

PUTT PUMP DIELESS HEAD CRIMPER
With Swivel Bench Adapter and Terminal Locator
Instruction Manual
Order No. 19286-0065
Engineering. No. PDDLHBA-CS
For Insulated and Non-Insulated Terminal and Splices

- Description
- Operation
- Maintenance

Table of Contents

SECTION

- 1 Safety Warnings
- 2 General Description
- 3 Setup and Adjustments
- 4 Terminal Specifications and Crimping Operation
- 5 Maintenance
- 6 Parts List, Assembly Drawings and Troubleshooting

WARNING

MOLEX CANNOT BE RESPONSIBLE FOR DAMAGE OR INJURY RESULTING FROM UNSAFE PRODUCT USE, LACK OF MAINTENANCE, OR INCORRECT PRODUCT AND SYSTEM APPLICATION.

All WARNINGS must be carefully observed to help prevent personal injury.

AIR/HYDRAULIC PUMP

HAND/FOOT OPERATED - MAXIMUM CAPACITY:
10,000 PSI

WARNING Before operating the hydraulic pump, all hose connections must be tightened with proper tools. Do not over-tighten. Connections need only be tightened securely and leak-free. Over-tightening may cause premature thread failure or may cause high-pressure fittings to split at pressures lower than their rated capacities.

WARNING Should a hydraulic hose ever rupture, burst, or need to be disconnected, immediately shut off the pump and shift the control valve twice to release all pressure. Never attempt to grasp a leaking hose under pressure with your hands. The force of escaping hydraulic fluid could cause serious injury.

WARNING Do not subject the hose to potential hazard such as fire, extreme heat or cold, sharp surfaces, or heavy impact. Do not allow the hose to kink, twist, curl, or bend so tightly that the oil flow within the hose is blocked or reduced. Periodically inspect the hose for wear because any of these conditions can damage the hose and possibly result in personal injury.

WARNING Do not use the hose to move attached equipment. Stress may damage hose and possibly cause personal injury.

WARNING Hose material and coupler seals must be compatible with the hydraulic fluid used. Hoses must not encounter corrosive materials such as creosote-impregnated objects and some paints. Consult the

manufacturer before painting a hose. Never paint the couplers. Hose deterioration due to corrosive materials may result in possible personal injury.

Pump

WARNING Do not exceed the PSI hydraulic rating noted on the pump nameplate or tamper with the internal high pressure relief valve. Creating pressure beyond rated capacities may result in personal injury.

WARNING Before replenishing the oil level, retract the system to prevent overfilling the pump reservoir. An overfill may cause personal injury due to excess reservoir pressure created when cylinders are retracted.

Cylinder

WARNING Do not exceed rated capacities of the cylinders. Excess pressure may result in personal injury.

WARNING Do not set poorly balanced or off-center loads on a cylinder. The load may tip and cause personal injury.

Air Supply

WARNING Shut off and disconnect the air supply when the pump is not in use or before breaking any connection in the system.

WARNING If the swivel base-mounting plate is to be removed from the DLH (19078-0478) crimping head, unscrew the M5 X 20 SHCS from the swivel base. Remove the M6 X 50 SHCS with the nut and replace with an M6 X 25 SHCS.

WARNING MOLEX SPECIFICATIONS ARE VALID ONLY WHEN USED WITH MOLEX TERMINALS AND TOOLING.

WORK SAFELY AT ALL TIMES

**For Service, Contact Your
Local Molex Sales Office**

**Molex Application Tooling Group
2200 Wellington Court
Lisle, Illinois 60532
Tel: 630-969-4550
Fax: 630-505-0049**

Section 2

General Description

- 2.1 Description
- 2.2 Features
- 2.3 Technical Specifications
- 2.4 Delivery Check
- 2.5 Tools

Principal Mechanical Parts of the 19286-0065 (PPDLHBA-CS)

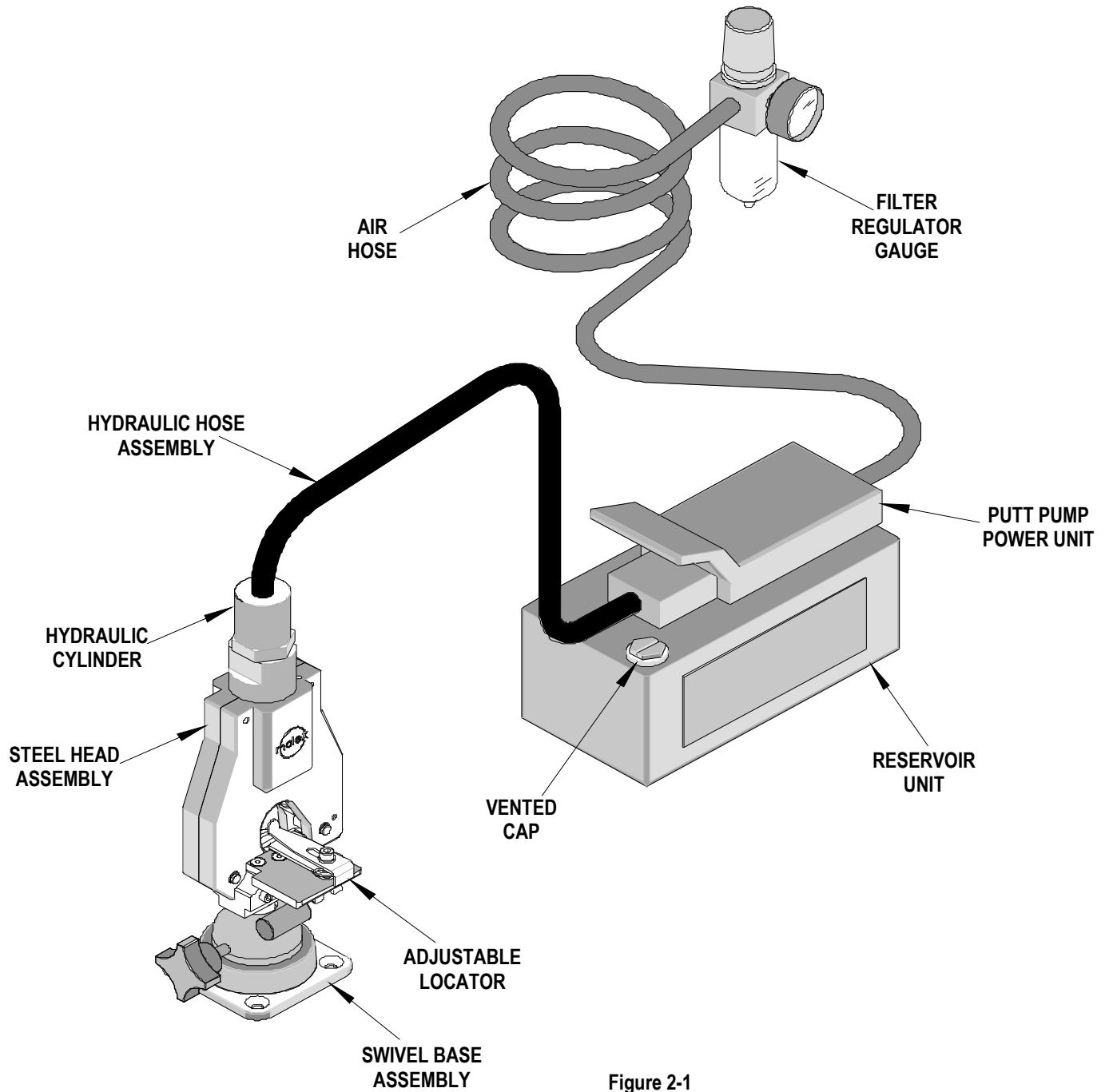


Figure 2-1

General Description

2.1 Description (See Figure 2-1)

The Molex Putt Pump Dieless Head Crimper is a combination Air and Hydraulic crimping system which utilizes four crimp “nibs” (3 moving and one stationary). The three movable nibs close against the terminal, which nests on the fourth nib, creating crimp indentations from the top, bottom and both sides, resulting in a four sided (quad) crimp.

The operator adjusts the air pressure thru the air gauge to produce the proper crimp.

This tool is designed to crimp 8 AWG to 500MCM insulated and uninsulated terminals and splices.

This tool is also designed to crimp 8 AWG to 500MCM heavy duty compression terminals and connectors. These terminals are used for electrical and industrial applications such as generators, switch gear, transformers, motor controls, power distribution equipment, welding equipment, telecommunications and utilities.

