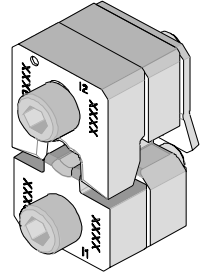




Crimp Tooling Specification Sheet
ATP Tooling Kit No.19288-0057
Engineering No. ATP-AA-AFIG



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® 22-18 AWG Fully Insulated Quick Disconnect Flag Terminals.

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

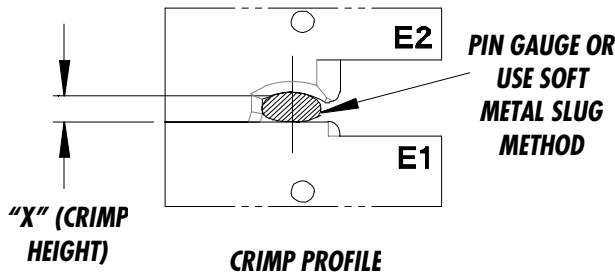
Testing

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
Red	22	8
Red	20	13
Red	18	20

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



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

Molex does not sell gauge pins. Contact your local industrial

Wire Range		"X" Dimension Conductor Crimp						Crimp Inspection Marking
		Mean		Go		No Go		
AWG	mm ²	In	mm	In	mm	In	mm	
18-22	.80-.35	.088	2.23	.085	2.16	.092	2.34	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.

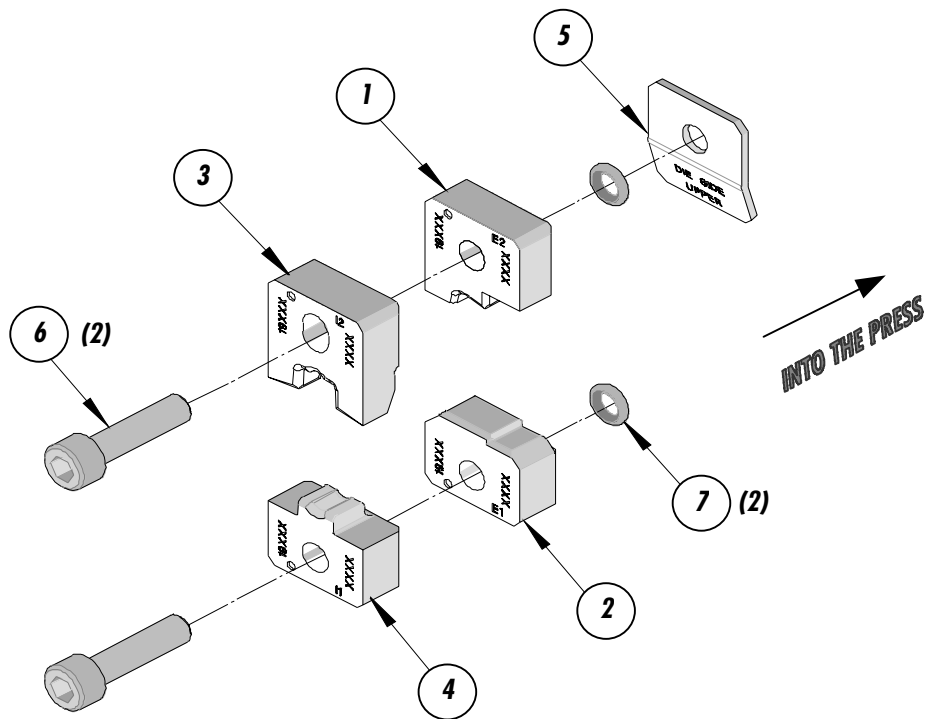
<i>Wire Size: 18-22 AWG .80-.35 mm²</i>					
<i>Terminal No.</i>	<i>Terminal Eng No. (REF)</i>	<i>Wire Strip Length</i>		<i>Insul. Dia. Max.</i>	
		<i>In</i>	<i>mm</i>	<i>In</i>	<i>mm</i>
<i>19006-0003</i>	<i>AA-5220T</i>	<i>.344</i>	<i>8.73</i>	<i>.150</i>	<i>3.81</i>
<i>19006-0006</i>	<i>AA-5222T</i>	<i>.344</i>	<i>8.73</i>	<i>.150</i>	<i>3.81</i>
<i>19006-0009</i>	<i>AA-5223T</i>	<i>.344</i>	<i>8.73</i>	<i>.150</i>	<i>3.81</i>

Parts List

Item	Order No.	Engineering No.	Description	Qty
	19288-0057	ATP-AA-AFIFG	ATP Tooling Kit	REF
1	19288-0059	ATP-AA-AFIFG-E2	Conductor Punch	1
2	19288-0058	ATP-AA-AFIFG-E1	Conductor Anvil	1
3	19288-0061	ATP-AA-AFIFG-12	Insulation Punch	1
4	19288-0060	ATP-AA-AFIFG-11	Insulation Anvil	1
5	19281-0081	19281-0081	Back Up Plate	1
6	N/A	N/A	#10-32 by 7/8" SHCS	2**
7	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.**

NOTE: This kit must be used with the 64016-0068 Stripper Assembly.



Molex Application Tooling Group
 1150 E. Diehl Road
 Naperville, IL 60563
 Tel: (630) 969-4550
 Fax: (630) 505-0049

Visit our Web site at <http://www.molex.com>