Air Powered Crimp Tool Head VersaKrimp™	**molex**® **Application Tooling Specification Sheet**	**Order No. 64007-4400 Engineering No. AT1080**

FEATURES

- Quick-change tool head for the 19279-0001 (AT-200)
- Tooling kit is interchangeable with other kits in the 64001 and 64003 Series
- Pneumatic powered crimp tools help reduce fatigue and discomfort from repetitive manual crimping

SCOPE

Products: VersaKrimp™ Ring Tongue Terminals and Splices 8 AWG. This tool head is intended for use in the 19279-0001 (AT-200) either hand held or with optional bench adapter 19078-0307 (ATBA) and foot switch.

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 the terminal from the conductor.

Wire Size (AWG)	*UL - 486 A	*UL – 486 C	*UL – 310
8	90	45	N/A

*UL - 486 A - Terminals (Copper conductors only)
*UL - 486 C - Butt Splices, Parallel Splices

The following is a partial list of the product part numbers and their specifications that this tool is designed to run. We will be adding to this list and an up to date copy is available on www.molex.com

Wire Size: 8 AWG 8.50mm²			
Terminal Order No.	Terminal Eng. No. (REF)	Wire Strip Length In	Wire Strip Length mm
19193-0143	D-350-06	.438	11.11
19193-0144	D-350-06R90	.438	11.11
19193-0146	D-350-08	.438	11.11
19193-0147	D-350-08R90	.438	11.11
19193-0149	D-350-10	.438	11.11
19193-0152	D-350-14	.438	11.11
19193-0154	D-350-14R90	.438	11.11
19193-0157	D-350-56	.438	11.11
19193-0159	D-351-10	.438	11.11
19193-0161	D-351-10R90	.438	11.11
19193-0163	D-351-14	.438	11.11
19193-0165	D-351-14R90	.438	11.11
19193-0167	D-351-38	.438	11.11

Wire Size: 8 AWG 8.50mm²			
Terminal Order No.	Terminal Eng. No. (REF)	Wire Strip Length In	Wire Strip Length mm
19193-0171	D-351-56	.438	11.11
19193-0175	D-351-76	.438	11.11
19193-0178	D-352-10	.438	11.11
19193-0179	D-352-12	.438	11.11
19193-0182	D-352-14	.438	11.11
19193-0184	D-352-38	.438	11.11
19193-0185	D-352-56	.438	11.11
19193-0186	D-352-58	.438	11.11
19193-0187	D-352-76	.438	11.11
19193-0190	D-353-12	.438	11.11
19193-0191	D-353-14	.438	11.11
19193-0192	D-353-34	.438	11.11
19193-0193	D-353-38	.438	11.11

Wire Size: 8 AWG 8.50mm²			
Terminal Order No.	Terminal Eng. No. (REF)	Wire Strip Length	
		In	mm
19193-0194	D-353-56	.438	11.11
19193-0195	D-353-58	.438	11.11
19193-0196	D-353-76	.438	11.11
19193-0198	D-356-06	.438	11.11
19193-0200	D-356-08	.438	11.11
19193-0202	D-356-10	.438	11.11
19193-0204	D-356-14	.438	11.11
19193-0506	D-356-14R90	.438	11.11

Wire Size: 8 AWG 8.50mm²			
Terminal Order No.	Terminal Eng. No. (REF)	Wire Strip Length	
		In	mm
19193-0527	D-351-56R90	.438	11.11
19203-0244	D-T-350-10		
19203-0245	D-T-350-14		
19205-0004	D-355	.312	7.92
19215-0034	D-354	.375	9.53
19215-0037	DC-354	.375	9.53

OPERATION

Refer to the instruction manual for the 19279-0001 (AT200) for mounting this crimp tool head.