2.2 Features

- Crimps a wide range of products and does not require die set changes, which reduce the overall cost and provides production flexibility.
- Swivel base and terminal locator included to provide the operator with a user-friendly tool to increase productivity.
- Complete lightweight system that allows tool to be moved and stored easily.

2.3 Technical Specification

Pneumatic:

Supply Pressure: 100 PSI (6.9 Bars)
 Air Pressure: 125-PSI max. (8.6 Bars max.)
 Cycle Time: 15 seconds

2.4 Delivery Check

Carefully remove the Putt Pump Dieless Head from its shipping container and determine that the following items are included in the package.

Description	Quantity
19286-0029 Swivel Base Mount	1
19286-0200 Steel Head Assembly	1
19286-0059 PuttPump Power Unit with hoses	1
19286-0049 Filter regulator with gauge	1
TM-192860065 Instruction Manual	1

2.5 Tools

The following tools are recommended for setup and adjustments.

- ✓ Metric standard hex wrench set
- ✓ Adjustable wrench
- ✓ Wire stripper / cutter

Section 3

Set-Up and Adjustments

- 3.1. Setup
- 3.2. Adjustments
- 3.3. Alternative Pump Settings

3.1 Set-Up

Caution: Always disconnect the air pressure until the system is ready to operate.

The principal mechanical parts of the 19286-0065 are illustrated in Section 6 Assembly Drawings.

Air Supply Hook-Up

1. Select the 1/4 NPT threaded fittings that are compatible with your air supply.
2. Next install the fittings to the filter, regulator, gauge unit. The air supply should be 20 CFM (550 L/M) and 100 PSI (6.9 Bars) to obtain the rated hydraulic output. Air pressure should be regulated to a maximum of 125 PSI (8.6 Bars). See Figure 3-1.

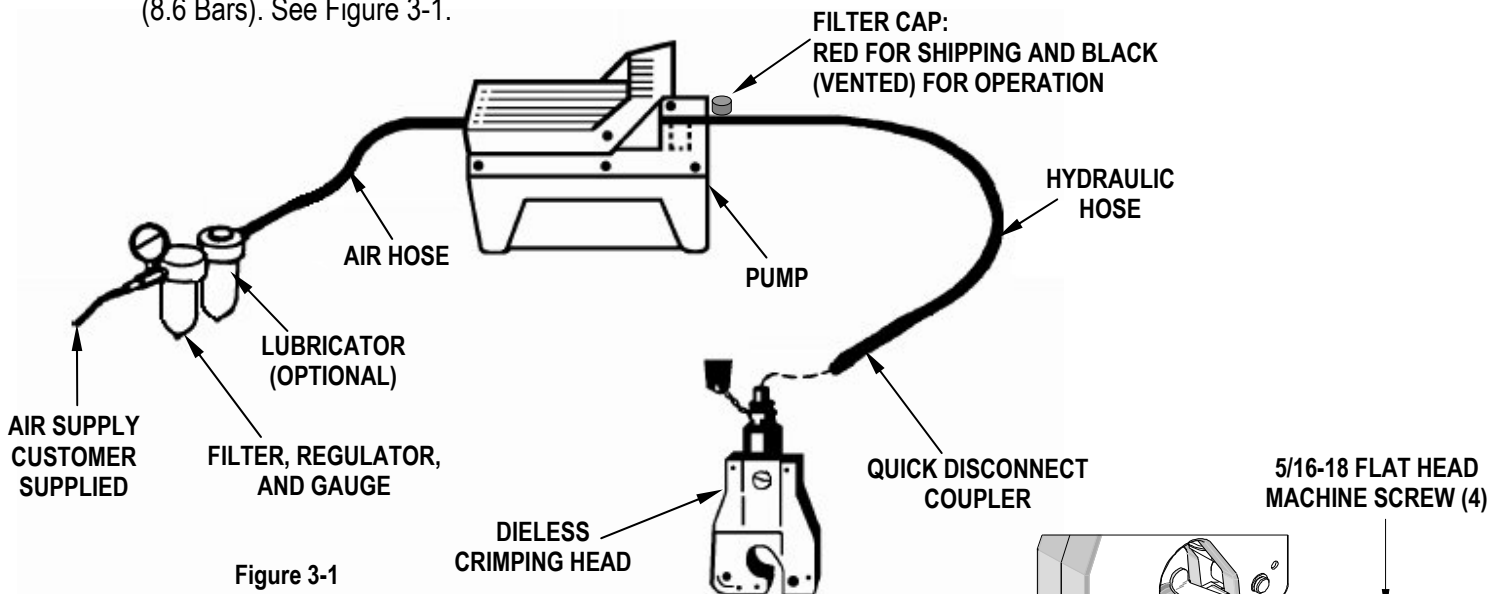


Figure 3-1

Hydraulic Connections and Bench Mounting

1. Remove the dust cap from the cylinder on the crimp head.
2. Connect the quick disconnect coupler onto the cylinder inlet on the crimp head. See figure 3-1.
3. Replace the red filler cap on the pump reservoir with the black vented cap that is supplied with the unit.
4. Before attempting to crimp any terminals, be sure the Swivel Base is securely fastened to a clean, sturdy work bench or table in a well-lighted area. Fasten the base with four 5/16-18 flat head machine screws, nuts and washers of sufficient length for the table top. (Not supplied). See Figure 3-2.

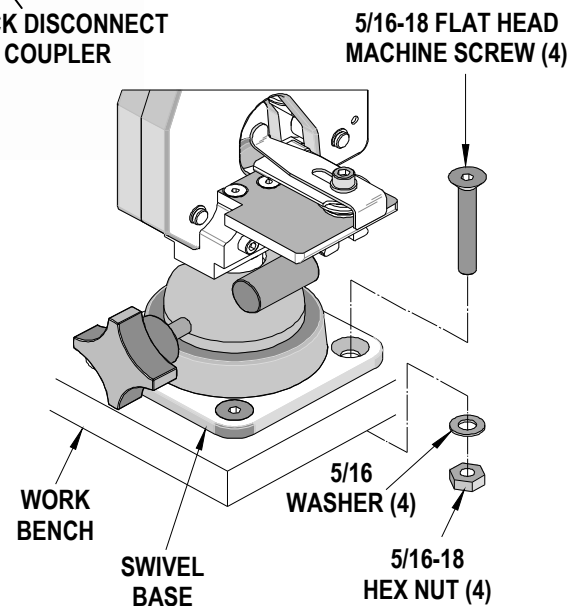


Figure 3-2

WARNING: Seal all external pipe connections with a high quality, non-hardening pipe sealant. Teflon tape may also be used to seal hydraulic connections if only one layer of tape is used.

3.2. Adjustments

Recommended air pressure gauge settings to obtain proper crimp on noninsulated and insulated terminals and splices.

Wire Size (AWG)	*SPX Power Team Pump	Pump Output Hydraulic Pressure (Ref.)	DLH Head Crimp Pressure (Ref.)
8	40 PSI	4000 PSI	4960 PSI
6	45 PSI	4500 PSI	5580 PSI
4	50 PSI	5000 PSI	6200 PSI
2	55 PSI	5500 PSI	6820 PSI
1	65 PSI	6500 PSI	8060 PSI
1/0	65 PSI	6500 PSI	8060 PSI
2/0	70 PSI	7000 PSI	8680 PSI
3/0	75 PSI	7500 PSI	9300 PSI
4/0	75 PSI	7500 PSI	9300 PSI
250 MCM	85 PSI	8500 PSI	10,540 PSI
300 MCM	90 PSI	9000 PSI	11,160 PSI
350 MCM	90 PSI	9000 PSI	11,160 PSI
400 MCM	100 PSI	10,000 PSI	12,400 PSI
500 MCM	100 PSI	10,000 PSI	12,400 PSI

*The SPX Power Team pump is currently shipped with the 19286-0065 tool. This pump has a 100:1 oil / air pressure ratio at the outlet hose with a 10,000 max. safety, regardless of air input. The pressure ratio at the crimp dies is 124:1 (6.2 ton max.)

3.3. Alternative Pump Settings

The following chart shows the pressure settings for other equivalent pumps. (Ref. only)

Wire Size (AWG)	OTC Pump	Enerpac Turbo Pump
8	30 PSI	21 PSI
6	35 PSI	25 PSI
4	40 PSI	28 PSI
2	45 PSI	32 PSI
1	60 PSI	42 PSI
1/0	60 PSI	42 PSI
2/0	65 PSI	46 PSI
3/0	70 PSI	50 PSI
4/0	70 PSI	50 PSI
250 MCM		
300 MCM		
350 MCM		
400 MCM		
500 MCM		

Section 4

Terminal Specifications and Crimping Operation

- 4.1 Scope
- 4.2 Terminal Specifications Chart
- 4.3 Crimping Terminals

4.1 SCOPE

Heavy Duty Compression Terminals and Connectors 8 AWG to 500 MCM. Standard and Long Barrel with one to two holes for copper conductors only.

