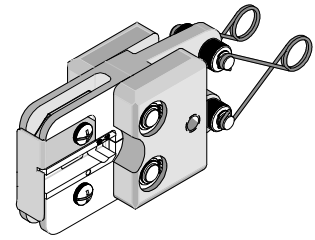




**Air Powered
Crimp Tool Head
Insulkrimp™**

**Application Tooling
Specification Sheet**



Order No. 64005-8100

FEATURES

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

SCOPE

Products: Insulkrimp™ Male Quick Disconnect, 10 - 12 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 - 310
10	80
12	70

*UL - 310 – Quick Disconnects

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: 10 – 12 AWG 5.00 – 3.30mm ²					
Terminal No.	Terminal Eng No. (REF)	Wire Strip Length		Insulation Diameter Maximum	
		In.	mm	In.	mm
19023-0008	CMCT-2X	.375	9.53	.250	6.35

Operation

Refer to the instruction manual for the 19279-0001 (AT-200) for mounting this crimp tool head.

Crimping Terminals

Caution: Never operate this tool without the supplied safety shield in place. Never place fingers in the tool nests.

1. Push up on the locator blade and position the terminal with the barrel facing up into the nest with the front edge of the barrel against the locator. See Figure 1.
2. Insert the properly stripped wire into the terminal barrel. See Figure 2.
3. Push on the wire to assure it is fully seated in the terminal. See Figure 3. The wires end should butt against the locator. Cycle the tool.
4. Remove the crimped terminal. Inspect for proper crimp location.

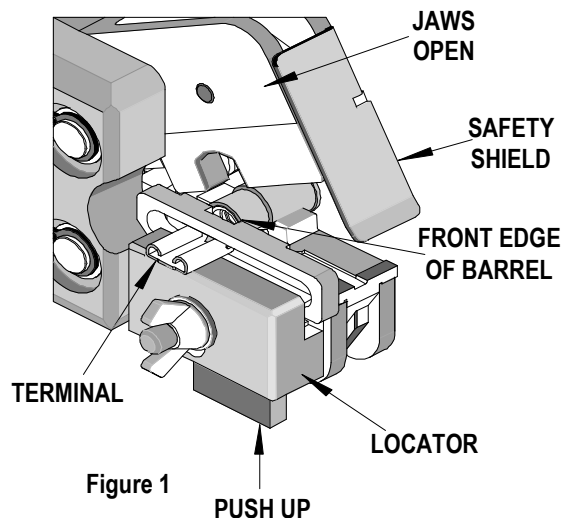


Figure 1

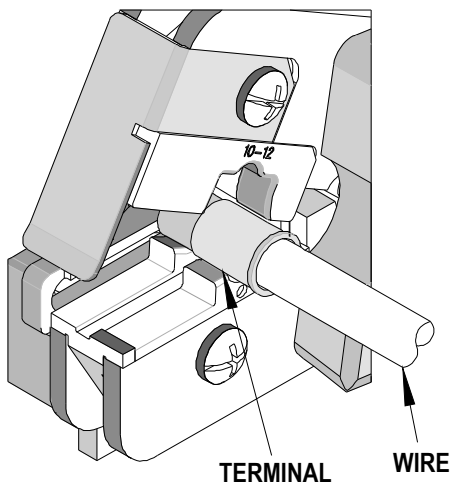


Figure 2

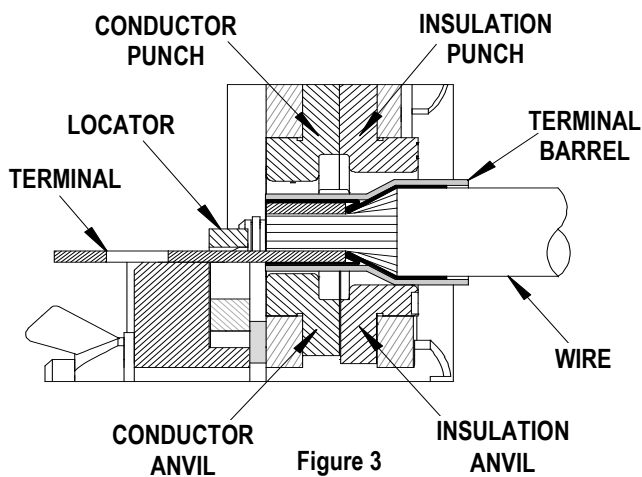


Figure 3

Maintenance

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

Remove dust, moisture and other contaminants with a clean brush, or soft, lint-free cloth.