> **CAUTION**: Never operate this tool without the supplied safety shield in place. Never place fingers in the tool nests.
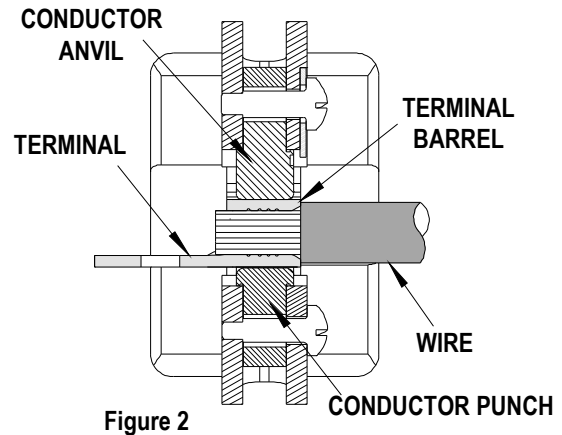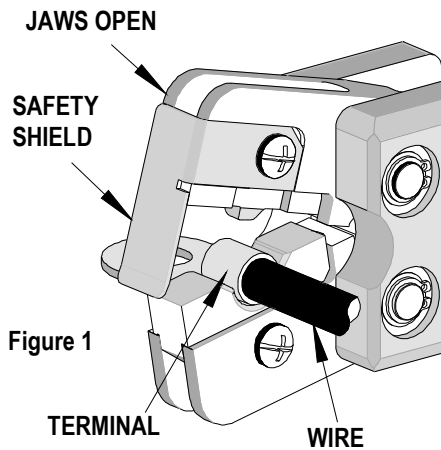
Figure 1

Figure 2

Crimping Terminals

1. Insert the wire into the terminal. Then insert the terminal in the nest with the barrel up and centered in the nest.
2. Push on wire to assure it is still fully seated in the terminal. See Figure 2 and 3. Cycle the tool.
3. When crimping butt splices, insert the wire into the butt splice. Position the splice and the wire into the nest with conductor crimp on the conductor barrel of the splice. The splice should be approximately centered inside the tooling nests. See Figure 3. Cycle the tool.
4. Remove the crimp and inspect for proper crimp location.
5. Molex offers a Crimp Inspection Handbook for closed barrel industrial product. See our website or contact your sales engineer.

> **Note**: Whenever crimping unbrazed product, make sure the seam of the terminal is oriented up or down in the tool. This will provide higher pull force values.

6. When crimping parallel splices insert the first wire into one end of splice then insert the second wire into the opposite end of the parallel splice. This procedure will crimp both wires at the same time. Make sure the wires are fully seated into the parallel splice. Position the splice and the wires in the nest with conductor crimp on the conductor barrel of the splice The splice should be approximately centered inside the tooling nests. See Figure 4. Cycle the tool.
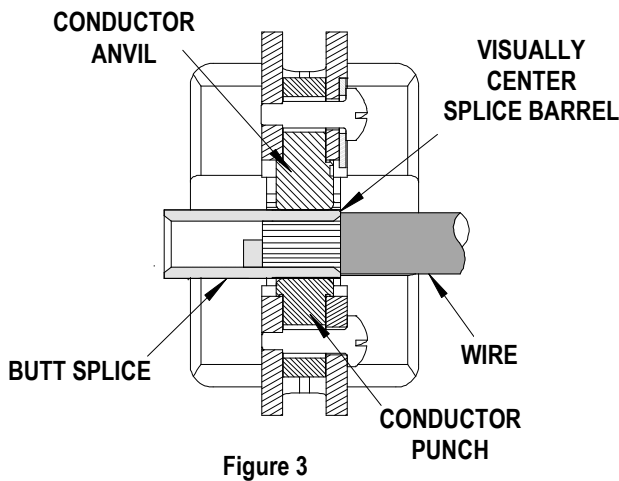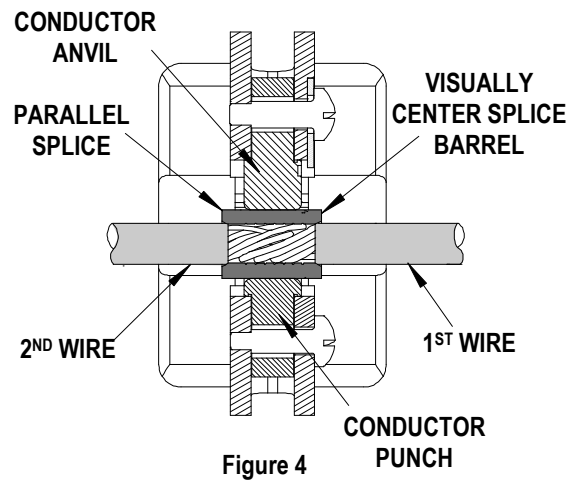
Figure 3

