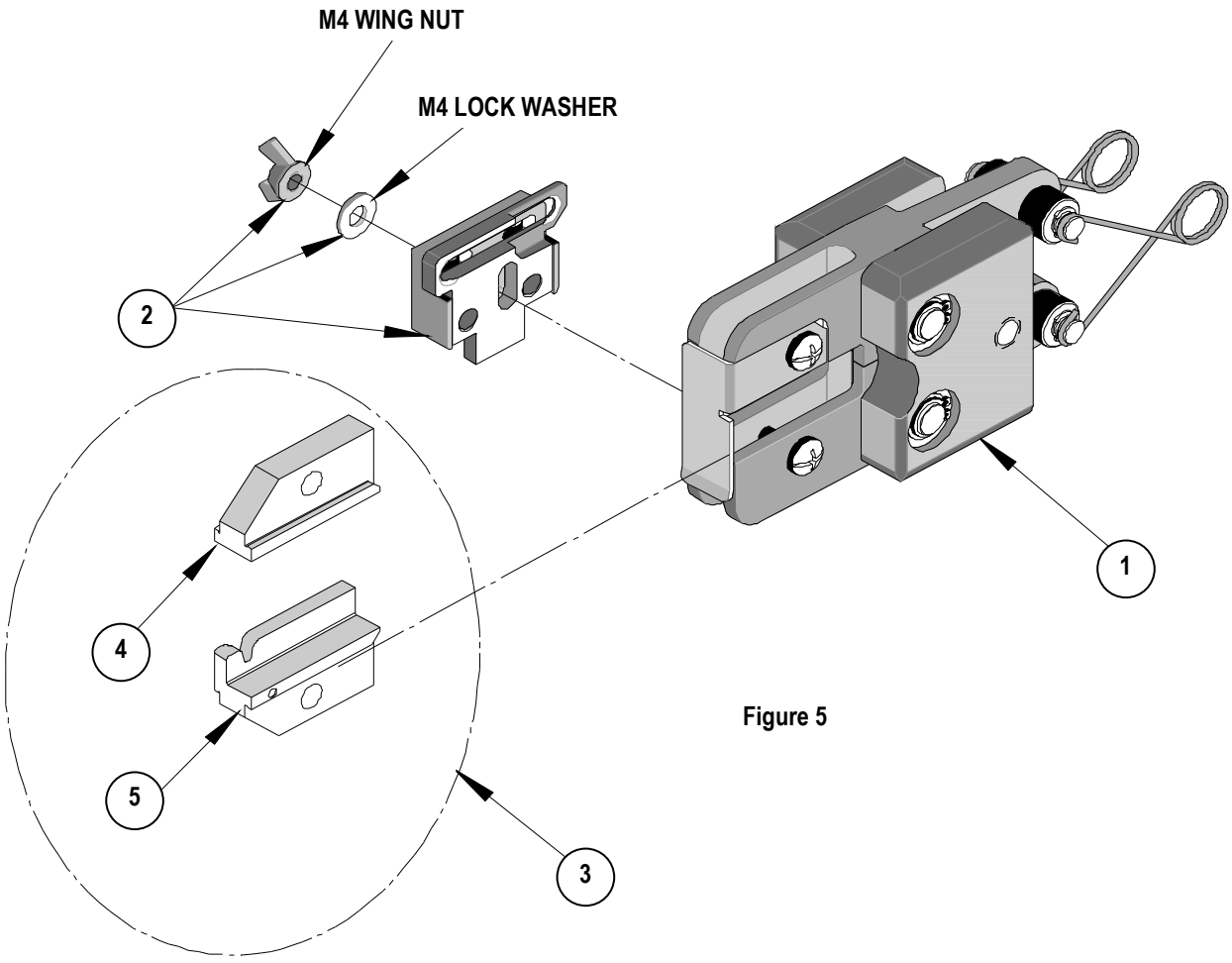


Figure 5

Parts List (Continued)

Item	Order No.	Description	Quantity
	64005-0000	**Basic Air Tool Head**	**Figure 6**
1	64005-0103	Nose Guard	1
2	64000-0077	Repair Kit (Springs, Rods Pivots, Rings, and Washers)	1
3	N/A	M4 by 12 Long Freedrive Pan Head Screw	1**
4	N/A	M4 by 30 Long Freedrive Pan Head Screw	1**
5	N/A	3/16" by 3/8" Long Dowel Pin	1**
** Available from an Industrial supply company such as MSC (1-800-645-7270).			