Do not use any abrasive materials that could damage the tool.

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 4, every 5,000 crimps or monthly, will significantly enhance the tool life and ensure a stable calibration. When tool is not in use store the tool in a clean, dry area.

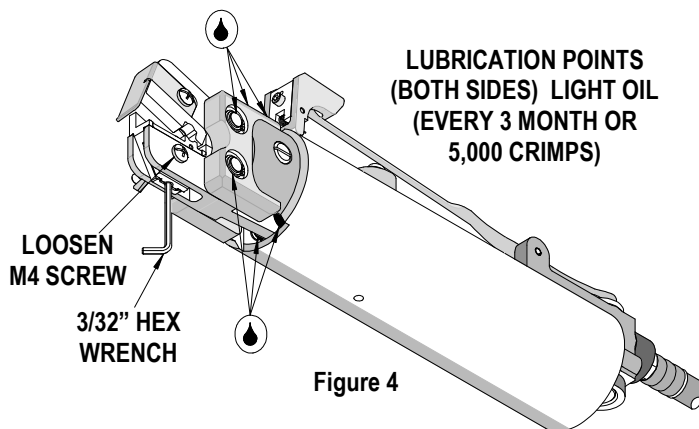
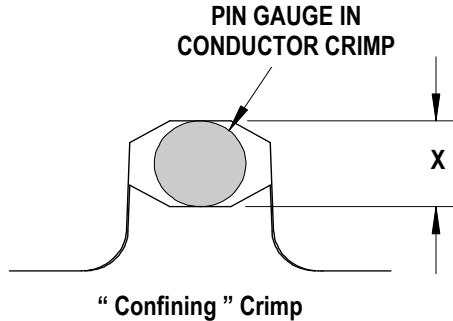


Figure 4

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.



Nest Color Code	Wire Range		“X” Dimension Conductor Crimp			Crimp Inspection Marking
	AWG	mm ²	Mean	Go	No Go	
Yellow	10 - 12	3.30 - 5.00	.100	.097	.103	oo

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 and tooling.

PARTS LIST

Item	Order No	Description	Quantity
	64005-8100	Crimp Tool Head	Figure 5
1	64005-0000	Basic Air Tool Head	1
2	64005-1275	Locator Assembly	1
3	64005-8170	Tooling Kit	1
Tooling Kit Only			
4	64001-8102	Conductor Punch	1
5	64001-8101	Conductor Anvil	1
6	64001-8104	Insulation Punch	1
7	64001-8103	Insulation Anvil	1
8	N/A	4mm Diameter by 5.0mm Long Roll Pins	2**
9	N/A	#10-32 by 5/16" Long Cup Pt. Set Screw	1**
** Available from an Industrial supply company such as MSC (1-800-645-7270).			