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, which indicates the minimum acceptable force to break or separate the terminal from the conductor.

Wire Size (AWG)	Color Code	*UL – 486A
8	Red	90
6	Blue	100
4	Gray	140
2	Brown	180
1	Green	200
1/0	Pink	250
2/0	Black	300
3/0	Orange	350
4/0	Purple	450
250 MCM	Yellow	
300 MCM	White	
350 MCM	Red	
400 MCM	Blue	
500 MCM	Brown	

*UL – 486A – Terminals (Copper Conductors Only)

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.

4.2 Terminal Chart

Wire Size: 8 AWG 8.50mm ²					
Terminal No.	Terminal Eng No. (REF)	Wire Strip Length		Insulation Diameter Maximum	
		In	mm	In	mm
19063-0006	D-750-10	.438	11.11	.265	6.73
19063-0009	D-750-14	.438	11.11	.265	6.73
19063-0012	D-750-56	.438	11.11	.265	6.73
19063-0019	D-750-38	.438	11.11	.265	6.73
19063-0021	D-750-56	.438	11.11	.265	6.73
19063-0025	D-752-10	.438	11.11	.265	6.73
19063-0026	D-752-12	.438	11.11	.265	6.73
19063-0028	D-752-14	.438	11.11	.265	6.73
19063-0029	D-752-38	.438	11.11	.265	6.73
19063-0031	D-752-58	.438	11.11	.265	6.73
19063-0032	D-752-78	.438	11.11	.265	6.73
19063-0033	D-753-12	.438	11.11	.265	6.73
19063-0035	D-753-34	.438	11.11	.265	6.73
19063-0036	D-753-38	.438	11.11	.265	6.73
19063-0038	D-753-58	.438	11.11	.265	6.73
19063-0040	D-756-06	.438	11.11	.265	6.73
19063-0042	D-756-08	.438	11.11	.265	6.73

Wire Size: 8 AWG 8.50mm ²					
Terminal No.	Terminal Eng No. (REF)	Wire Strip Length		Insulation Diameter Maximum	
		In	mm	In	mm
19063-0044	D-756-10	.438	11.11	.265	6.73
19063-0046	D-756-14	.438	11.11	.265	6.73
19067-0001	D-950-06	.438	11.11	.350	8.89
19067-0003	D-950-08	.438	11.11	.350	8.89
19067-0006	D-950-10	.438	11.11	.350	8.89
19067-0008	D-950-14	.438	11.11	.350	8.89
19067-0012	D-950-56	.438	11.11	.350	8.89
19067-0016	D-951-10	.438	11.11	.350	8.89
19067-0018	D-951-14	.438	11.11	.350	8.89
19067-0022	D-951-38	.438	11.11	.350	8.89
19067-0025	D-951-56	.438	11.11	.350	8.89
19067-0028	D-952-12	.438	11.11	.350	8.89
19067-0030	D-952-38	.438	11.11	.350	8.89
19067-0031	D-952-76	.438	11.11	.350	8.89
19067-0032	D-953-12	.438	11.11	.350	8.89
19067-0033	D-953-34	.438	11.11	.350	8.89
19067-0034	D-953-58	.438	11.11	.350	8.89

DLH-Putt Pump Dieless Head Crimper

Wire Size: 8 AWG 8.50mm ²					
Terminal No.	Terminal Eng No. (REF)	Wire Strip Length		Insulation Diameter Maximum	
		In	mm	In	mm
19067-0035	D-956-06	.438	11.11	.350	8.89
19067-0037	D-956-08	.438	11.11	.350	8.89
19067-0039	D-956-10	.438	11.11	.350	8.89
19067-0041	D-956-14	.438	11.11	.350	8.89
19067-0128	D-951-76	.438	11.11	.350	8.89
19067-0129	D-952-58	.438	11.11	.350	8.89
19071-0132	D-650-06X	.438	11.11	.385	9.77
19071-0134	D-650-08X	.438	11.11	.385	9.77
19071-0136	D-650-10X	.438	11.11	.385	9.77
19071-0140	D-650-14X	.438	11.11	.385	9.77
19071-0144	D-650-56X	.438	11.11	.385	9.77
19071-0146	D-651-10X	.438	11.11	.385	9.77
19071-0148	D-651-14X	.438	11.11	.385	9.77
19071-0150	D-651-38X	.438	11.11	.385	9.77
19071-0153	D-651-56X	.438	11.11	.385	9.77
19071-0156	D-651-76X	.438	11.11	.385	9.77
19071-0158	D-652-10X	.438	11.11	.385	9.78
19071-0161	D-652-14X	.438	11.11	.385	9.78
19071-0162	D-652-38X	.438	11.11	.385	9.78
19071-0163	D-652-56X	.438	11.11	.385	9.78
19071-0164	D-652-58X	.438	11.11	.385	9.78
19071-0166	D-652-76X	.438	11.11	.385	9.78
19071-0168	D-653-12X	.438	11.11	.385	9.78
19071-0169	D-653-14X	.438	11.11	.385	9.78
19071-0170	D-653-34X	.438	11.11	.385	9.78
19071-0171	D-653-38X	.438	11.11	.385	9.78
19071-0172	D-653-56X	.438	11.11	.385	9.78
19071-0173	D-653-58X	.438	11.11	.385	9.78
19071-0174	D-653-76X	.438	11.11	.385	9.78
19071-0176	D-656-06X	.438	11.11	.385	9.78
19071-0178	D-656-08X	.438	11.11	.385	9.78
19071-0180	D-656-10X	.438	11.11	.385	9.78
19071-0182	D-656-14X	.438	11.11	.385	9.78
19071-0334	D-652-12X	.438	11.11	.385	9.78
19154-0041	D-654X	.375	9.53	.385	9.78
19193-0143	D-350-06	.438	11.11	N/A	N/A
19193-0146	D-350-08	.438	11.11	N/A	N/A
19193-0149	D-350-10	.438	11.11	N/A	N/A
19193-0152	D-350-14	.438	11.11	N/A	N/A
19193-0157	D-350-56	.438	11.11	N/A	N/A
19193-0159	D-351-10	.438	11.11	N/A	N/A
19193-0163	D-351-14	.438	11.11	N/A	N/A
19193-0167	D-351-38	.438	11.11	N/A	N/A
19193-0171	D-351-56	.438	11.11	N/A	N/A
19193-0175	D-351-76	.438	11.11	N/A	N/A
19193-0178	D-352-10	.438	11.11	N/A	N/A
19193-0179	D-352-12	.438	11.11	N/A	N/A
19193-0182	D-352-14	.438	11.11	N/A	N/A
19193-0184	D-352-38	.438	11.11	N/A	N/A
19193-0185	D-352-56	.438	11.11	N/A	N/A
19193-0186	D-352-58	.438	11.11	N/A	N/A
19193-0187	D-352-76	.438	11.11	N/A	N/A
19193-0190	D-353-12	.438	11.11	N/A	N/A
19193-0191	D-353-14	.438	11.11	N/A	N/A
19193-0192	D-353-34	.438	11.11	N/A	N/A
19193-0193	D-353-38	.438	11.11	N/A	N/A
19193-0194	D-353-56	.438	11.11	N/A	N/A
19193-0195	D-353-58	.438	11.11	N/A	N/A
19193-0196	D-353-76	.438	11.11	N/A	N/A
19193-0198	D-356-06	.438	11.11	N/A	N/A
19193-0200	D-356-08	.438	11.11	N/A	N/A
19193-0202	D-356-10	.438	11.11	N/A	N/A
19193-0204	D-356-14	.438	11.11	N/A	N/A
19202-0054	D-754	.375	9.53	.265	6.73
19205-0004	D-355	.312	7.92	N/A	N/A

Wire Size: 8 AWG 8.50mm ²					
Terminal No.	Terminal Eng No. (REF)	Wire Strip Length		Insulation Diameter Maximum	
		In	mm	In	mm
19215-0034	D-354	.375	9.53	.170	4.32
19221-0167	HDC-8102-CC	.610	15.49	N/A	N/A
19221-0212	HDC-810-CC	.516	13.11	N/A	N/A
19221-0223	BCL-810-PL	.438	11.11	N/A	N/A
19221-0224	BCL-814-PL	.438	11.11	N/A	N/A
19221-0225	BCL-8516-PL	.438	11.11	N/A	N/A
19221-0226	BCL-838-WP-PL	.438	11.11	N/A	N/A
19221-0290	HDCL-8102-CC	.915	23.24	N/A	N/A
19221-0315	HDCL-810-CC	.984	24.99	N/A	N/A

