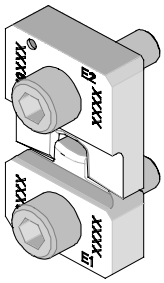
Crimp Tooling Specification Sheet
ATP Tooling Kit No. 19027-0068
Engineering No. ATP-BB-120



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® and Versakrimp® Ring Tongue, Spade Tongue, Rectangular Tongue, Hook Tongue and Wire Pin Terminals 14-16 AWG.

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

Also see ATP Tooling Kit 19027-0303. This kit uses 19027-0068 (ATP-BB-120) tooling with spacers. Adding the appropriate spacers to this kit allows crimping of all products listed for kits 19027-0303.

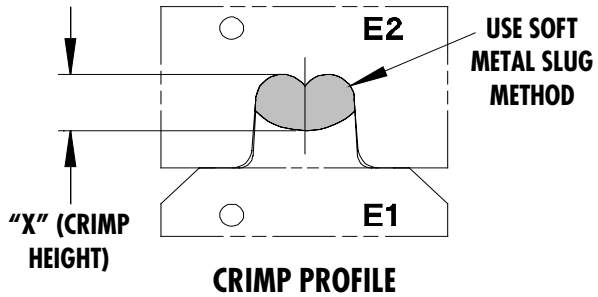
Testing

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)



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	
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.

Wire Size: 14 – 16 AWG 2.00 – 1.30mm²					
Terminal No.	Terminal Eng No. (REF)	Wire Strip Length		Insul. Dia. Max.	
		In	mm	In	mm
19069-0100	BB-123-04T	.187	4.76	N/A	N/A
19069-0102	BB-123-06T	.187	4.76	N/A	N/A
19069-0104	BB-123-08T	.187	4.76	N/A	N/A
19069-0106	BB-125-10T	.187	4.76	N/A	N/A
19069-0108	BB-125-14T	.187	4.76	N/A	N/A
19069-0110	BB-125-56T	.187	4.76	N/A	N/A
19069-0113	BB-137-06T	.187	4.76	N/A	N/A
19069-0115	BB-137-08T	.187	4.76	N/A	N/A
19069-0117	BB-137-10T	.187	4.76	N/A	N/A
19069-0122	BB-139-08T	.187	4.76	N/A	N/A
19069-0124	BB-139-10T	.187	4.76	N/A	N/A
19069-0134	BB-123-02T	.187	4.76	N/A	N/A
19069-0135	BB-123-04BT	.187	4.76	N/A	N/A
19069-0136	BB-137-04T	.187	4.76	N/A	N/A
19069-0137	BB-139-04T	.187	4.76	N/A	N/A
19069-0138	BB-139-06T	.187	4.76	N/A	N/A
19087-0097	BB-113-04T	.187	4.76	N/A	N/A
19087-0099	BB-113-06T	.187	4.76	N/A	N/A
19087-0101	BB-113-08T	.187	4.76	N/A	N/A
19087-0105	BB-182-06T	.187	4.76	N/A	N/A
19087-0107	BB-182-08T	.187	4.76	N/A	N/A
19087-0109	BB-182-10T	.187	4.76	N/A	N/A
19087-0114	BB-185-06T	.187	4.76	N/A	N/A
19087-0116	BB-185-08T	.187	4.76	N/A	N/A
19087-0118	BB-185-10T	.187	4.76	N/A	N/A
19087-0123	BB-188-04T	.187	4.76	N/A	N/A
19087-0125	BB-188-06T	.187	4.76	N/A	N/A
19087-0127	BB-188-08T	.187	4.76	N/A	N/A
19087-0129	BB-188-10T	.187	4.76	N/A	N/A
19093-0040	BB-313-04T	.187	4.76	N/A	N/A
19093-0042	BB-313-06T	.187	4.76	N/A	N/A
19093-0044	BB-313-08T	.187	4.76	N/A	N/A
19098-0035	BB-1193-06T	.187	4.76	N/A	N/A
19098-0037	BB-1194-08T	.187	4.76	N/A	N/A
19098-0040	BB-1195-10T	.187	4.76	N/A	N/A
19098-0042	BB-1707-05T	.187	4.76	N/A	N/A
19098-0044	BB-1707-06T	.187	4.76	N/A	N/A
19098-0048	BB-1716-08T	.187	4.76	N/A	N/A
19098-0050	BB-1717-10T	.187	4.76	N/A	N/A
19098-0082	BB-1707-04T	.187	4.76	N/A	N/A
19118-0055	BB-116-06T	.187	4.76	N/A	N/A
19118-0057	BB-116-08T	.187	4.76	N/A	N/A
19118-0059	BB-116-10T	.187	4.76	N/A	N/A
19118-0069	BB-183-10T	.187	4.76	N/A	N/A