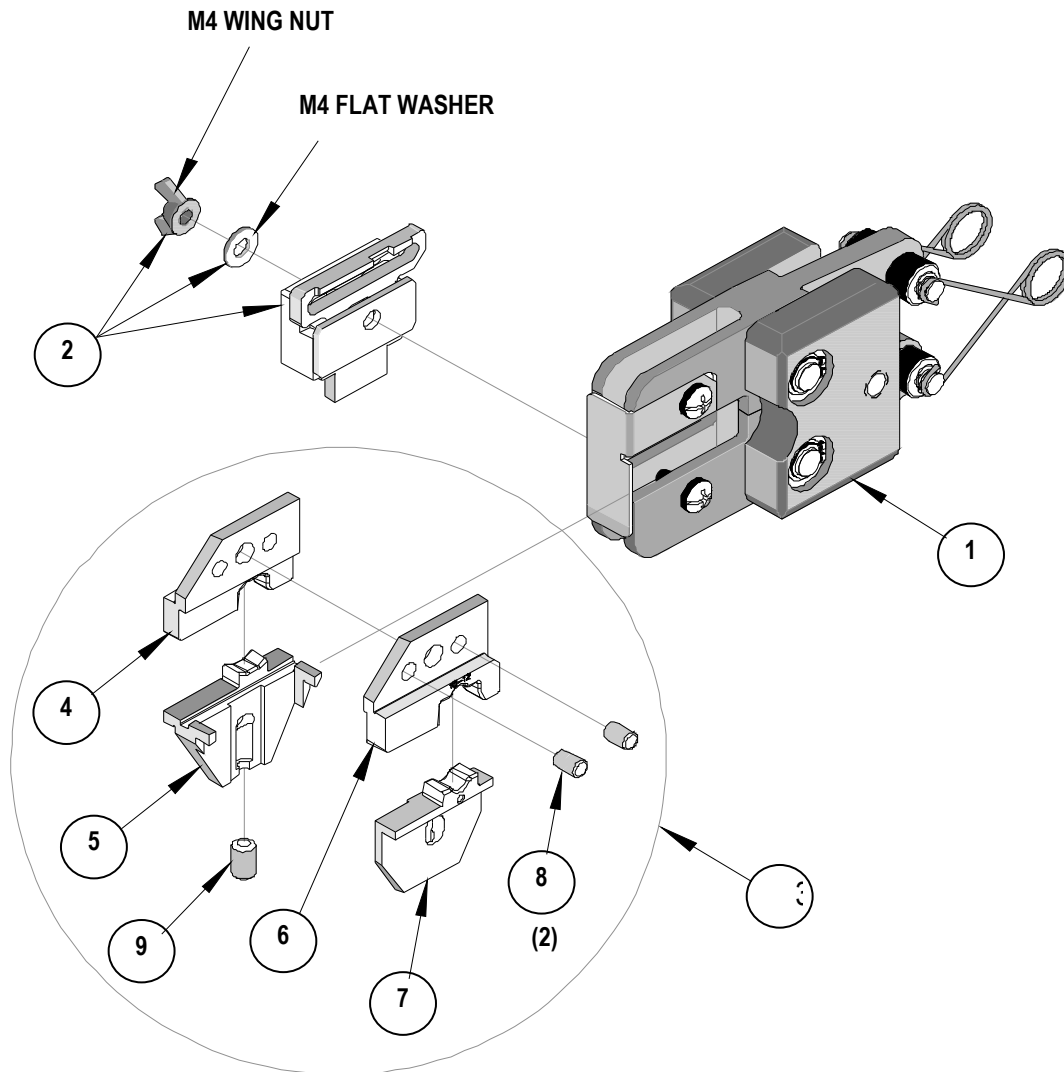


Figure 5

Parts List (Continued)

Item	Order No.	Description	Quantity
	64005-0000	Basic Air Tool Head	Figure 6
1	64005-0103	Nose Guard	1
2	64000-0077	Repair Kit (Springs, Rods Pivots ,Rings, and Washers)	1
3	N/A	M4 by 12LG. Freedrive Pan Head Screw	1**
4	N/A	M4 by 20LG. Freedrive Pan Head Screw	1**
5	N/A	3/16" by 3/8" Long Dowel Pin	1**

