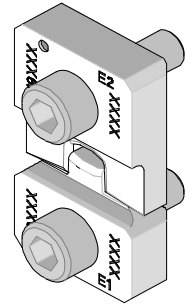




## Crimp Tooling Specification Sheet ATP Tooling Kit No. 19027-0055 Engineering No. ATP-B-120



### SCOPE

**Tooling:** ATP Tooling Kits used with Molex Air Tape Press: (ATP 100 and 300 series) or a Molex Mylar Tape Applicator (MTA series). Refer to the appropriate tool instruction manual for installation and operation information.

**Products:** Krimptite®/Versakrimp® Ring, Spade, Rectangular, Hook Tongue Terminals, And Butt Splices 14-16 AWG.

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

### Testing

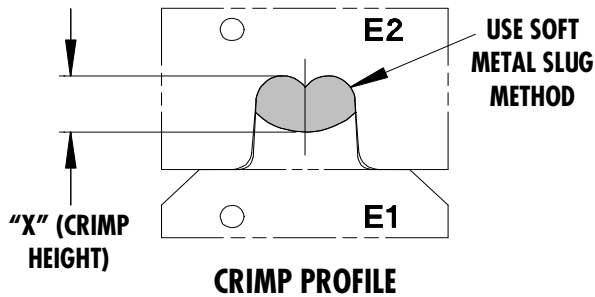
#### Mechanical

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 terminal from the conductor.

Color Code	Wire Size (AWG)	*UL - 486 A	*UL - 486 C
Blue	14	50	25
Blue	16	30	15

\*UL - 486 A - Terminals (Copper Conductors only)

\*UL - 486 C - Butt Splices, Parallel Splices



Use soft metal slug (solder) method to measure the "X" dimension. Verify 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	
14 - 16	2.00-1.30	.085	2.15	.082	2.08	.092	2.33	N/A

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: 14 – 16 AWG 2.00 – 1.30mm <sup>2</sup>					
Terminal No.	Terminal Eng No. (REF)	Wire Strip Length		Insul. Dia. Max.	
		In	mm	In	mm
19033-0006	B-179T	.281	7.14	N/A	N/A
19033-0008	B-189T	.281	7.14	N/A	N/A
19044-0015	B-118-10T	.281	7.14	N/A	N/A
19044-0017	B-123-02T	.281	7.14	N/A	N/A
19044-0018	B-125-56T	.281	7.14	N/A	N/A
19044-0029	B-137-04T	.281	7.14	N/A	N/A
19044-0034	B-139-04T	.281	7.14	N/A	N/A
19044-0036	B-139-06T	.281	7.14	N/A	N/A
19044-0038	B-139-08T	.281	7.14	N/A	N/A
19044-0151	B-123-04T	.281	7.14	N/A	N/A
19044-0153	B-123-06T	.281	7.14	N/A	N/A
19044-0155	B-123-08T	.281	7.14	N/A	N/A
19044-0157	B-125-10T	.281	7.14	N/A	N/A
19044-0159	B-125-14T	.281	7.14	N/A	N/A
19044-0175	B-137-06T	.281	7.14	N/A	N/A
19044-0176	B-137-08T	.281	7.14	N/A	N/A
19044-0177	B-137-10T	.281	7.14	N/A	N/A
19044-0178	B-139-10T	.281	7.14	N/A	N/A
19056-0054	B-318-10T	.281	7.14	N/A	N/A
19056-0056	B-318-14T	.281	7.14	N/A	N/A
19056-0058	B-318-38T	.281	7.14	N/A	N/A
19056-0060	B-318-56T	.281	7.14	N/A	N/A
19056-0062	B-323-02T	.281	7.14	N/A	N/A
19056-0064	B-323-04T	.281	7.14	N/A	N/A
19056-0067	B-323-06T	.281	7.14	N/A	N/A
19056-0069	B-323-08T	.281	7.14	N/A	N/A
19056-0071	B-325-10T	.281	7.14	N/A	N/A
19056-0074	B-325-14T	.281	7.14	N/A	N/A
19056-0076	B-325-56T	.281	7.14	N/A	N/A
19079-0009	B-1006-MST	.281	7.14	N/A	N/A
19086-0067	B-108-06T	.281	7.14	N/A	N/A
19086-0119	B-108-04T	.281	7.14	N/A	N/A
19086-0120	B-108-08T	.281	7.14	N/A	N/A
19086-0121	B-109-06T	.281	7.14	N/A	N/A
19086-0122	B-109-08T	.281	7.14	N/A	N/A
19086-0123	B-109-10T	.281	7.14	N/A	N/A
19086-0124	B-113-04T	.281	7.14	N/A	N/A
19086-0125	B-113-06T	.281	7.14	N/A	N/A
19086-0126	B-113-08T	.281	7.14	N/A	N/A
19086-0127	B-182-06T	.281	7.14	N/A	N/A
19086-0128	B-182-08T	.281	7.14	N/A	N/A
19086-0129	B-182-10T	.281	7.14	N/A	N/A
19086-0130	B-185-06T	.281	7.14	N/A	N/A
19086-0131	B-185-08T	.281	7.14	N/A	N/A
19086-0132	B-185-10T	.281	7.14	N/A	N/A
19086-0133	B-188-04T	.281	7.14	N/A	N/A
19086-0134	B-188-06T	.281	7.14	N/A	N/A
19086-0135	B-188-08T	.281	7.14	N/A	N/A
19086-0136	B-188-10T	.281	7.14	N/A	N/A
19088-0062	B-308-04T	.281	7.14	N/A	N/A
19088-0063	B-308-06T	.281	7.14	N/A	N/A