Figure 4

Maintenance

It is recommended that each operator of the tool be made aware of, and responsible for, the following maintenance steps:

1. Remove dust, moisture and other contaminants with a clean brush, or soft, lint-free cloth.
2. Do not use any abrasive materials that could damage the tool.
3. Make certain all pins, pivot points and bearing surfaces are protected with a thin coat of high quality machine oil. Do not oil excessively. This tool was engineered for durability, but like any fine piece of equipment it needs cleaning and lubrication for a maximum service life of trouble-free crimping. A light oil, such as 30 weight automotive oil used at the oil points shown in Figure 5, every 5,000 crimps or monthly will significantly enhance the tool life and ensure a stable calibration.
4. When tool is not in use store the tool in a clean, dry area.

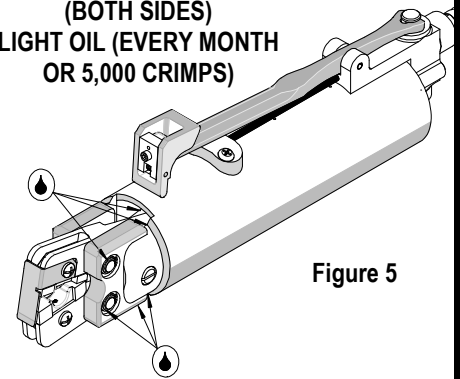**LUBRICATION POINTS (BOTH SIDES) LIGHT OIL (EVERY MONTH OR 5,000 CRIMPS)**

Figure 5

Tool Calibration

A Certificate of Calibration (See last page) was supplied with the tool. To recalibrate this tool, measurements should be taken from each conductor nest and compared to this chart. The tool should be lubricated prior to recalibration to ensure consistent measurements.

PIN GAUGE IN CONDUCTOR CRIMP

"INDENTOR" CRIMP
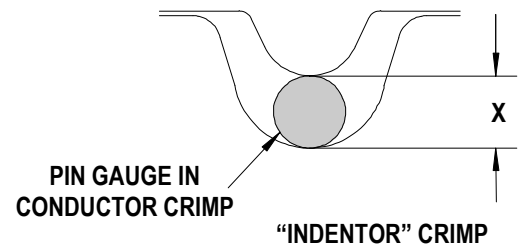
Nest Color Code	Wire Range		"X" Dimension Conductor Crimp			Crimp Inspection Marking
	AWG	mm²	Mean	Go	No Go	
N/A	8	13.30	.115	.109	.122	8

Warranty

This tool is for electrical terminal crimping purposes only. This tool is made of the best quality materials. All vital components are long-life tested. All tools are warranted to be free of manufacturing defects for a period of 30 days. Should such a defect occur, we would repair or exchange the tool free of charge. This repair or exchange will not be applicable to altered, misused or damaged tools.

CAUTION: Molex crimp specifications are valid only when used with Molex terminals, applicators and tooling.