Wire Size: 6 AWG 16.50mm ²					
Terminal No.	Terminal Eng No. (REF)	Wire Strip Length		Insulation Diameter Maximum	
		In	mm	In	mm
19063-0048	E-757-08	.468	11.88	.350	8.89
19063-0050	E-757-10	.468	11.88	.350	8.89
19063-0052	E-757-14	.468	11.88	.350	8.89
19063-0054	E-757-38	.468	11.88	.350	8.89
19063-0056	E-757-56	.468	11.88	.350	8.89
19063-0059	E-757-76	.468	11.88	.350	8.89
19063-0061	E-758-10	.468	11.88	.350	8.89
19063-0062	E-758-12	.468	11.88	.350	8.89
19063-0063	E-758-14	.468	11.88	.350	8.89
19063-0064	E-758-38	.468	11.88	.350	8.89
19063-0065	E-758-56	.468	11.88	.350	8.89
19063-0066	E-758-58	.468	11.88	.350	8.89
19063-0067	E-758-76	.468	11.88	.350	8.89
19063-0069	E-760-08	.468	11.88	.350	8.89
19063-0071	E-760-10	.468	11.88	.350	8.89
19063-0073	E-760-14	.468	11.88	.350	8.89
19063-0076	E-760-56	.468	11.88	.350	8.89
19067-0043	E-957-08	.468	11.88	.428	10.87
19067-0045	E-957-10	.468	11.88	.428	10.87
19067-0047	E-957-14	.468	11.88	.428	10.87
19067-0052	E-957-38	.468	11.88	.428	10.87
19067-0055	E-957-56	.468	11.88	.428	10.87
19067-0059	E-957-76	.468	11.88	.428	10.87
19067-0061	E-958-12	.468	11.88	.428	10.87
19067-0062	E-958-14	.468	11.88	.428	10.87
19067-0063	E-958-38	.468	11.88	.428	10.87
19067-0064	E-958-58	.468	11.88	.428	10.87
19067-0065	E-958-76	.468	11.88	.428	10.87
19067-0067	E-960-08	.468	11.88	.428	10.87
19067-0069	E-960-10	.468	11.88	.428	10.87
19067-0071	E-960-14	.468	11.88	.428	10.87
19067-0073	E-960-56	.468	11.88	.428	10.87
19071-0185	E-657-08X	.468	11.88	.440	11.17
19071-0188	E-657-10X	.468	11.88	.440	11.17
19071-0190	E-657-14X	.468	11.88	.440	11.17
19071-0193	E-657-38X	.468	11.88	.440	11.17
19071-0196	E-657-56X	.468	11.88	.440	11.17
19071-0200	E-658-10X	.468	11.88	.440	11.17
19071-0201	E-658-12X	.468	11.88	.440	11.17
19071-0203	E-658-14X	.468	11.88	.440	11.17
19071-0204	E-658-38X	.468	11.88	.440	11.17
19071-0206	E-658-56X	.468	11.88	.440	11.17
19071-0207	E-658-58X	.468	11.88	.440	11.17
19071-0208	E-658-76X	.468	11.88	.440	11.17
19071-0218	E-660-08X	.468	11.88	.440	11.17
19071-0221	E-660-10X	.468	11.88	.440	11.17
19071-0225	E-660-14X	.468	11.88	.440	11.17
19071-0229	E-660-56X	.468	11.88	.440	11.17
19154-0045	E-662X	.438	11.11	.440	11.17
19193-0206	E-357-08	.468	11.88	N/A	N/A
19193-0209	E-357-10	.468	11.88	N/A	N/A

DLH-Putt Pump Dieless Head Crimper

Wire Size: 6 AWG 16.50mm ²					
Terminal No.	Terminal Eng No. (REF)	Wire Strip Length		Insulation Diameter Maximum	
		In	mm	In	mm
19193-0212	E-357-14	.468	11.88	N/A	N/A
19193-0216	E-357-38	.468	11.88	N/A	N/A
19193-0219	E-357-56	.468	11.88	N/A	N/A
19193-0225	E-358-10	.468	11.88	N/A	N/A
19193-0226	E-358-12	.468	11.88	N/A	N/A
19193-0229	E-358-14	.468	11.88	N/A	N/A
19193-0230	E-358-38	.468	11.88	N/A	N/A
19193-0232	E-358-56	.468	11.88	N/A	N/A
19193-0233	E-358-58	.468	11.88	N/A	N/A
19193-0234	E-358-76	.468	11.88	N/A	N/A
19193-0236	E-359-12	.468	11.88	N/A	N/A
19193-0237	E-359-14	.468	11.88	N/A	N/A
19193-0238	E-359-34	.468	11.88	N/A	N/A
19193-0239	E-359-34	.468	11.88	N/A	N/A
19193-0240	E-359-56	.468	11.88	N/A	N/A
19193-0241	E-359-58	.468	11.88	N/A	N/A
19193-0242	E-359-76	.468	11.88	N/A	N/A
19193-0243	E-360-08	.468	11.88	N/A	N/A
19193-0245	E-360-10	.468	11.88	N/A	N/A
19193-0248	E-360-14	.468	11.88	N/A	N/A
19193-0251	E-360-56	.468	11.88	N/A	N/A
19193-0252	E-360-56R90	.468	11.88	N/A	N/A
19202-0055	E-762	.438	11.11	.342	8.68
19205-0006	E-361	.375	9.52	N/A	N/A
19215-0040	E-362	.438	11.11	N/A	N/A
19221-0168	HDC-6142-CC	.540	13.71	N/A	N/A
19221-0213	HDC-614-CC	.547	13.90	N/A	N/A
19221-0215	HDC-610-CC	.547	13.90	N/A	N/A
19221-0227	BCL-614-WP-PL	.468	11.88	N/A	N/A
19221-0228	BCL-6516-WP-PL	.468	11.88	N/A	N/A
19221-0229	BCL-638-WP-PL	.468	11.88	N/A	N/A
19221-0291	HDCL-6142-CC	.670	17.02	N/A	N/A
19221-0316	HDCL-614-CC	1.047	26.59	N/A	N/A

Wire Size: 4 AWG 25.00mm ²					
Terminal No.	Terminal Eng No. (REF)	Wire Strip Length		Insulation Diameter Maximum	
		In	mm	In	mm
19067-0088	F-970-34	.531	13.48	.520	13.20
19067-0089	F-970-58	.531	13.48	.520	13.20
19071-0231	F-666-10X	.531	13.48	.515	13.08
19071-0234	F-666-12X	.531	13.48	.515	13.08
19071-0237	F-666-14X	.531	13.48	.515	13.08
19071-0240	F-666-38X	.531	13.48	.515	13.08
19071-0243	F-666-56X	.531	13.48	.515	13.08
19071-0247	F-666-76X	.531	13.48	.515	13.08
19071-0250	F-667-10X	.531	13.48	.515	13.08
19071-0253	F-667-14X	.531	13.48	.515	13.08
19071-0255	F-667-56X	.531	13.48	.515	13.08
19154-0082	F-664X	.453	11.50	.605	15.36
19193-0254	F-366-10	.531	13.48	N/A	N/A
19193-0258	F-366-12	.531	13.48	N/A	N/A
19193-0261	F-366-14	.531	13.48	N/A	N/A
19193-0264	F-366-38	.531	13.48	N/A	N/A
19193-0267	F-366-56	.531	13.48	N/A	N/A
19193-0270	F-366-76	.531	13.48	N/A	N/A
19193-0273	F-367-10	.531	13.48	N/A	N/A
19193-0275	F-367-14	.531	13.48	N/A	N/A
19193-0278	F-367-56	.531	13.48	N/A	N/A
19193-0281	F-369-12	.531	13.48	N/A	N/A
19193-0282	F-369-14	.531	13.48	N/A	N/A
19193-0283	F-369-38	.531	13.48	N/A	N/A
19193-0284	F-369-56	.531	13.48	N/A	N/A
19193-0285	F-369-58	.531	13.48	N/A	N/A
19193-0286	F-369-76	.531	13.48	N/A	N/A
19193-0287	F-370-12	.531	13.48	N/A	N/A
19193-0288	F-370-14	.531	13.48	N/A	N/A
19193-0289	F-370-34	.531	13.48	N/A	N/A
19193-0291	F-370-38	.531	13.48	N/A	N/A
19193-0292	F-370-56	.531	13.48	N/A	N/A
19193-0293	F-370-58	.531	13.48	N/A	N/A
19193-0294	F-370-76	.531	13.48	N/A	N/A
19202-0085	F-764	.531	13.48	.429	10.89
19205-0086	F-365	.531	13.48	N/A	N/A
19215-0089	F-364	.531	13.48	N/A	N/A
19221-0169	HDC-4142-CC	.610	15.49	N/A	N/A
19221-0170	HDC-45162-CC	.610	15.49	N/A	N/A
19221-0214	HDC-414-CC	.594	15.09	N/A	N/A
19221-0216	HDC-410-CC	.594	15.09	N/A	N/A
19221-0217	HDC-4516-CC	.610	15.49	N/A	N/A
19221-0230	BCL-414-PL	.500	12.70	N/A	N/A
19221-0231	BCL-4516-PL	.500	12.70	N/A	N/A
19221-0232	BCL-438-PL	.500	12.70	N/A	N/A
19221-0292	HDCL-4142-CC	1.047	26.58	N/A	N/A
19221-0317	HDCL-414-CC	1.047	26.59	N/A	N/A