Wire Size: 14 – 16 AWG 2.00 – 1.30mm <sup>2</sup>					
Terminal No.	Terminal Eng No. (REF)	Wire Strip Length		Insul. Dia. Max.	
		In	mm	In	mm
19088-0064	B-309-06T	.281	7.14	N/A	N/A
19088-0065	B-309-08T	.281	7.14	N/A	N/A
19088-0066	B-309-10T	.281	7.14	N/A	N/A
19088-0067	B-313-04T	.281	7.14	N/A	N/A
19088-0068	B-313-06T	.281	7.14	N/A	N/A
19088-0069	B-313-08T	.281	7.14	N/A	N/A
19117-0049	B-116-06T	.281	7.14	N/A	N/A
19117-0051	B-116-08T	.281	7.14	N/A	N/A
19117-0067	B-183-10T	.281	7.14	N/A	N/A
19117-0082	B-116-04T	.281	7.14	N/A	N/A
19117-0085	B-116-10T	.281	7.14	N/A	N/A
19117-0088	B-180-06T	.281	7.14	N/A	N/A
19117-0089	B-180-08T	.281	7.14	N/A	N/A
19117-0090	B-180-10T	.281	7.14	N/A	N/A
19117-0091	B-183-06T	.281	7.14	N/A	N/A
19117-0092	B-183-08T	.281	7.14	N/A	N/A
19117-0093	B-186-04T	.281	7.14	N/A	N/A
19117-0094	B-186-06T	.281	7.14	N/A	N/A
19117-0095	B-186-08T	.281	7.14	N/A	N/A
19123-0052	B-316-04T	.281	7.14	N/A	N/A
19123-0053	B-316-06T	.281	7.14	N/A	N/A
19123-0054	B-316-08T	.281	7.14	N/A	N/A
19123-0055	B-316-10T	.281	7.14	N/A	N/A
19128-0015	B-1471-04T	.281	7.14	N/A	N/A
19128-0017	B-1471-06T	.281	7.14	N/A	N/A
19128-0018	B-1491-06T	.281	7.14	N/A	N/A
19128-0019	B-1491-08T	.281	7.14	N/A	N/A
19128-0020	B-1491-10T	.281	7.14	N/A	N/A
19128-0022	B-1781-06T	.281	7.14	N/A	N/A
19128-0024	B-1781-08T	.281	7.14	N/A	N/A
19140-0092	B-127-08T	.281	7.14	N/A	N/A
19140-0094	B-127-10T	.281	7.14	N/A	N/A
19140-0110	B-184-10T	.281	7.14	N/A	N/A
19140-0111	B-187-06T	.281	7.14	N/A	N/A
19140-0129	B-107-04T	.281	7.14	N/A	N/A
19140-0130	B-107-06T	.281	7.14	N/A	N/A
19140-0131	B-107-08T	.281	7.14	N/A	N/A
19140-0132	B-124-04T	.281	7.14	N/A	N/A
19140-0133	B-124-06T	.281	7.14	N/A	N/A
19140-0134	B-124-08T	.281	7.14	N/A	N/A
19140-0135	B-127-06T	.281	7.14	N/A	N/A
19140-0139	B-181-06T	.281	7.14	N/A	N/A
19140-0140	B-181-08T	.281	7.14	N/A	N/A
19140-0141	B-181-10T	.281	7.14	N/A	N/A
19140-0142	B-184-06T	.281	7.14	N/A	N/A
19140-0143	B-184-08T	.281	7.14	N/A	N/A
19140-0144	B-187-04T	.281	7.14	N/A	N/A
19140-0145	B-187-08T	.281	7.14	N/A	N/A
19146-0020	B-324-06T	.281	7.14	N/A	N/A
19146-0065	B-307-04T	.281	7.14	N/A	N/A
19146-0066	B-307-06T	.281	7.14	N/A	N/A

