

Modular Crimp Tooling Kit

Application Tooling Specification Sheet

Order No. 64001-7870

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 4 AWG. Refer to the Product part number charts on this sheet for terminals with the barrel and tongue styles listed above.

TESTING

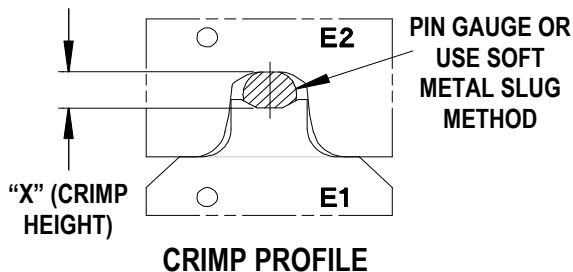
The tensile test or pull test is a means of evaluating the mechanical properties of the crimped connections. The following charts show the UL specifications for various wire sizes. The tensile strength is shown in pounds and indicates the minimum acceptable force to break or separate the terminal from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

Color Code	Wire Size (AWG)	*UL - 486 A	*UL - 486 C	**MIL-T-7928
Yellow	4	140	---	400

*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	
4	16.8-26.6	.340	8.67	.334	8.48	.346	8.79	④

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: 4 AWG 16.8-26.6mm ² CMA 33,100-52,600					
Terminal No.	Terminal Eng No. (REF)	Wire Strip Length		Insulation Diameter Maximum	
		In	mm	In	mm
19063-0078	F-766-10	.531	13.49	.432	10.97
19063-0079	F-766-12	.531	13.49	.432	10.97
19063-0080	F-766-14	.531	13.49	.432	10.97
19063-0083	F-766-76	.531	13.49	.432	10.97
19063-0084	F-767-10	.531	13.49	.432	10.97
19063-0086	F-767-56	.531	13.49	.432	10.97
19063-0087	F-770-12	.531	13.49	.432	10.97
19063-0088	F-770-14	.531	13.49	.432	10.97
19063-0089	F-770-34	.531	13.49	.432	10.97
19063-0090	F-770-38	.531	13.49	.432	10.97
19063-0091	F-770-56	.531	13.49	.432	10.97
19063-0092	F-770-76	.531	13.49	.432	10.97
19063-0165	F-766-10R90	.531	13.49	.432	10.97
19063-0166	F-766-14R90	.531	13.49	.432	10.97
19063-0167	F-769-14	.531	13.49	.432	10.97
19063-0169	F-767-14R90	.531	13.49	.432	10.97
19063-0174	F-766-56R90	.531	13.49	.432	10.97
19067-0075	F-966-10	.531	13.49	.510	12.95
19067-0076	F-966-12	.531	13.49	.510	12.95
19067-0077	F-966-14	.531	13.49	.510	12.95
19067-0078	F-966-38	.531	13.49	.510	12.95
19067-0079	F-966-56	.531	13.49	.510	12.95
19067-0080	F-966-76	.531	13.49	.510	12.95
19067-0081	F-967-10	.531	13.49	.510	12.95
19067-0082	F-967-14	.531	13.49	.510	12.95
19067-0083	F-967-14UB	.531	13.49	.510	12.95
19067-0084	F-967-56	.531	13.49	.510	12.95
19067-0085	F-969-12	.531	13.49	.510	12.95
19067-0086	F-969-38	.531	13.49	.510	12.95
19067-0087	F-969-58	.531	13.49	.510	12.95
19067-0088	F-970-34	.531	13.49	.510	12.95
19067-0089	F-970-58	.531	13.49	.510	12.95
19071-0231	F-666-10X	.531	13.49	.515	13.08
19071-0233	F-666-10XR90	.531	13.49	.515	13.08
19071-0234	F-666-12X	.531	13.49	.515	13.08
19071-0236	F-666-12XR90	.531	13.49	.515	13.08
19071-0237	F-666-14X	.531	13.49	.515	13.08
19071-0239	F-666-14XR90	.531	13.49	.515	13.08
19071-0240	F-666-38X	.531	13.49	.515	13.08
19071-0242	F-666-38XR90	.531	13.49	.515	13.08
19071-0243	F-666-56X	.531	13.49	.515	13.08
19071-0245	F-666-56XR90	.531	13.49	.515	13.08
19071-0247	F-666-76X	.531	13.49	.515	13.08
19071-0249	F-666-76XR90	.531	13.49	.515	13.08
19071-0250	F-667-10X	.531	13.49	.515	13.08
19071-0253	F-667-14X	.531	13.49	.515	13.08
19071-0255	F-667-56X	.531	13.49	.515	13.08