Wire Size: 4 AWG 25.00mm ²					
Terminal No.	Terminal Eng No. (REF)	Wire Strip Length		Insulation Diameter Maximum	
		In	mm	In	mm
19063-0078	F-766-10	.531	13.48	.432	10.97
19063-0079	F-766-12	.531	13.48	.432	10.97
19063-0080	F-766-14	.531	13.48	.432	10.97
19063-0081	F-766-38	.531	13.48	.432	10.97
19063-0082	F-766-56	.531	13.48	.432	10.97
19063-0083	F-766-76	.531	13.48	.432	10.97
19063-0084	F-767-10	.531	13.48	.432	10.97
19063-0085	F-767-14	.531	13.48	.432	10.97
19063-0086	F-767-56	.531	13.48	.432	10.97
19063-0087	F-770-12	.531	13.48	.432	10.97
19063-0088	F-770-14	.531	13.48	.432	10.97
19063-0089	F-770-34	.531	13.48	.432	10.97
19063-0090	F-770-38	.531	13.48	.432	10.97
19063-0091	F-770-56	.531	13.48	.432	10.97
19063-0092	F-770-76	.531	13.48	.432	10.97
19067-0075	F-966-10	.531	13.48	.520	13.20
19067-0076	F-966-12	.531	13.48	.520	13.20
19067-0077	F-966-14	.531	13.48	.520	13.20
19067-0078	F-966-38	.531	13.48	.520	13.20
19067-0079	F-966-56	.531	13.48	.520	13.20
19067-0080	F-966-76	.531	13.48	.520	13.20
19067-0081	F-967-10	.531	13.48	.520	13.20
19067-0082	F-967-14	.531	13.48	.520	13.20
19067-0084	F-967-56	.531	13.48	.520	13.20
19067-0085	F-969-12	.531	13.48	.520	13.20
19067-0086	F-969-38	.531	13.48	.520	13.20
19067-0087	F-969-58	.531	13.48	.520	13.20

Wire Size: 2 AWG 35.00mm ²					
Terminal No.	Terminal Eng No. (REF)	Wire Strip Length		Insulation Diameter Maximum	
		In	mm	In	mm
19063-0093	G-774-12	.578	14.68	.525	13.33
19063-0094	G-774-14	.578	14.68	.525	13.33
19063-0095	G-774-38	.578	14.68	.525	13.33
19063-0096	G-774-56	.578	14.68	.525	13.33
19063-0097	G-774-58	.578	14.68	.525	13.33
19063-0098	G-774-76	.578	14.68	.525	13.33
19063-0099	G-775-12	.578	14.68	.525	13.33
19063-0100	G-775-14	.578	14.68	.525	13.33
19063-0101	G-775-38	.578	14.68	.525	13.33
19063-0102	G-775-56	.578	14.68	.525	13.33
19063-0103	G-775-58	.578	14.68	.525	13.33
19063-0104	G-775-76	.578	14.68	.525	13.33
19063-0111	G-777-12	.578	14.68	.525	13.33

DLH-Putt Pump Dieless Head Crimper

Wire Size: 2 AWG 35.00mm ²					
Terminal No.	Terminal Eng No. (REF)	Wire Strip Length		Insulation Diameter Maximum	
		In	mm	In	mm
19063-0112	G-777-14	.578	14.68	.525	13.33
19063-0113	G-777-34	.578	14.68	.525	13.33
19063-0114	G-777-38	.578	14.68	.525	13.33
19063-0115	G-777-56	.578	14.68	.525	13.33
19063-0116	G-777-58	.578	14.68	.525	13.33
19063-0117	G-777-76	.578	14.68	.525	13.33
19067-0090	G-974-12	.578	14.68	.600	15.24
19067-0091	G-974-14	.578	14.68	.600	15.24
19067-0092	G-974-38	.578	14.68	.600	15.24
19067-0093	G-974-56	.578	14.68	.600	15.24
19067-0094	G-974-76	.578	14.68	.600	15.24
19067-0095	G-975-10	.578	14.68	.600	15.24
19067-0096	G-975-14	.578	14.68	.600	15.24
19067-0097	G-975-38	.578	14.68	.600	15.24
19067-0098	G-975-56	.578	14.68	.600	15.24
19067-0099	G-977-34	.578	14.68		
19067-0100	G-977-58	.578	14.68		
19067-0105	G-776-12	.578	14.68	.525	13.33
19067-0106	G-776-14	.578	14.68	.525	13.33
19067-0107	G-776-38	.578	14.68	.525	13.33
19067-0108	G-776-56	.578	14.68	.525	13.33
19067-0109	G-776-58	.578	14.68	.525	13.33
19067-0110	G-776-76	.578	14.68	.525	13.33
19067-0130	G-974-58	.578	14.68	.600	15.24
19071-0272	G-674-12X	.578	14.68	.655	16.63
19071-0273	G-674-14X	.578	14.68	.655	16.63
19071-0275	G-674-38X	.578	14.68	.655	16.63
19071-0276	G-674-56X	.578	14.68	.655	16.63
19071-0277	G-674-58X	.578	14.68	.655	16.63
19071-0278	G-674-76X	.578	14.68	.655	16.63
19071-0279	G-675-10X	.578	14.68	.655	16.63
19071-0281	G-675-14X	.578	14.68	.655	16.63
19071-0283	G-675-38X	.578	14.68	.655	16.63
19071-0285	G-675-56X	.578	14.68	.655	16.63
19071-0287	G-675-76X	.578	14.68	.655	16.63
19071-0289	G-676-12X	.578	14.68	.655	16.63
19071-0290	G-676-14X	.578	14.68	.655	16.63
19071-0291	G-676-38X	.578	14.68	.655	16.63
19071-0292	G-676-56X	.578	14.68	.655	16.63
19071-0293	G-676-58X	.578	14.68	.655	16.63
19071-0294	G-676-76X	.578	14.68	.655	16.63
19071-0295	G-677-12X	.578	14.68	.655	16.63
19071-0296	G-677-14X	.578	14.68	.655	16.63
19071-0297	G-677-34X	.578	14.68	.655	16.63
19071-0298	G-677-38X	.578	14.68	.655	16.63
19071-0299	G-677-56X	.578	14.68	.655	16.63
19071-0300	G-677-58X	.578	14.68	.655	16.63
19071-0301	G-677-76X	.578	14.68	.655	16.63
19154-0049	G-672X	.531	13.48	.650	16.51
19193-0296	G-374-12	.578	14.68	N/A	N/A
19193-0297	G-374-14	.578	14.68	N/A	N/A
19193-0298	G-374-38	.578	14.68	N/A	N/A
19193-0299	G-374-56	.578	14.68	N/A	N/A
19193-0301	G-374-58	.578	14.68	N/A	N/A
19193-0302	G-374-76	.578	14.68	N/A	N/A
19193-0303	G-375-10	.578	14.68	N/A	N/A
19193-0305	G-375-14	.578	14.68	N/A	N/A
19193-0307	G-375-38	.578	14.68	N/A	N/A
19193-0309	G-375-56	.578	14.68	N/A	N/A
19193-0311	G-375-76	.578	14.68	N/A	N/A
19193-0318	G-377-12	.578	14.68	N/A	N/A
19193-0319	G-377-14	.578	14.68	N/A	N/A
19193-0320	G-377-34	.578	14.68	N/A	N/A
19193-0321	G-377-38	.578	14.68	N/A	N/A
19193-0322	G-377-56	.578	14.68	N/A	N/A

