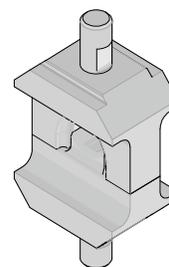




**Crimp Tool Kit
For Imperium
and Imperium Plus**

**Application Tooling
Specification Sheet**



Order No. 19290-0100

SCOPE

Tooling: Crimp Tool Kits are used with the Hydraulic Head Crimper with the Air/Hydraulic Pump (19286-1000). Refer to the appropriate tool instruction manual for installation and operation information.

Products: Imperium and Imperium Plus Terminals to 1 AWG bare and pre-tinned copper wire. Refer to the Product part number charts on this sheet for terminals.

Testing

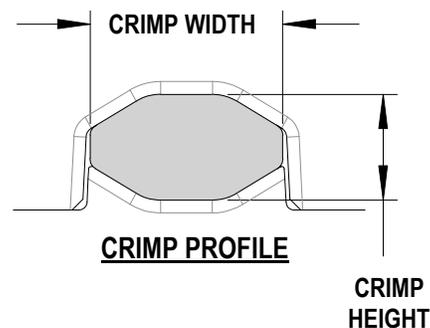
The tensile test or pull test is a means of evaluating the mechanical properties of the crimped connections. The following chart shows the specifications for the wire size. The tensile strength is shown in Newton and (pounds) and indicates the minimum acceptable force to break or separate the terminal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

Wire Size (AWG)	Minimum Pull (UL 486)
1	890N (200 lbs.)

Crimp measurement

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

Terminal Series	Wire Size		Crimp Height (Ref)		Crimp Width (Ref)	
	AWG	Wire Style	mm	In.	mm	In.
171423 / 171562	1	Bare copper Pre-Tinned	6.90-7.10	.272-.280	11.95-12.15	.470-.478
31561	1	Bare copper Pre-Tinned	6.85-7.05	.270-.278	11.90-12.10	.469-.476



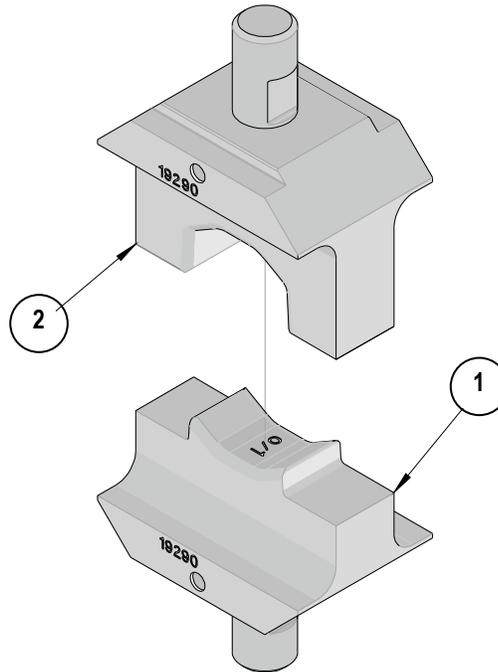
The following is a Partial List of the Product Part Numbers and their specifications that this tooling is designed to crimp. We will be adding to this list and an up to date copy is available on www.molex.com.

Terminal Series	Terminal No.	Wire Size (AWG)	Wire Strands / AWG	Wire Strip Length	
				In	mm
171423	171423-1402	1	779 / 30 817 / 30	0.87	22.0
171562	171562-7004				
31561	31561-7001				

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

Parts List

Item	Order No.	Description	Qty
	19290-0100	Crimp Tooling Kit	REF
1	19290-0101	Conductor Anvil	1
2	19290-0102	Conductor Punch	1



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