

Order Number
213938-0220



Application Tooling Specification

TOOLING

- The square DIN-style die sets are used with two machines, and each machine requires an adapter for the square DIN dies. The Molex Pneumatic Universal Crimp Machine (63801-8900) will process the square DIN-style die sets with the 63801-8901 adapter.
- The Molex 12-ton battery crimp tool (63816-1000) will process the square DIN-style die sets with the 63816-1100 adapter.
- Refer to the appropriate crimper instruction manual for installation and operation information.

SCOPE

Products: 3.4 PowerWise BMI for 8 AWG wire.

Terminal Series No.	Terminal Order No.	Wire Size		Strip Length	
		AWG	mm ²	mm	In.
204608	204608-3011	8	-	11.00-11.50	.433-.453

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.

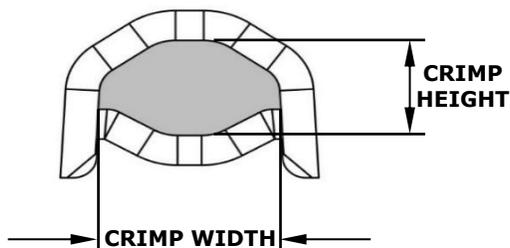
Wire Size (AWG)	Minimum Pull (Military)	
	N	Lb.
8	1,000	225

CRIMP MEASUREMENT

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

Terminal Series No.	Wire Size		Crimp Height (Ref)		Crimp Width (Ref)	
	AWG	mm ²	mm	In.	mm	In.
204608	8	—	4.04-4.14	.159-.163	6.60-6.70	.259-.264

CRIMP PROFILE



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

PARTS LIST

Item Number	Order Number	Engineering No.	Description	Quantity
	213938-0220	213938-0220	Crimp Tooling Kit: 8 AWG	REF
1	213938-0016	213938-0016	Conductor Punch	1
2	213938-0017	213938-0017	Conductor Anvil	1

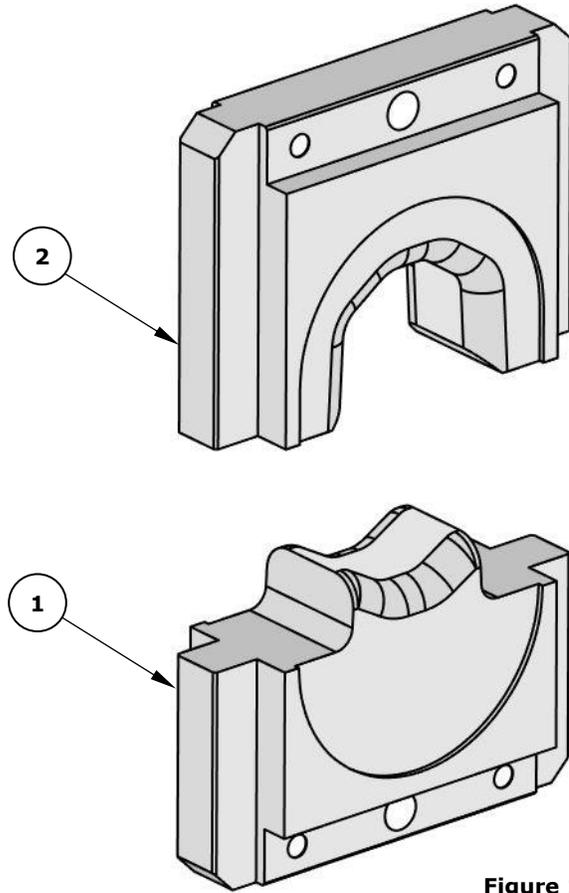


Figure 1

Application Tooling Support

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