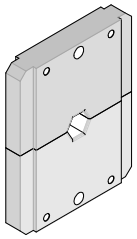
Modular Crimp Tooling Kit Compression Lug (Tool code 10)

molex

Application Tooling Specification Sheet



Order No. 64008-0470

SCOPE

Tooling: The Square "DIN" style die sets are used with two machines and each machine requires an adapter for the square "DIN" dies. The Molex UP60, order number 63801-8900 will process the square "DIN" style die sets with the 63801-8901 adapter. The Molex 12 ton battery crimp tool, order number 63816-1000 will process the square "DIN" style die sets with the 63816-1100 adapter. Refer to the appropriate crimper instruction manual for installation and operation information.

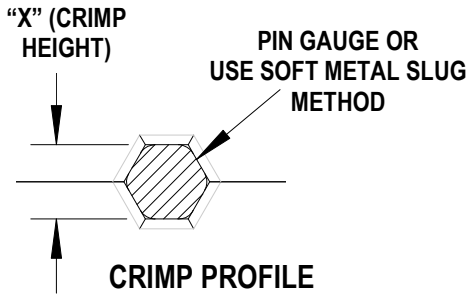
Products: Metric Compression Lug Terminals and Splices 25mm² (4 AWG). Refer to the Product part number charts on this sheet for terminals with the barrel and tongue styles listed above.

TESTING

The tensile test or pull test is a means of evaluating the mechanical properties of the crimped connections. The following chart shows the UL specifications for the equivalent AWG wire size. The tensile strength is shown in Newtons & (pounds) and indicates the minimum acceptable force to break or separate the terminal from the conductor.

Wire Size (mm²)	Wire Size (AWG)	Tensile (UL - 486 A)
25	4	623 (140)

*UL - 486 A – Lugs (to AWG wire) (Copper Conductors only)



Use gauge pins or soft metal slug (solder) method to measure the "X" dimension. Verify the 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.

Tool Code	Wire Range		"X" Dimension Conductor Crimp					
			Mean		Go		No Go	
	mm²	AWG	In	mm	In	mm	In	mm
10	25	4	.299	7.60	.295	7.50	---	7.70

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.

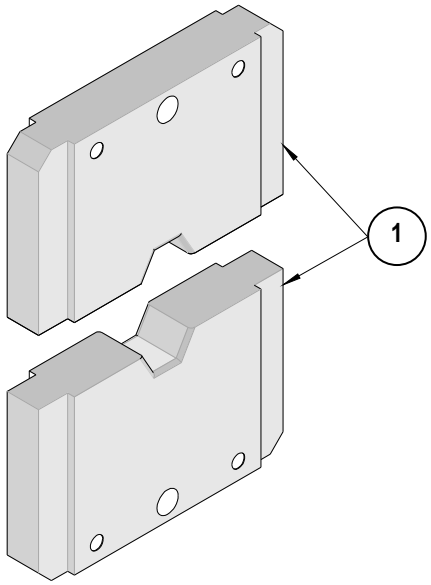
Wire Size: 25mm² (4AWG)			
Terminal No.	Terminal Eng No. (REF)	Wire Strip Length (Minimum)	
		In	mm
19322-0008	BCLM-6-25-PL	.790	20.0
19322-0041	BCLM-6-25-PLS	.790	20.0
19322-0009	BCLM-8-25-PL	.790	20.0
19322-0042	BCLM-8-25-PLS	.790	20.0
19322-0010	BCLM-10-25-PL	.790	20.0
19322-0043	BCLM-10-25-PLS	.790	20.0
19322-0011	BCLM-12-25-PL	.790	20.0
19322-0044	BCLM-12-25-PLS	.790	20.0

CAUTION: Install only Molex terminals listed above with this kit. Do not crimp hardened objects as damage can occur to the tool or die.

CAUTION: Molex specifications are valid only when used with Molex tooling.

CRIMP TOOLING KIT PARTS LIST

Item Number	Order Number	Description	Quantity
	64008-0470	**Crimp Tooling Kit – 25mm² Un-insulated**	**REF**
1	64008-0401	Hex Crimp Die (matched pair)	2



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