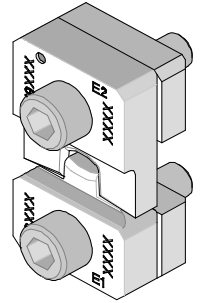




**Crimp Tooling Specification Sheet**  
**ATP Tooling Kit No. 19027-0305**  
**Engineering No. 19027-0305**



**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: Versakrimp® Ring Tongue Terminals 6 AWG.

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

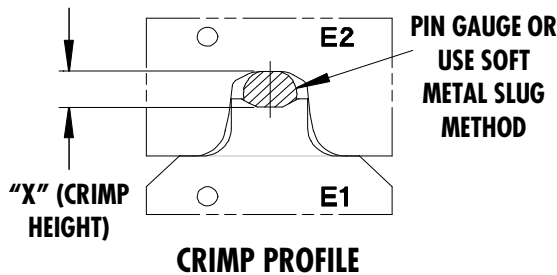
**Testing**

**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
Blue	6	100

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



Use gauge pins or 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	
6	16.0	.224	5.69	.221	5.61	.231	5.86	N/A

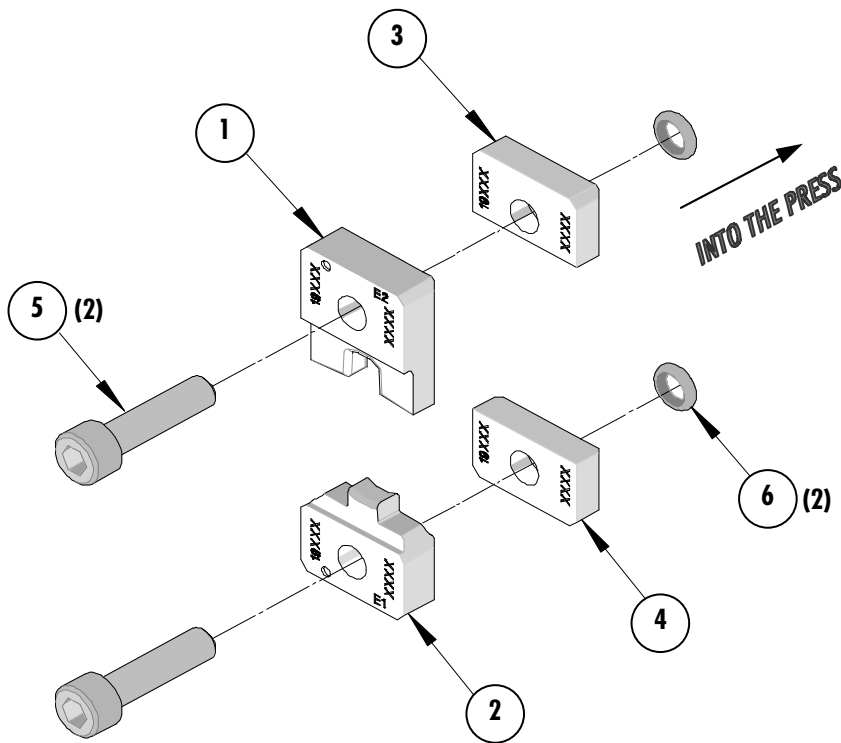
The following is a Partial List of the Product Part Numbers and their specifications that this tooling is designed to crimp. We will be adding to this list and an up to date copy is available on [www.molex.com](http://www.molex.com).

Wire Size: 6 AWG 16.0mm <sup>2</sup>					
Terminal No.	Terminal Eng No. (REF)	Wire Strip Length		Insul. Dia. Max.	
		In	mm	In	mm
19193-0228	E-358-12T	.468	11.90	N/A	N/A
19193-0231	E-358-38T	.468	11.90	N/A	N/A

### Parts List

Item	Order No.	Engineering No.	Description	Qty
	<b>19027-0305</b>	<b>19027-0305</b>	<b>ATP Tooling Kit</b>	<b>REF</b>
1	19027-0147	ATP-E-152-E2	Conductor Punch	1
2	19027-0146	ATP-E-152-E1	Conductor Anvil	1
3	19027-0202	DS-300-UPPER	Die Spacer - Upper (.300")	1
4	19027-0203	DS-300-LOWER	Die Spacer - Lower (.300")	1
5	N/A	N/A	#10-32 by 1" Long SHCS	2**
6	N/A	N/A	O-ring 1/16 W by 9/32" OD	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

**Far East North Headquarters**  
 Yamato, Kanagawa, Japan  
 81-462-65-2324  
 feninfo@molex.com

**Far East South Headquarters**  
 Jurong, Singapore  
 65-6-268-6868  
 fesinfo@molex.com

**European Headquarters**  
 Munich, Germany  
 49-89-413092-0  
 eurinfo@molex.com

**Corporate Headquarters**  
 2222 Wellington Ct.  
 Lisle, IL 60532 U.S.A.  
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Visit our Web site at <http://www.molex.com>