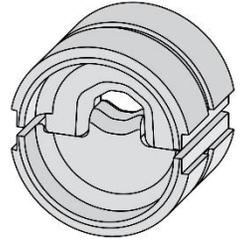


Order Number
219382-0050



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 CST Receptacle / 6mm SideWize R/A WTB / Hypercube Male Terminal for 2 AWG Wire.

Terminal Series No.	Terminal Assembly Order No.	Wire Size		Strip Length	
		AWG	mm ²	mm	In.
204608	204608-0006	2	—	14.5-16.0	.570-.630
217884	217884-2000			18.75-19.25	.738-.758
	217884-2001				
220719	220719-1001			14.30-15.80	.563-.622

TESTING

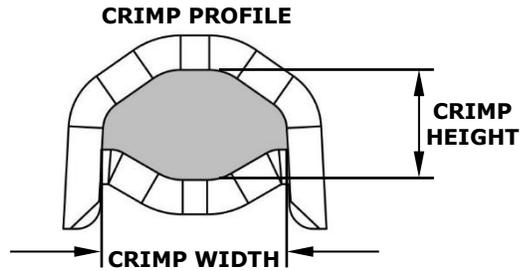
The *tensile test* or *pull test* is a means of evaluating the mechanical properties of the crimped connections. The following chart shows the specifications for the wire size. The tensile strength is shown in newtons and pounds, and it indicates the minimum acceptable force to break or separate the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

Wire Size (AWG)	Minimum Pull (UL486)	
	N	Lb.
2	2,446	550

CRIMP MEASUREMENT

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

Terminal Series No.	Wire Size	Wire Size	Crimp Height (Ref)		Crimp Width (Ref)	
	AWG	mm ²	mm	In.	mm	In.
204608	2	—	6.35-6.50	.250-.256	10.20-10.40	.401-.410
217884						
220719						



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

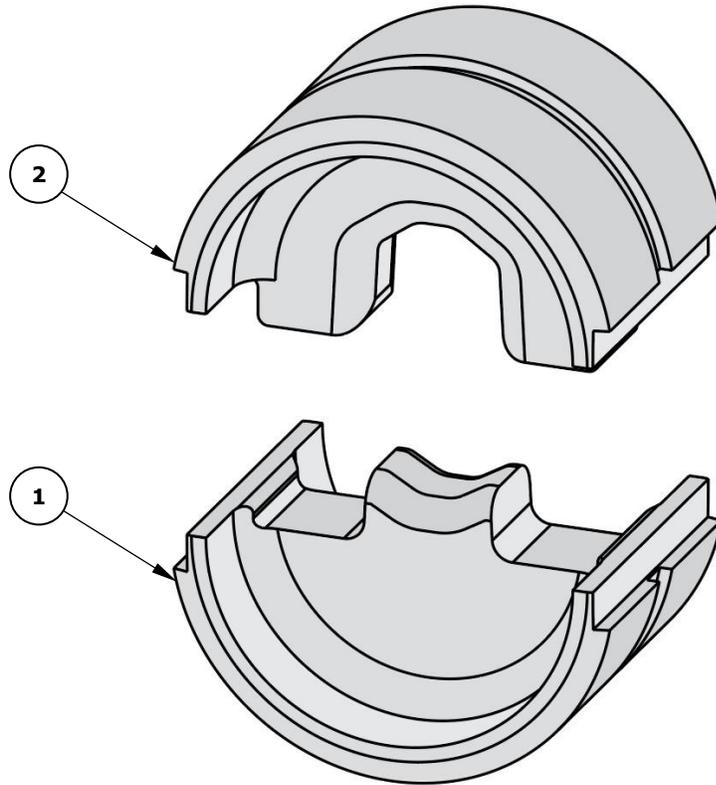


Figure 1

Application Tooling Support

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Website: www.molex.com/applicationtooling

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