PARTS LIST

Item	Order No	Description	Quantity
	64007-4400	**Crimp Tool Head**	**Figure 6**
1	64005-0000	Basic Air Tool Head	1
2	64003-4470	Tooling Kit	1
Tooling Kit Only			
3	64003-4402	Conductor Anvil	1
4	64003-4401	Conductor Punch	1
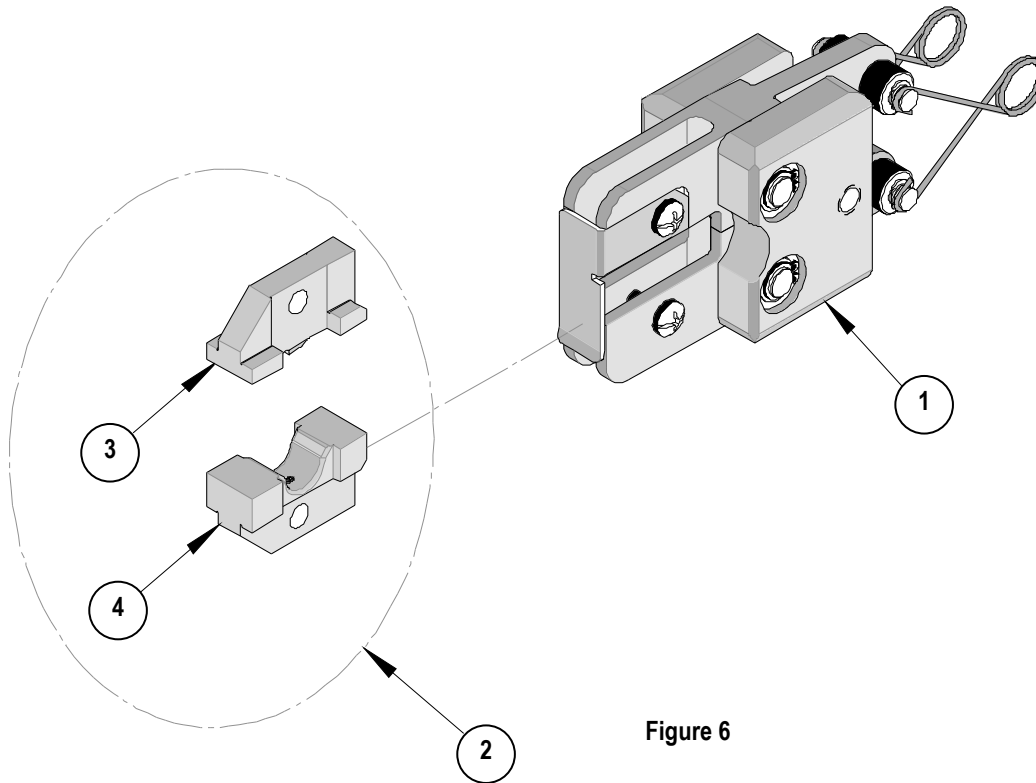
Figure 6

Parts List (Continued)