Wire Size: 2 AWG 35.00mm ²					
Terminal No.	Terminal Eng No. (REF)	Wire Strip Length		Insulation Diameter Maximum	
		In	mm	In	mm
19193-0324	G-377-76	.578	14.68	N/A	N/A
19193-0611	G-377-76	.578	14.68	N/A	N/A
19202-0057	G-772	.531	13.48	.509	12.92
19205-0008	G-373	.578	14.68	N/A	N/A
19215-0046	G-372	.531	13.48	N/A	N/A
19221-0171	HDC-2142-CC			N/A	N/A
19221-0172	HDC-25162-CC	.780	19.81	N/A	N/A
19221-0218	HDC-214-CC	.547	13.90	N/A	N/A
19221-0219	HDC-2516-CC	.547	13.90	N/A	N/A
19221-0220	HDC-238-CC	.657	16.69	N/A	N/A
19221-0233	BCL-2516-PL	.593	15.06	N/A	N/A
19221-0235	BCL-238-PL	.593	15.06	N/A	N/A
19221-0236	BCL-212-WP-PL	.593	15.06	N/A	N/A
19221-0293	HDCL-2142-CC	1.052	26.72	N/A	N/A
19221-0294	HDCL-25162-CC	1.052	26.72	N/A	N/A
19221-0323	HDCL-214-CC	1.266	32.16	N/A	N/A
19221-0324	HDCL-2516-CC	1.266	32.16	N/A	N/A

Wire Size: 1 AWG 42.5mm ²					
Terminal No.	Terminal Eng No. (REF)	Wire Strip Length		Insulation Diameter Maximum	
		In	mm	In	mm
19221-0173	HDC-1142-CC	.420	10.67	N/A	N/A
19221-0174	HDC-15162-CC	.770	19.56	N/A	N/A
19221-0221	HDC-114-CC	.750	19.05	N/A	N/A
19221-0237	BCL-1516-PL	.656	16.66	N/A	N/A
19221-0238	BCL-138-PL	.656	16.66	N/A	N/A
19221-0239	BCL-112-PL	.656	16.66	N/A	N/A
19221-0271	HDC-1516-CC	.750	19.05	N/A	N/A
19221-0272	HDC-138-CC	.750	19.05	N/A	N/A
19221-0273	HDC-112-CC	.750	19.05	N/A	N/A
19221-0295	HDCL-1142-CC	1.410	35.81	N/A	N/A
19221-0296	HDCL-15162-CC	1.410	35.81	N/A	N/A
19221-0334	HDCL-114-CC			N/A	N/A
19221-0335	HDCL-1516-CC			N/A	N/A

Wire Size: 1/0 AWG 50.00mm ²					
Terminal No.	Terminal Eng No. (REF)	Wire Strip Length		Insulation Diameter Maximum	
		In	mm	In	mm
19063-0118	H-780-12	.765	19.43	.595	15.11
19063-0119	H-780-14	.765	19.43	.595	15.11
19063-0120	H-780-38	.765	19.43	.595	15.11
19063-0121	H-780-56	.765	19.43	.595	15.11
19063-0122	H-780-76	.765	19.43	.595	15.11
19063-0123	H-781-14	.765	19.43	.595	15.11
19063-0124	H-781-38	.765	19.43	.595	15.11
19063-0125	H-781-56	.765	19.43	.595	15.11
19063-0126	H-782-14	.765	19.43	.595	15.11
19063-0127	H-782-38	.765	19.43	.595	15.11
19063-0128	H-782-56	.765	19.43	.595	15.11
19067-0101	H-980-38	.765	19.43	.680	17.27
19067-0102	H-980-76	.765	19.43	.680	17.27
19067-0315	H-980-12	.765	19.43	.680	17.27
19071-0302	H-680-76X	.765	19.43	.680	17.27
19071-0303	H-681-14X	.765	19.43	.680	17.27
19071-0305	H-681-38X	.765	19.43	.680	17.27
19071-0306	H-681-56X	.765	19.43	.680	17.27
19071-0308	H-682-12X	.765	19.43	.680	17.27
19071-0336	H-682-34X	.765	19.43	.680	17.27
19071-0337	H-682-38X	.765	19.43	.680	17.27
19071-0338	H-682-58X	.765	19.43	.680	17.27
19193-0325	H-380-12	.765	19.43	N/A	N/A
19193-0326	H-380-14	.765	19.43	N/A	N/A

DLH-Putt Pump Dieless Head Crimper

Wire Size: 1/0 AWG 50.00mm ²					
Terminal No.	Terminal Eng No. (REF)	Wire Strip Length		Insulation Diameter Maximum	
		In	mm	In	mm
19193-0327	H-380-38	.765	19.43	N/A	N/A
19193-0328	H-380-56	.765	19.43	N/A	N/A
19193-0329	H-380-76	.765	19.43	N/A	N/A
19193-0330	H-381-14	.765	19.43	N/A	N/A
19193-0331	H-381-38	.765	19.43	N/A	N/A
19193-0333	H-381-56	.765	19.43	N/A	N/A
19193-0556	H-381-12	.765	19.43	N/A	N/A
19202-0058	H-783	.578	14.68	.590	14.98
19205-0009	H-384	.718	18.23	N/A	N/A
19215-0047	H-383	.625	15.88	N/A	N/A
19221-0176	HDC-10382-CC	1.070	27.18	N/A	N/A
19221-0240	BCL-10516-PL	.703	17.85	N/A	N/A
19221-0241	BCL-1038-PL	.703	17.85	N/A	N/A
19221-0274	HDC-1014-CC	.875	22.23	N/A	N/A
19221-0275	HDC-10516-CC	.875	22.23	N/A	N/A
19221-0276	HDC-1038-CC	.875	22.23	N/A	N/A
19221-0277	HDC-1012-CC	.875	22.23	N/A	N/A
19221-0297	HDCL-105162-CC	1.520	38.61	N/A	N/A
19221-0298	HDCL-10382-CC	1.520	38.61	N/A	N/A
19221-0336	HDCL-10516-CC	1.406	35.71	N/A	N/A
19221-0337	HDCL-1038-CC	1.406	35.71	N/A	N/A
19221-0353	HDCL-105162-CC	.860	21.84	N/A	N/A

Wire Size: 2/0 AWG 70.00mm ²					
Terminal No.	Terminal Eng No. (REF)	Wire Strip Length		Insulation Diameter Maximum	
		In	mm	In	mm
19063-0129	J-785-12	.781	19.83	.675	17.14
19063-0130	J-785-14	.781	19.83	.675	17.14
19063-0131	J-785-38	.781	19.83	.675	17.14
19063-0132	J-785-56	.781	19.83	.675	17.14
19063-0133	J-785-76	.781	19.83	.675	17.14
19063-0134	J-787-12	.781	19.83	.675	17.14
19063-0135	J-787-34	.781	19.83	.675	17.14
19063-0136	J-787-58	.781	19.83	.675	17.14
19063-0137	J-787-78	.781	19.83	.675	17.14
19067-0109	J-985-12	.781	19.83	.765	19.43
19067-0110	J-985-14	.781	19.83	.765	19.43
19067-0111	J-985-38	.781	19.83	.765	19.43
19067-0112	J-985-56	.781	19.83	.765	19.43
19067-0113	J-985-76	.781	19.83	.765	19.43
19067-0114	J-987-12	.781	19.83	.765	19.43
19067-0115	J-987-34	.781	19.83	.765	19.43
19067-0116	J-987-58	.781	19.83	.765	19.43
19071-0309	J-685-12X	.781	19.83	.735	18.66
19071-0310	J-685-14X	.781	19.83	.735	18.66
19071-0311	J-685-38X	.781	19.83	.735	18.66
19071-0312	J-685-56X	.781	19.83	.735	18.66
19071-0313	J-685-76X	.781	19.83	.735	18.66
19071-0314	J-687-12X	.781	19.83	.675	17.14
19071-0339	J-687-34X	.781	19.83	.675	17.14
19071-0340	J-687-58X	.781	19.83	.675	17.14
19193-0341	J-385-12	.781	19.83	N/A	N/A
19193-0342	J-385-14	.781	19.83	N/A	N/A
19193-0345	J-385-38	.781	19.83	N/A	N/A
19193-0346	J-385-56	.781	19.83	N/A	N/A
19193-0348	J-385-76	.781	19.83	N/A	N/A
19193-0350	J-387-12	.781	19.83	N/A	N/A
19193-0351	J-387-34	.781	19.83	N/A	N/A
19193-0352	J-387-58	.781	19.83	N/A	N/A
19193-0353	J-387-78	.781	19.83	N/A	N/A
19202-0059	J-788	.688	17.47	.670	17.02
19205-0010	J-389	.718	18.23	N/A	N/A
19215-0048	J-388	.640	16.25	N/A	N/A
19221-0105	HDC-20516-CC	.985	25.02	N/A	N/A