Wire Size: 14 – 16 AWG 2.00 – 1.30mm²					
Terminal No.	Terminal Eng No. (REF)	Wire Strip Length		Insul. Dia. Max.	
		In	mm	In	mm
19118-0114	BB-116-04T	.187	4.76	N/A	N/A
19118-0115	BB-1491-06T	.187	4.76	N/A	N/A
19118-0117	BB-180-06T	.187	4.76	N/A	N/A
19118-0118	BB-180-08T	.187	4.76	N/A	N/A
19118-0119	BB-180-10T	.187	4.76	N/A	N/A
19118-0120	BB-183-06T	.187	4.76	N/A	N/A
19118-0121	BB-183-08T	.187	4.76	N/A	N/A
19118-0122	BB-186-04T	.187	4.76	N/A	N/A
19118-0123	BB-186-06T	.187	4.76	N/A	N/A
19118-0124	BB-186-08T	.187	4.76	N/A	N/A
19124-0034	BB-316-04T	.187	4.76	N/A	N/A
19124-0036	BB-316-06T	.187	4.76	N/A	N/A
19124-0038	BB-316-08T	.187	4.76	N/A	N/A
19124-0039	BB-316-10T	.187	4.76	N/A	N/A
19129-0021	BB-1781-08T	.187	4.76	N/A	N/A
19129-0028	BB-1471-06T	.187	4.76	N/A	N/A
19129-0069	BB-1781-06T	.187	4.76	N/A	N/A
19129-0070	BB-181-06T	.187	4.76	N/A	N/A
19129-0071	BB-181-08T	.187	4.76	N/A	N/A
19129-0072	BB-181-10T	.187	4.76	N/A	N/A
19129-0073	BB-184-06T	.187	4.76	N/A	N/A
19129-0074	BB-184-08T	.187	4.76	N/A	N/A
19129-0075	BB-184-10T	.187	4.76	N/A	N/A
19129-0076	BB-187-04T	.187	4.76	N/A	N/A
19129-0077	BB-187-06T	.187	4.76	N/A	N/A
19129-0078	BB-187-08T	.187	4.76	N/A	N/A
19141-0051	BB-107-04T	.187	4.76	N/A	N/A
19141-0053	BB-107-06T	.187	4.76	N/A	N/A
19141-0055	BB-124-04T	.187	4.76	N/A	N/A
19141-0057	BB-124-06T	.187	4.76	N/A	N/A
19141-0059	BB-124-08T	.187	4.76	N/A	N/A
19141-0062	BB-127-06T	.187	4.76	N/A	N/A
19141-0064	BB-127-08T	.187	4.76	N/A	N/A
19141-0066	BB-127-10T	.187	4.76	N/A	N/A
19147-0041	BB-307-04T	.187	4.76	N/A	N/A
19147-0043	BB-307-06T	.187	4.76	N/A	N/A
19147-0045	BB-324-04T	.187	4.76	N/A	N/A
19147-0047	BB-324-06T	.187	4.76	N/A	N/A
19147-0049	BB-324-08T	.187	4.76	N/A	N/A
19147-0051	BB-327-06T	.187	4.76	N/A	N/A
19147-0053	BB-327-08T	.187	4.76	N/A	N/A
19147-0055	BB-327-10T	.187	4.76	N/A	N/A
19178-0009	BB-119-06T	.187	4.76	N/A	N/A
19178-0011	BB-119-08T	.187	4.76	N/A	N/A