Wire Size: 4 AWG 16.8-26.6mm ² CMA 33,100-52,600					
Terminal No.	Terminal Eng No. (REF)	Wire Strip Length		Insulation Diameter Maximum	
		In	mm	In	mm
19071-0256	F-669-12X	.531	13.49	.515	13.08
19071-0257	F-669-14X	.531	13.49	.515	13.08
19071-0258	F-669-38X	.531	13.49	.515	13.08
19071-0259	F-669-56X	.531	13.49	.515	13.08
19071-0260	F-669-58X	.531	13.49	.515	13.08
19071-0261	F-669-76X	.531	13.49	.515	13.08
19071-0264	F-670-12X	.531	13.49	.515	13.08
19071-0265	F-670-14X	.531	13.49	.515	13.08
19071-0266	F-670-34X	.531	13.49	.515	13.08
19071-0268	F-670-38X	.531	13.49	.515	13.08
19071-0269	F-670-56X	.531	13.49	.515	13.08
19071-0270	F-670-58X	.531	13.49	.515	13.08
19071-0271	F-670-76X	.531	13.49	.515	13.08
19071-0378	F-667-14XR90	.531	13.49	.515	13.08
19154-0048	F-664X	.593	15.06	.515	13.08
19202-0056	F-764	.593	15.06	.430	10.92
19206-0015	F-665X	.593	15.06	.605	15.37
19207-0008	F-765	.593	15.06	.429	10.90

MILITARY					
Wire Size: 4 AWG-16.8-26.6mm ² CMA 33,100-52,600					
Terminal No.	Terminal Eng No. (REF)	Wire Strip Length		Insulation Diameter Maximum	
		In	mm	In	mm
19063-0081	F-766-38	.531	13.49	.432	10.97
19063-0082	F-766-56	.531	13.49	.432	10.97
19063-0085	F-767-14	.531	13.49	.432	10.97

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
	64001-7870	Crimp Tooling Kit – 4 AWG Insulated	REF
1	64001-7801	Anvil	1
2	64001-7802	Punch	1

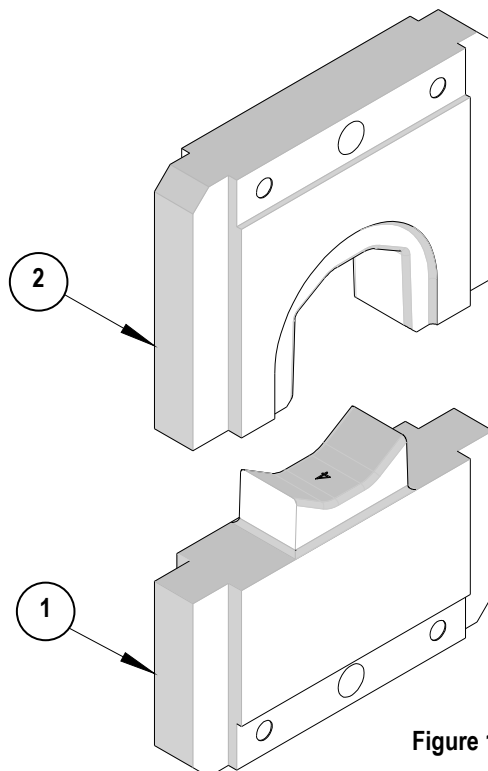


Figure 1

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