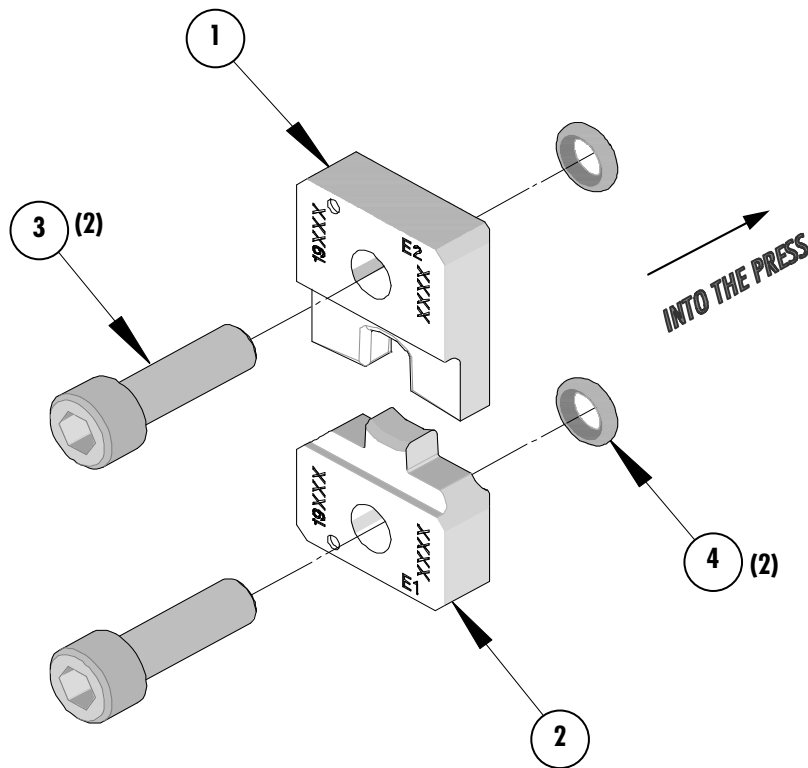
Wire Size: 14 – 16 AWG 2.00 – 1.30mm <sup>2</sup>					
Terminal No.	Terminal Eng No. (REF)	Wire Strip Length		Insul. Dia. Max.	
		In	mm	In	mm
19146-0067	B-307-08T	.281	7.14	N/A	N/A
19146-0068	B-324-04T	.281	7.14	N/A	N/A
19146-0069	B-324-08T	.281	7.14	N/A	N/A
19170-0008	B-119-06T	.281	7.14	N/A	N/A
19170-0010	B-119-08T	.281	7.14	N/A	N/A
19170-0013	B-119-10T	.281	7.14	N/A	N/A
19172-0008	B-319-06T	.281	7.14	N/A	N/A
19172-0010	B-319-08T	.281	7.14	N/A	N/A
19172-0012	B-319-10T	.281	7.14	N/A	N/A
19189-0010	B-131T	.281	7.14	N/A	N/A
19022-0026	MCT-1T	.281	7.14	N/A	N/A
19056-0103	B-337-04T	.281	7.14	N/A	N/A
19056-0105	B-337-06T	.281	7.14	N/A	N/A
19056-0108	B-337-08T	.281	7.14	N/A	N/A
19056-0111	B-337-10T	.281	7.14	N/A	N/A
19056-0113	B-339-04T	.281	7.14	N/A	N/A
19056-0115	B-339-06T	.281	7.14	N/A	N/A
19056-0117	B-339-08T	.281	7.14	N/A	N/A
19056-0119	B-339-10T	.281	7.14	N/A	N/A
19088-0070	B-382-06T	.281	7.14	N/A	N/A
19088-0071	B-382-08T	.281	7.14	N/A	N/A
19088-0072	B-382-10T	.281	7.14	N/A	N/A
19088-0073	B-385-06T	.281	7.14	N/A	N/A
19088-0074	B-385-08T	.281	7.14	N/A	N/A
19088-0075	B-385-10T	.281	7.14	N/A	N/A
19088-0076	B-388-04T	.281	7.14	N/A	N/A
19088-0077	B-388-06T	.281	7.14	N/A	N/A
19088-0078	B-388-08T	.281	7.14	N/A	N/A
19088-0079	B-388-10T	.281	7.14	N/A	N/A
19123-0059	B-380-06T	.281	7.14	N/A	N/A
19123-0060	B-380-08T	.281	7.14	N/A	N/A

