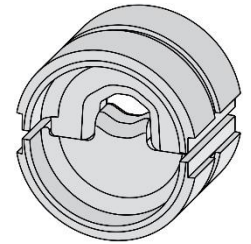**Order Number
219382-0050**

molex

Application Tooling Specification

TOOLING

- The U-style die set can be used with any C-head compression tool that accepts U-style dies.
- Molex does not sell a C-head compression tool, but we recommend the three Huskie tools listed below:
  - **S7L-MK510:** 12-ton C-head compression tool, handle-forward design
  - **REC-MK7510:** 12-ton C-head compression tool, pistol design
  - **SL-MKC7510:** 12-ton C-head compression tool, inline design
    - A C-head is required for fast and easy terminal placement and extraction from the die set.
- Other compression tools can be used; however, they must meet the following requirements:
  - Accept U-style industry-standard die sets
  - C-shaped head for terminal removal
- Refer to the appropriate crimper instruction manual for installation and operation information.

SCOPE

Products: 6mm SideWize R/A WTB Terminal for 2 AWG Wire.

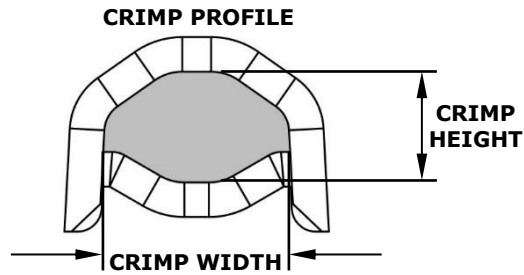| Terminal Series No.	Terminal Assembly Order No.	Wire Size		Strip Length	
		AWG	mm²	mm	In.
217884	217884-2000	2	—	18.75-19.25	.787
	217884-2001				

TESTING

The *tensile test* or *pull test* is a means of evaluating the mechanical properties of the crimped connections. The following chart shows the specifications for the wire size. The tensile strength is shown in newtons and pounds, and it indicates the minimum acceptable force to break or separate the terminal from the conductor.

Wire Size (AWG)	Minimum Pull (UL486)	
	N	Lb.
2	801	180

CRIMP MEASUREMENT

After crimping, the terminal crimp profiles should measure the following:

Terminal Series No.	Wire Size AWG	Wire Size mm²	Crimp Height (Ref) mm	Crimp Height (Ref) In.	Crimp Width (Ref) mm	Crimp Width (Ref) In.
217884	2	—	10.67-10.83	.420-.426	19.50-19.70	.767-.776

CRIMP PROFILE

CRIMP HEIGHT

CRIMP WIDTH

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

PARTS LIST

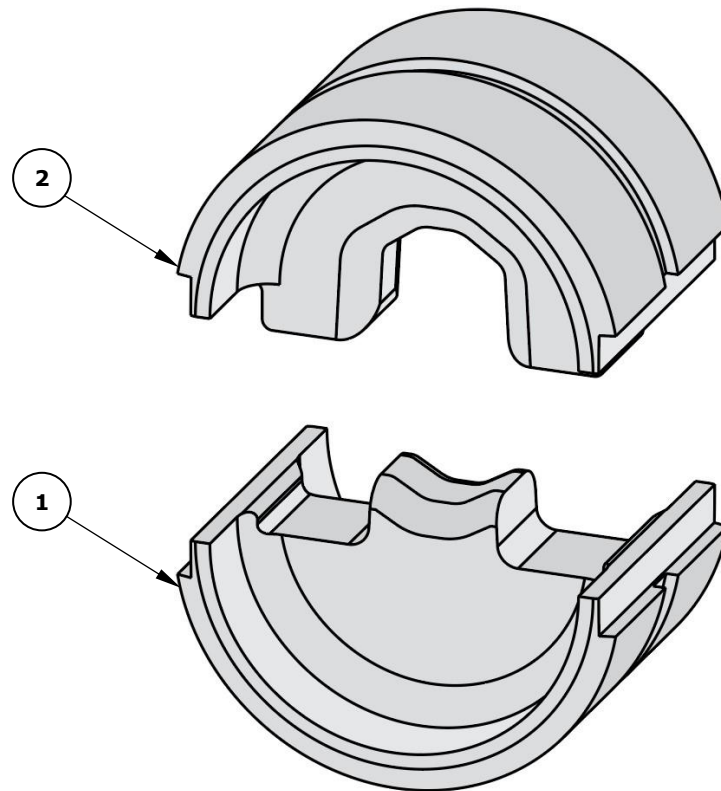| Item Number	Order Number	Description	Quantity
	219382-0050	**Crimp Tooling Kit – 2 AWG**	**REF**
1	219382-0051	Conductor Anvil	1
2	219382-0052	Conductor Punch	1

2

1

Figure 1

Application Tooling Support

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E-Mail: toolingsupport@molex.com
Website: www.molex.com/applicationtooling