Wire Size: 14 – 16 AWG 2.00 – 1.30mm²					
Terminal No.	Terminal Eng No. (REF)	Wire Strip Length		Insul. Dia. Max.	
		In	mm	In	mm
19178-0013	BB-119-10T	.187	4.76	N/A	N/A
19180-0008	BB-319-06T	.187	4.76	N/A	N/A
19180-0010	BB-319-08T	.187	4.76	N/A	N/A
19180-0012	BB-319-10T	.187	4.76	N/A	N/A
19193-0054	BB-318-10T	.187	4.76	N/A	N/A
19193-0056	BB-318-14T	.187	4.76	N/A	N/A
19193-0058	BB-318-38T	.187	4.76	N/A	N/A
19193-0061	BB-318-56T	.187	4.76	N/A	N/A
19193-0063	BB-323-02T	.187	4.76	N/A	N/A
19193-0065	BB-323-04T	.187	4.76	N/A	N/A
19193-0067	BB-323-06T	.187	4.76	N/A	N/A
19193-0069	BB-323-08T	.187	4.76	N/A	N/A
19193-0071	BB-325-10T	.187	4.76	N/A	N/A
19193-0073	BB-325-14T	.187	4.76	N/A	N/A
19193-0075	BB-325-56T	.187	4.76	N/A	N/A
19193-0077	BB-337-04T	.187	4.76	N/A	N/A
19193-0079	BB-337-06T	.187	4.76	N/A	N/A
19193-0081	BB-337-08T	.187	4.76	N/A	N/A
19193-0083	BB-337-10T	.187	4.76	N/A	N/A

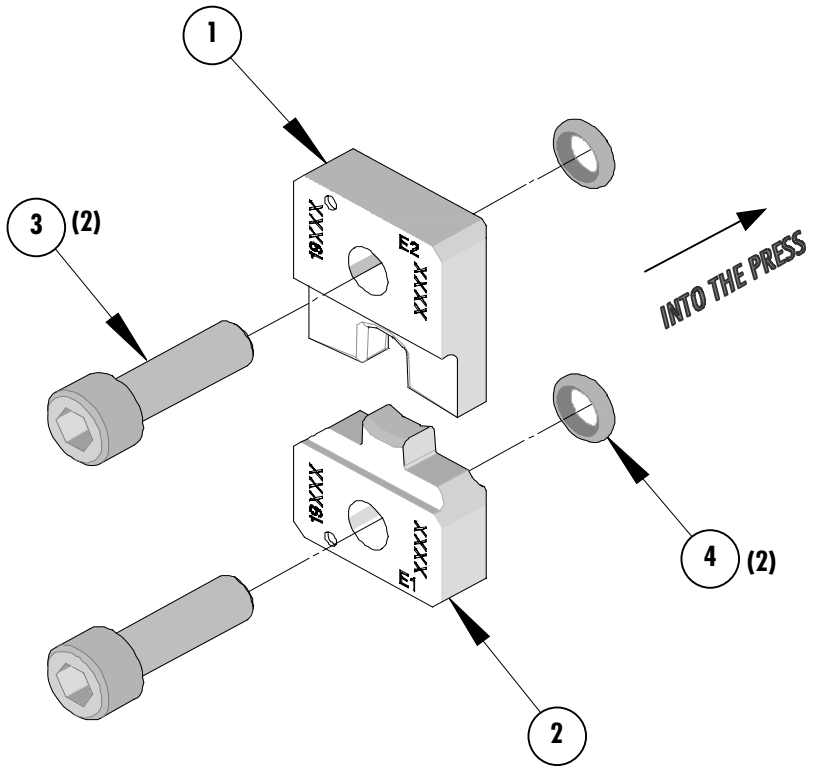
Wire Size: 14 – 16 AWG 2.00 – 1.30mm²					
Terminal No.	Terminal Eng No. (REF)	Wire Strip Length		Insul. Dia. Max.	
		In	mm	In	mm
19093-0046	BB-382-06T	.187	4.76	N/A	N/A
19093-0048	BB-382-08T	.187	4.76	N/A	N/A
19093-0050	BB-382-10T	.187	4.76	N/A	N/A
19093-0052	BB-385-06T	.187	4.76	N/A	N/A
19093-0054	BB-385-08T	.187	4.76	N/A	N/A
19093-0056	BB-385-10T	.187	4.76	N/A	N/A
19093-0058	BB-388-04T	.187	4.76	N/A	N/A
19093-0060	BB-388-06T	.187	4.76	N/A	N/A
19093-0062	BB-388-08T	.187	4.76	N/A	N/A
19093-0064	BB-388-10T	.187	4.76	N/A	N/A
19124-0044	BB-380-06T	.187	4.76	N/A	N/A
19124-0046	BB-380-08T	.187	4.76	N/A	N/A