** The following purchased parts are available from an Industrial supply company such as MSC (1-800-645-7270).

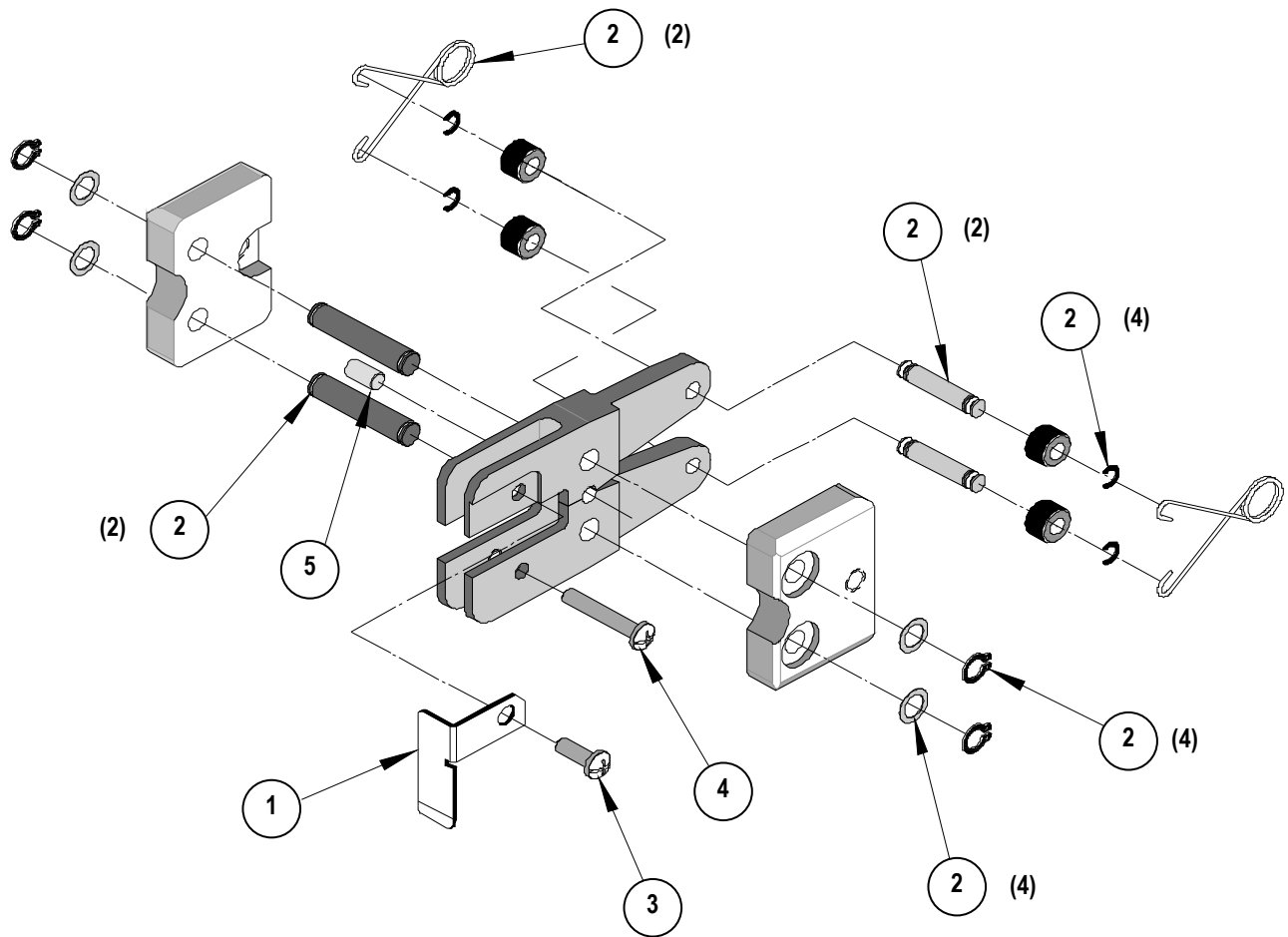
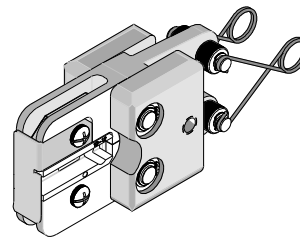


Figure 6



**Air Powered
Crimp Tool Head
Insulkrimp™**

Certificate of Calibration

Order No. 64005-8100

Tool Order Number 64005-8100

Tool Revision _____

Serial Number _____

Date of Manufacture _____

Pin Gauge of Conductor Nest.

Range Conductor Nest = .097" - .103" (2.46mm - 2.62mm) 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>