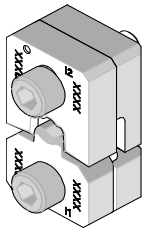
| ATP Tooling Kit | Application Tooling Specification Sheet |  Order No. 19027-0019 |
|---|---|---|

## 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: Avikrimp™ Quick Disconnect Terminal 10-12 AWG. Refer to the Product part number charts on this sheet for terminals with the barrel and tongue styles listed above.

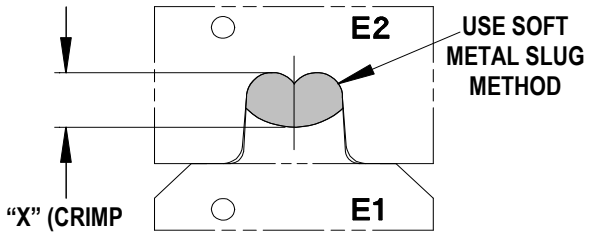
### Testing

#### 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 - 310 |
|---|---|---|
| Yellow | 10 | 80 |
| Yellow | 12 | 70 |

*UL – 310 –Quick Disconnects, Flags, and Couplers




CRIMP PROFILE

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 | mm² | In | mm | In | mm | In | mm | |
| 10 - 12 | 5.00 - 3.30 | .100 | 2.54 | .098 | 2.49 | .102 | 2.59 | 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.

| Wire Size: 10 – 12 AWG 5.00 – 3.30mm² | | | | | |
|---|---|---|---|---|---|
| Terminal No. | Terminal Eng No. (REF) | Wire Strip Length | | Insulation Diameter Maximum | |
| | | In | mm | In | mm |
| 19606-0006 | 19606-0006 | .343 | 8.73 | .230 | 5.84 |
| 19277-0009 | C-5293T-LIF | .343 | 8.73 | .233 | 5.92 |

## DEFINITION OF TERMS

The following illustrations are a generic terminal representation and not an exact image of any terminal listed in the scope.

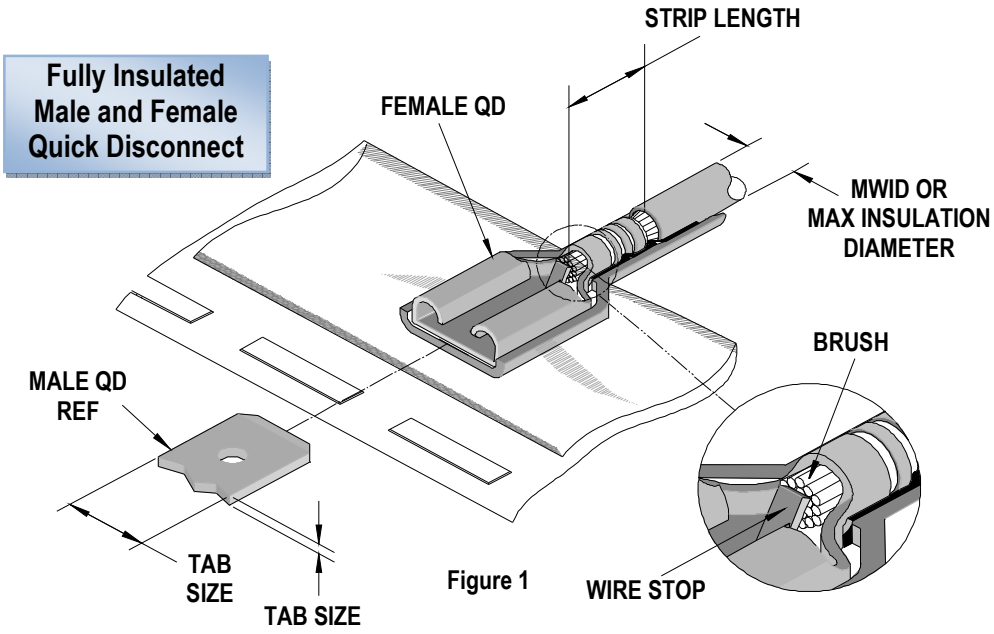
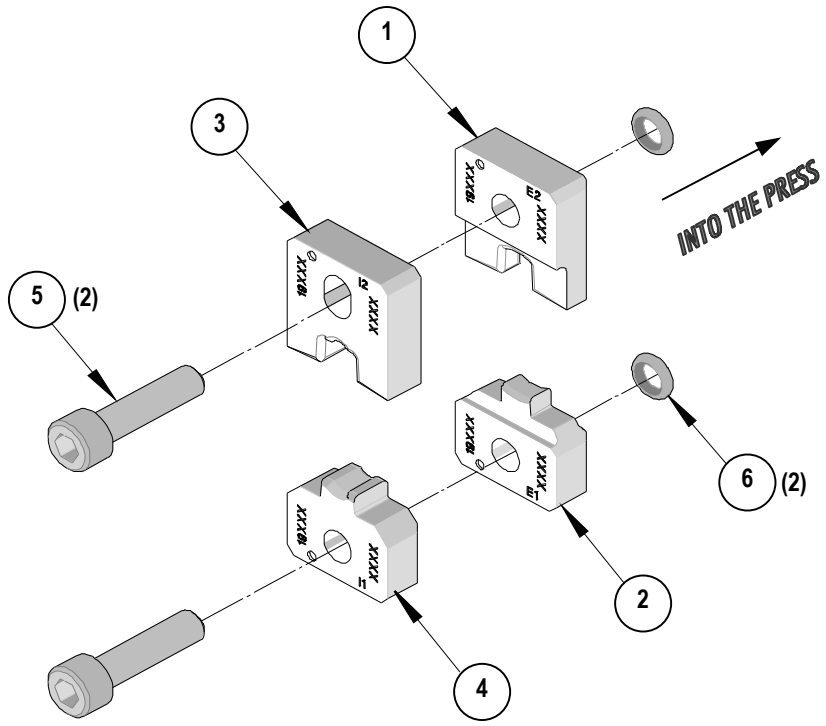



Figure 1

## Parts List

| Item | Order No. | Engineering No. | Description | Qty |
|---|---|---|---|---|
| | **19027-0019** | **19027-0019** | **ATP Tooling Kit** | **REF** |
| 1 | 19027-0020 | 19027-0020 | Conductor Punch | 1 |
| 2 | 19027-0021 | 19027-0021 | Conductor Anvil | 1 |
| 3 | 19027-0022 | 19027-0022 | Insulation Punch | 1 |
| 4 | 19027-0023 | 19027-0023 | Insulation Anvil | 1 |
| 5 | N/A | N/A | #10-32 by 7/8" Long SHCS | 2** |
| 6 | N/A | N/A | O-ring 1/16 W. by 9/32" O.D. | 2** |
| ** Available from an industrial supply company such as MSC (1-800-645-7270). | | | | |

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