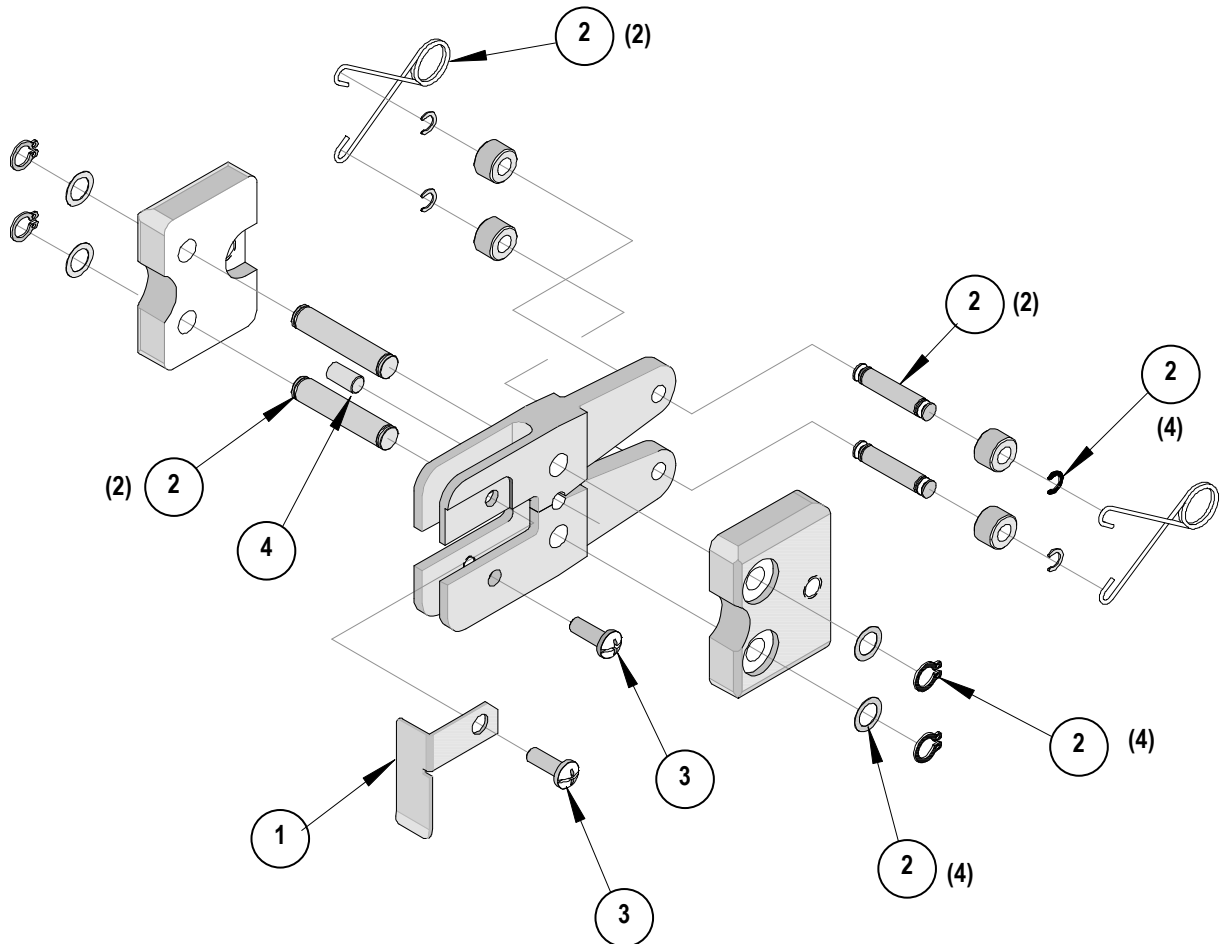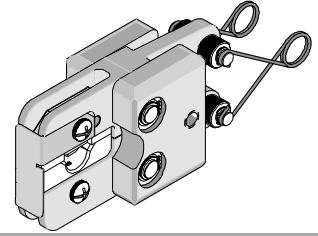| Item	Order No.	Description	Quantity
	64005-0000	**Basic Air Tool Head**	**Figure 7**
1	64005-0103	Nose Guard	1
2	64000-0077	Repair Kit (Springs, Rods Pivots ,Rings, and Washers)	1
3	N/A	M4 by 12 Long Freedrive Pan Head Screw	2**
4	N/A	3/16" by 3/8" Long Dowel Pin	1**
	** Available from an Industrial supply company such as MSC (1-800-645-7270).		

Figure 7

molex

**Air Powered
Crimp Tool Head
VersaKrimp™**

Certificate of Calibration

**Order No. 64007-4400
Engineering No. AT1080**

Tool Order Number _____

Tool Eng. Number _____

Tool Revision _____

Serial Number _____

Date of Manufacture _____

Pin Gauge of Conductor Nest/Nests or Slug height if the nest is the "F" Crimp style.

Range Conductor Nest # 1 =_____ Actual = _____

Technician _____

Date of Calibration _____

Calibration should be done every 5,000 cycles or 3 months.
Tools should be lubricated during this operation.

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

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