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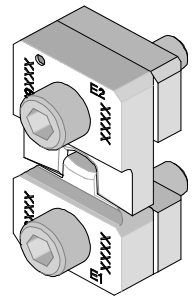
[Molex Connector Corporation](#)  
[0190270304](#)

For any questions, you can email us directly:

[sales@integrated-circuit.com](mailto:sales@integrated-circuit.com)



**Crimp Tooling Specification Sheet**  
**ATP Tooling Kit No. 19027-0304**  
**Engineering No. 19027-0304**



**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® Ring Tongue Terminals 14-16 AWG.

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

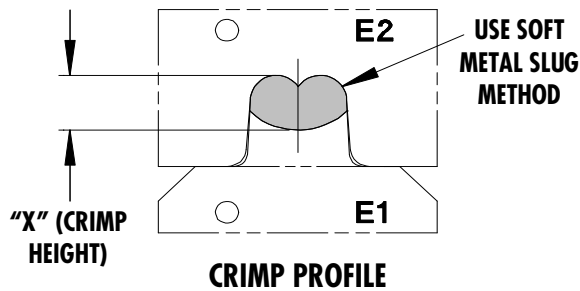
**Testing**

**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 |
|------------|-----------------|-------------|
| Blue       | 14              | 50          |
| Blue       | 16              | 30          |

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



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                      |

ATP - Tooling Kit-19027-0304

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).

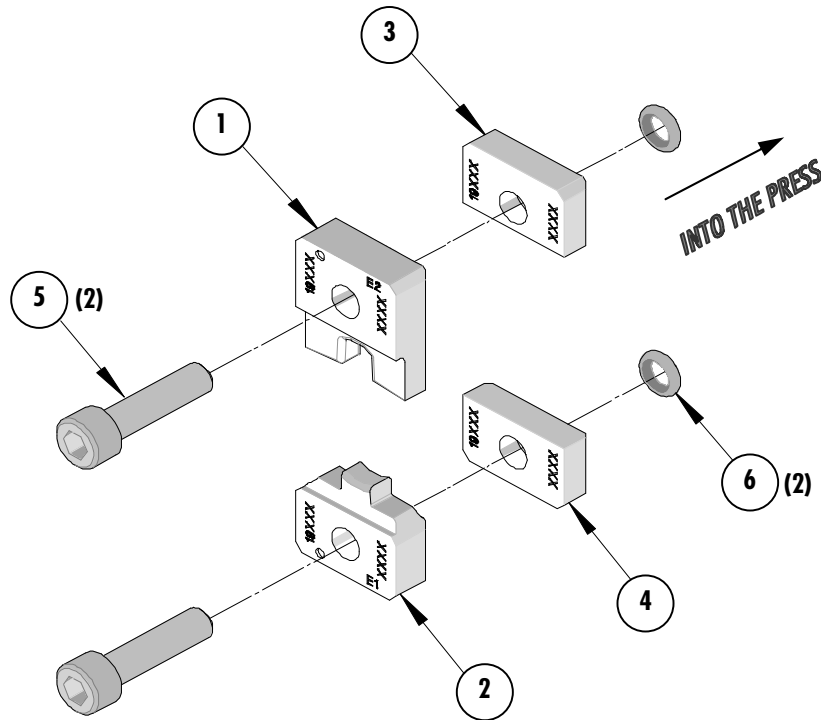
| Wire Size: 14 – 16 AWG 2.00 – 1.30mm <sup>2</sup> |                        |                   |      |                  |     |
|---|------------------------|-------------------|------|------------------|-----|
| Terminal No.                                      | Terminal Eng No. (REF) | Wire Strip Length |      | Insul. Dia. Max. |     |
|   |                        | In                | mm   | In               | mm  |
| 19044-0016  | B-118-56T              | .281              | 7.14 | N/A              | N/A |
| 19044-0145  | B-118-14T              | .281              | 7.14 | N/A              | N/A |
| 19044-0147  | B-118-38T              | .281              | 7.14 | N/A              | N/A |

ATP - Tooling Kit-19027-0304

**Parts List**

| Item | Order No.         | Engineering No.   | Description                | Qty        |
|------|-------------------|-------------------|----------------------------|------------|
|      | <b>19027-0304</b> | <b>19027-0304</b> | <b>ATP Tooling Kit</b>     | <b>REF</b> |
| 1    | 19027-0057        | ATP-B-120-E2      | Conductor Punch            | 1          |
| 2    | 19027-0056        | ATP-B-120-E1      | Conductor Anvil            | 1          |
| 3    | 19027-0201        | DS-187-UPPER      | Die Spacer - Upper (.187") | 1          |
| 4    | 19027-0200        | DS-187-LOWER      | Die Spacer - Lower (.187") | 1          |
| 5    | N/A               | N/A               | #10-32 by 3/4" 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  
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