Wire Size: 14 – 16 AWG 2.00 – 1.30mm²					
Terminal No.	Terminal Eng No. (REF)	Wire Strip Length		Insul. Dia. Max.	
		In	mm	In	mm
19124-0048	BB-380-10T	.187	4.76	N/A	N/A
19124-0050	BB-383-06T	.187	4.76	N/A	N/A
19124-0052	BB-383-08T	.187	4.76	N/A	N/A
19124-0054	BB-383-10T	.187	4.76	N/A	N/A
19124-0056	BB-386-04T	.187	4.76	N/A	N/A
19124-0058	BB-386-06T	.187	4.76	N/A	N/A
19124-0060	BB-386-08T	.187	4.76	N/A	N/A
19147-0063	BB-3781-10T	.187	4.76	N/A	N/A
19147-0065	BB-381-06T	.187	4.76	N/A	N/A
19147-0067	BB-381-08T	.187	4.76	N/A	N/A
19147-0069	BB-381-10T	.187	4.76	N/A	N/A
19147-0071	BB-384-06T	.187	4.76	N/A	N/A
19147-0073	BB-384-08T	.187	4.76	N/A	N/A
19147-0075	BB-384-10T	.187	4.76	N/A	N/A
19147-0077	BB-387-04T	.187	4.76	N/A	N/A
19147-0079	BB-387-06T	.187	4.76	N/A	N/A
19147-0081	BB-387-08T	.187	4.76	N/A	N/A
19193-0086	BB-339-04T	.187	4.76	N/A	N/A
19193-0088	BB-339-06T	.187	4.76	N/A	N/A
19193-0090	BB-339-08T	.187	4.76	N/A	N/A
19193-0092	BB-339-10T	.187	4.76	N/A	N/A
19203-0057	BB-T-323-06T	.187	4.76	N/A	N/A
19203-0058	BB-T-325-14T	.187	4.76	N/A	N/A
19203-0060	BB-T-337-06T	.187	4.76	N/A	N/A
19203-0062	BB-T-337-08T	.187	4.76	N/A	N/A
19203-0064	BB-T-337-10T	.187	4.76	N/A	N/A
19203-0078	BB-U-123-06T	.187	4.76	N/A	N/A
19203-0080	BB-U-125-14T	.187	4.76	N/A	N/A
19203-0081	BB-U-125-56T	.187	4.76	N/A	N/A
19203-0082	BB-U-137-06T	.187	4.76	N/A	N/A
19203-0084	BB-U-137-08T	.187	4.76	N/A	N/A
19203-0086	BB-U-137-10T	.187	4.76	N/A	N/A
19211-0006	WP-1614T	.187	4.76	N/A	N/A

Parts List

Item	Order No.	Engineering No.	Description	Qty
	19027-0068	ATP-BB-120	ATP Tooling Kit	REF
1	19027-0070	ATP-BB-120-E2	Conductor Punch	1
2	19027-0069	ATP-BB-120-E1	Conductor Anvil	1
3	N/A	N/A	#10-32 by 5/8″ 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

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

Far East South Headquarters
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