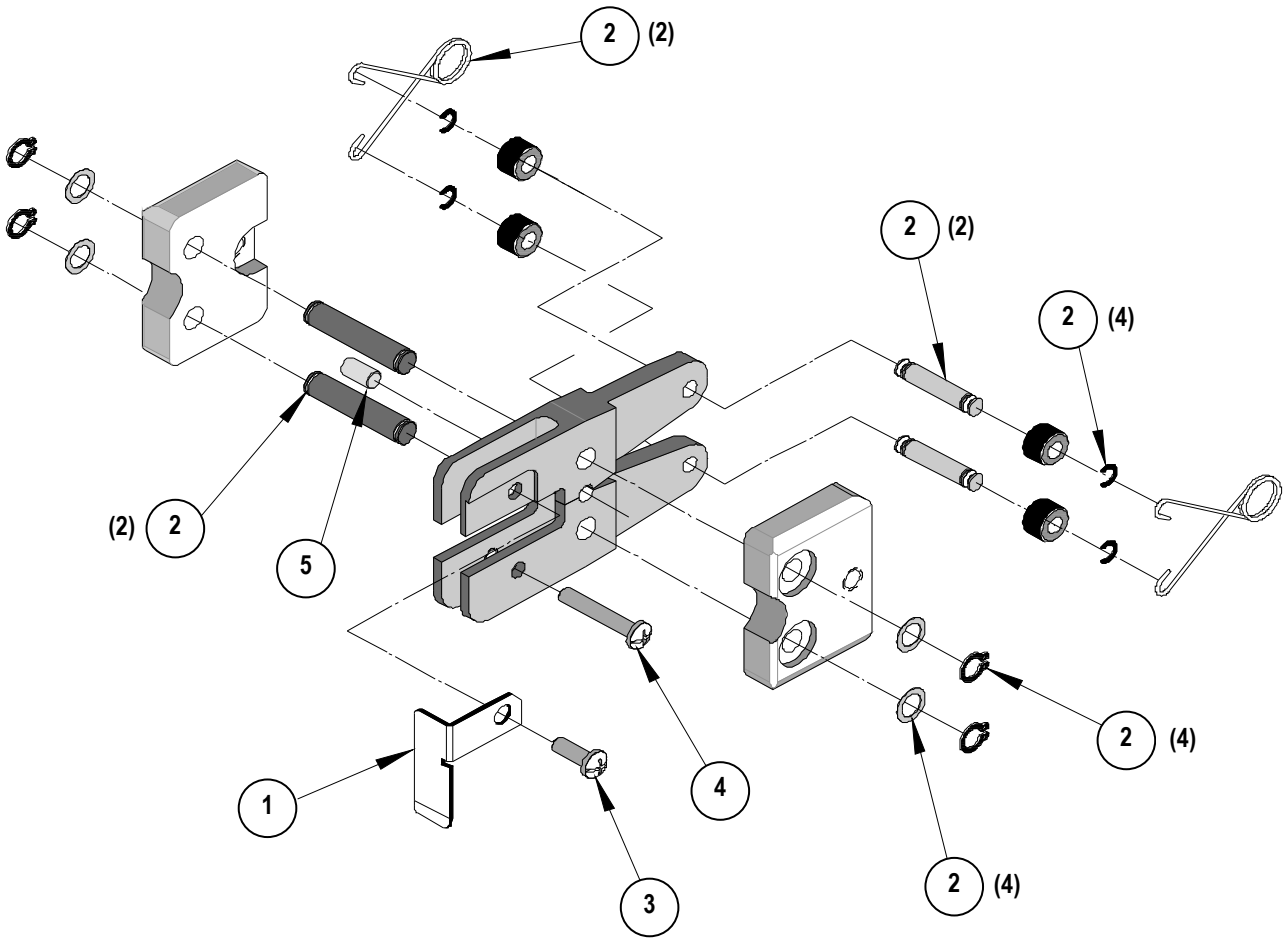
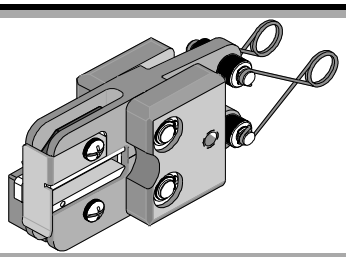


Figure 6

Air Powered Crimp Tool Head Krimptite™	molex **Certificate of Calibration**	 **Order No. 64007-0400** **Engineering No. AT 1753**

Tool Order Number ----------

Tool Eng. Number ----------

Tool Revision ----------

Serial Number ----------

Date of Manufacture ----------

Pin Gauge of Conductor Nest/Nests or Slug height if the nest is the “F” Crimp style.

Range Conductor Nest # 1 = ---------- Actual = ----------

Technician ----------

Date of Calibration ----------

Calibration should be done every 5,000 cycles or 3 months.
Tools should be lubricated during this operation.

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