Wire Size: 2/0 AWG 70.00mm ²					
Terminal No.	Terminal Eng No. (REF)	Wire Strip Length		Insulation Diameter Maximum	
		In	mm	In	mm
19221-0106	HDC-2038-CC	.985	25.02	N/A	N/A
19221-0107	HDC-2012-CC	.985	25.02	N/A	N/A
19221-0178	HDC-20382-CC	.980	24.90	N/A	N/A
19221-0179	HDC-20122-CC	.980	24.90	N/A	N/A
19221-0195	HDC-205162-CC	.980	24.90	N/A	N/A
19221-0243	BCL-20516-PL	.750	19.05	N/A	N/A
19221-0244	BCL-2038-PL	.750	19.05	N/A	N/A
19221-0245	BCL-2012-PL	.750	19.05	N/A	N/A
19221-0278	HDC-2014-CC	.985	25.02	N/A	N/A
19221-0299	HDCL-20382-CC	1.690	42.93	N/A	N/A
19221-0300	HDCL-20122-CC	1.690	42.93	N/A	N/A
19221-0338	HDCL-2038-CC	1.422	36.12	N/A	N/A
19221-0339	HDCL-2012-CC	1.422	36.12	N/A	N/A

Wire Size: 3/0 AWG 95.00mm ²					
Terminal No.	Terminal Eng No. (REF)	Wire Strip Length		Insulation Diameter Maximum	
		In	mm	In	mm
19202-0060	K-793	.640	16.25	.731	18.56
19205-0012	K-393	.672	17.06	N/A	N/A
19215-0049	K-394	.672	17.06	N/A	N/A
19221-0108	HDC-3014-CC	1.110	28.19	N/A	N/A
19221-0109	HDC-30516-CC	1.110	28.19	N/A	N/A
19221-0110	HDC-3038-CC	1.110	28.19	N/A	N/A
19221-0180	HDC-305162-CC	1.100	27.94	N/A	N/A
19221-0181	HDC-30382-CC	1.100	27.94	N/A	N/A
19221-0182	HDC-30122-CC	1.100	27.94	N/A	N/A
19221-0246	BCL-30516-PL	.812	20.63	N/A	N/A
19221-0247	BCL-3038-PL	.812	20.63	N/A	N/A
19221-0248	BCL-3012-PL	.812	20.63	N/A	N/A
19221-0301	HDCL-30382-CC	1.650	41.91	N/A	N/A
19221-0302	HDCL-30122-CC	1.650	41.91	N/A	N/A
19221-0325	HDCL-3038-CC	1.547	39.29	N/A	N/A
19221-0326	HDCL-3012-CC	1.547	39.29	N/A	N/A
19221-0355	HDC-3012-CC	1.110	28.19	N/A	N/A

Wire Size: 4/0 AWG 120.00mm ²					
Terminal No.	Terminal Eng No. (REF)	Wire Strip Length		Insulation Diameter Maximum	
		In	mm	In	mm
19202-0061	L-778	.750	19.05	.831	21.10
19205-0013	L-378	.750	19.05	N/A	N/A
19215-0050	L-379	.750	19.05	N/A	N/A
19221-0183	HDC-40382-CC	1.210	30.73	N/A	N/A
19221-0184	HDC-40122-CC	1.210	30.73	N/A	N/A
19221-0250	BCL-4038-PL	1.159	29.44	N/A	N/A
19221-0251	BCL-4012-PL	1.159	29.44	N/A	N/A
19221-0303	HDCL-40382-CC	1.880	47.75	N/A	N/A
19221-0304	HDCL-40122-CC	1.880	47.75	N/A	N/A
19221-0327	HDCL-4038-CC	1.843	46.81	N/A	N/A
19221-0328	HDCL-4012-CC	1.843	46.81	N/A	N/A
19221-0356	HDC-4014-CC	1.220	30.99	N/A	N/A
19221-0357	HDC-40516-CC	1.220	30.99	N/A	N/A
19221-0358	HDC-4038-CC	1.220	30.99	N/A	N/A
19221-0359	HDC-4012-CC	1.220	30.99	N/A	N/A

Wire Size: 250 MCM AWG 127.00mm ²					
Terminal No.	Terminal Eng No. (REF)	Wire Strip Length		Insulation Diameter Maximum	
		In	mm	In	mm
19221-0185	HDC-250382-CC	1.270	32.26	N/A	N/A
19221-0186	HDC-250122-CC	1.270	32.26	N/A	N/A
19221-0305	HDCL-250382-CC	1.870	47.50	N/A	N/A
19221-0306	HDCL-250122-CC	1.870	47.50	N/A	N/A

Wire Size: 250 MCM AWG 127.00mm ²					
Terminal No.	Terminal Eng No. (REF)	Wire Strip Length		Insulation Diameter Maximum	
		In	mm	In	mm
19221-0329	HDCL-25038-CC	2.093	53.16	N/A	N/A
19221-0330	HDCL-25012-CC	2.093	53.16	N/A	N/A
19221-0360	HDC-25038-CC	1.282	32.56	N/A	N/A
19221-0361	HDC-25012-CC	1.282	32.56	N/A	N/A

Wire Size: 300 MCM AWG 152.00mm ²					
Terminal No.	Terminal Eng No. (REF)	Wire Strip Length		Insulation Diameter Maximum	
		In	mm	In	mm
19221-0187	HDC-300382-CC	1.330	33.78	N/A	N/A
19221-0188	HDC-300122-CC	1.330	33.78	N/A	N/A
19221-0307	HDCL-300382-CC	2.060	52.32	N/A	N/A
19221-0308	HDCL-300122-CC	2.060	52.32	N/A	N/A
19221-0331	HDCL-30038-CC	2.235	56.77	N/A	N/A
19221-0332	HDCL-30012-CC	2.235	56.77	N/A	N/A
19221-0362	HDC-30038-CC	1.407	35.74	N/A	N/A
19221-0363	HDC-30012-CC	1.407	35.74	N/A	N/A
19221-0364	HDC-30058-CC	1.407	35.74	N/A	N/A

Wire Size: 350 MCM AWG 177.30mm ²					
Terminal No.	Terminal Eng No. (REF)	Wire Strip Length		Insulation Diameter Maximum	
		In	mm	In	mm
19221-0189	HDC-350382-CC	1.540	39.12	N/A	N/A
19221-0190	HDC-350122-CC	1.540	39.12	N/A	N/A
19221-0309	HDCL-350382-CC	2.210	56.13	N/A	N/A
19221-0310	HDCL-350122-CC	2.210	56.13	N/A	N/A
19221-0333	HDCL-35038-CC	2.931	74.45	N/A	N/A
19221-0340	HDCL-35012-CC	2.931	74.45	N/A	N/A
19221-0365	HDC-35012-CC	1.531	38.89	N/A	N/A

Wire Size: 350 MCM AWG 177.30mm ²					
Terminal No.	Terminal Eng No. (REF)	Wire Strip Length		Insulation Diameter Maximum	
		In	mm	In	mm
19221-0366	HDC-35058-CC	1.531	38.89	N/A	N/A

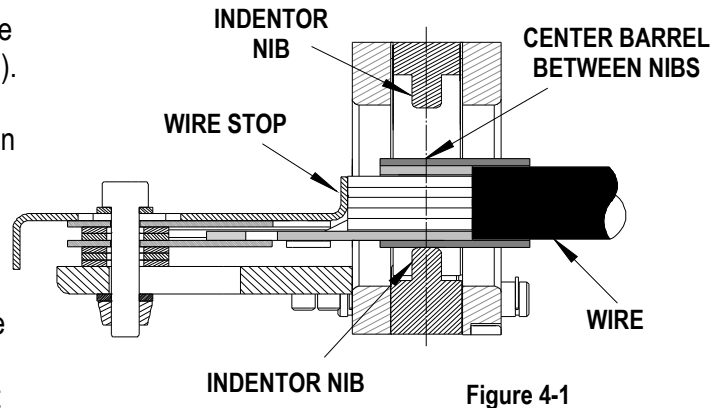
Wire Size: 400 MCM AWG 202.70 mm ²					
Terminal No.	Terminal Eng No. (REF)	Wire Strip Length		Insulation Diameter Maximum	
		In	mm	In	mm
19221-0191	HDC-400382-CC	1.590	40.37	N/A	N/A
19221-0192	HDC-400122-CC	1.590	40.37	N/A	N/A
19221-0311	HDCL-400382-CC	2.280	57.91	N/A	N/A
19221-0312	HDCL-400122-CC	2.280	57.91	N/A </td <td>N/A</td>	N/A
19221-0341	HDCL-40038-CC	2.469	62.71	N/A	N/A
19221-0342	HDCL-40012-CC	2.469	62.71	N/A	N/A
19221-0367	HDC-40012-CC	1.594	40.49	N/A	N/A
19221-0368	HDC-40058-CC	1.594	40.49	N/A	N/A