Wire Size: 14 – 16 AWG 2.00 – 1.30mm <sup>2</sup>					
Terminal No.	Terminal Eng No. (REF)	Wire Strip Length		Insul. Dia. Max.	
		In	mm	In	mm
19123-0061	B-380-10T	.281	7.14	N/A	N/A
19123-0062	B-383-06T	.281	7.14	N/A	N/A
19123-0063	B-383-08T	.281	7.14	N/A	N/A
19123-0064	B-383-10T	.281	7.14	N/A	N/A
19123-0065	B-386-04T	.281	7.14	N/A	N/A
19123-0066	B-386-06T	.281	7.14	N/A	N/A
19123-0067	B-386-08T	.281	7.14	N/A	N/A
19146-0070	B-327-06T	.281	7.14	N/A	N/A
19146-0071	B-327-08T	.281	7.14	N/A	N/A
19146-0072	B-327-10T	.281	7.14	N/A	N/A
19146-0076	B-381-06T	.281	7.14	N/A	N/A
19146-0078	B-381-08T	.281	7.14	N/A	N/A
19146-0079	B-381-10T	.281	7.14	N/A	N/A
19146-0080	B-384-06T	.281	7.14	N/A	N/A
19146-0081	B-384-08T	.281	7.14	N/A	N/A
19146-0082	B-384-10T	.281	7.14	N/A	N/A
19146-0083	B-387-04T	.281	7.14	N/A	N/A
19146-0084	B-387-06T	.281	7.14	N/A	N/A
19146-0085	B-387-08T	.281	7.14	N/A	N/A
19189-0013	B-L131T	.281	7.14	N/A	N/A
19203-0043	B-5-123-06T	.281	7.14	N/A	N/A
19203-0045	B-5-125-14T	.281	7.14	N/A	N/A
19203-0046	B-5-125-56T	.281	7.14	N/A	N/A
19203-0048	B-5-137-06T	.281	7.14	N/A	N/A
19203-0050	B-5-137-08T	.281	7.14	N/A	N/A
19203-0052	B-5-137-10T	.281	7.14	N/A	N/A
19215-0017	BA-331T	.281	7.14	N/A	N/A
19215-0115	BS-331T	.281	7.14	N/A	N/A

### Parts List

Item	Order No.	Engineering No.	Description	Qty
	19027-0055	ATP-B-120	ATP Tooling Kit	REF
1	19027-0057	ATP-B-120-E2	Conductor Punch	1
2	19027-0056	ATP-B-120-E1	Conductor Anvil	1
3	N/A	N/A	#10-32 by 5/8" Long SHCS	2**
4	N/A	N/A	O-ring 1/16 W. by 9/32" O.D.	2**

\*\* The following purchased parts are available from an Industrial supply company such as MSC 1-800-645-7270



**Americas Headquarters**  
 Lisle, Illinois 60532 U.S.A.  
 1-800-78MOLEX  
 amerinfo@molex.com

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 81-462-65-2324  
 feninfo@molex.com

**Far East South Headquarters**  
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 fesinfo@molex.com

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