Wire Size: 500 MCM AWG 253.40 mm ²					
Terminal No.	Terminal Eng No. (REF)	Wire Strip Length		Insulation Diameter Maximum	
		In	mm	In	mm
19221-0193	HDC-500382-CC	1.810	45.97	N/A	N/A
19221-0194	HDC-500122-CC	1.810	45.97	N/A	N/A
19221-0313	HDCL-500382-CC	2.860	72.64	N/A	N/A
19221-0314	HDCL-500122-CC	2.860	72.64	N/A	N/A
19221-0343	HDCL-50038-CC	3.063	77.80	N/A	N/A
19221-0344	HDCL-50012-CC	3.063	77.80	N/A	N/A
19221-0369	HDC-50012-CC	1.907	48.44	N/A	N/A
19221-0370	HDC-50058-CC	1.797	45.64	N/A	N/A

4.3 Crimping Terminals

Before crimping, set the recommended air pressure gauge to obtain the proper crimp . See Section 3.2 (Adjustments).

1. Adjust wire stop to position terminal barrel centered on the Indentor nibs. See figure 4-.1
2. Adjust wire stop so conductor is visible beyond terminal barrel but not so far that it effects use of terminal.
3. Position the terminal in the locator as shown in Figure 4-2 and 4-3. Insert the properly stripped wire into the terminal barrel. The wire ends should butt up against the wire stop of the locator.



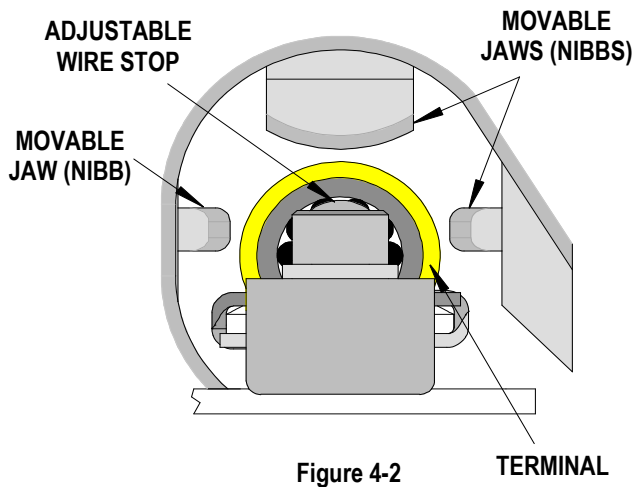


Figure 4-2

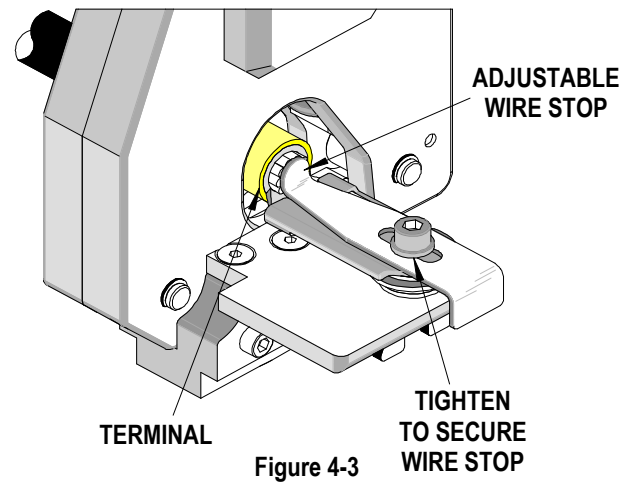


Figure 4-3

4. If the terminal is too big or the barrel of the terminal has a closed end, take off the locators and the wire stop. Position the terminal in the center of the jaws. Insert the properly stripped wire visually into the terminal barrel, as shown in Figure 4-4.
5. Depress the pedal on the putt pump to activate the jaws. The crimping process is done in small increments gradually allowing the press to fully crimp the terminal into the wire.
6. After the terminal is fully crimped, depress the elevated portion of the pedal to release the pump. This will allow the jaws to release.
7. Remove the crimp and inspect for proper crimp location.

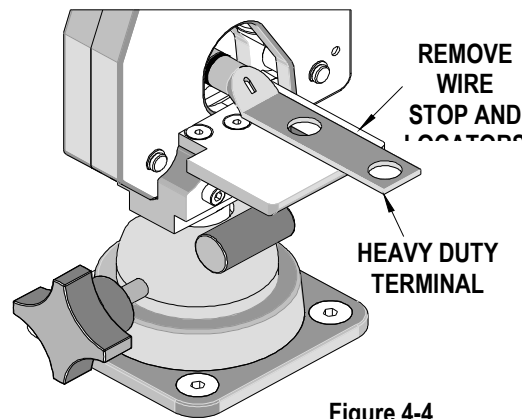


Figure 4-4

Section 5

Maintenance

- 5.1 Lubrication
- 5.2 Bleeding Air From the System
- 5.3 Inspecting the Hydraulic Fluid Level
- 5.4 Refilling the Reservoir
- 5.5 Periodic Cleaning
- 5.6 Spare Parts
- 5.7 Perishable Parts
- 5.8 Storage

5.1 Lubrication

WARNING: Any repair or servicing, which requires dismantling the pump must be performed in a dirt-free environment by a qualified technician.

CAUTION: Always disconnect power supply before all maintenance

If the pump is operated on a continuous duty cycle for extended periods, the manufacturer recommends an automatic air line oiler be installed in the air inlet as close to the pumping unit as possible.

Set the unit to feed approximately 1 drop of oil per minute into the system. Use SAE No. 10 oil.

5.2 Bleeding Air From The System

During the initial moments of activation or after prolonged use, a significant amount of air may accumulate within the hydraulic system. This entrapped air may cause the cylinder to respond slowly or behave in an unstable manner.

To remove the air, run the system through several cycles (extending and retracting the ram) free of any load. The rams must be at a lower level than the pump to allow air to be released through the pump reservoir.

5.3 Inspecting The Hydraulic Fluid Level

CAUTION: Always disconnect power supply before all maintenance

1. Check the oil level in the reservoir after every 10 hours of use.
2. The oil level should come to within 1/2" of the filler plug with all hoses attached.
3. Drain and replenish the reservoir with an approved, high-grade hydraulic oil such as OTC 16355 after every 300 hours of use.

Hoses: Hydraulic hoses on this unit carry a rating of 10,000 PSI.
Replacement hoses must carry the same rating.

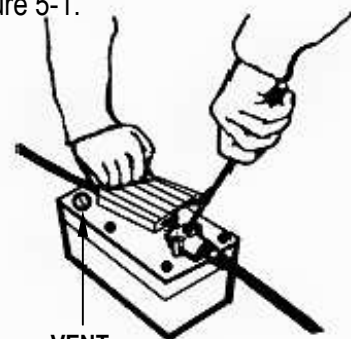
5.4 Refilling The Reservoir

CAUTION: Always disconnect power supply before all maintenance

1. If additional oil must be added to the reservoir, use only an approved high grade hydraulic oil such as OTC 16355 (215 SSU @ 100° F).
2. Clean the entire area around the filler plug before adding oil to the reservoir.
3. Remove the filler plug and insert a clean funnel with filter.
4. The ram must be fully retracted and the air supply disconnected when adding the oil to the reservoir.

5.5 Venting the Reservoir

To improve oil delivery and increase useable oil capacity, vent the reservoir by removing the vent screw from the filler plug before using the pump. See Figure 5-1.



VENT SCREW Figure 5-1

5.6 Priming the Pump Unit

If the pump unit must be primed, perform the following procedure:

1. Depress the release end of the pedal while holding down the air intake valve with a flathead screwdriver. See Figure 1-3. The air intake valve is located directly under the pedal in the area marked PUMP. This "button" is depressed simultaneously with the RELEASE area of the pedal during priming.

2. Allow the pump to cycle approximately 15 seconds.
3. Remove the screwdriver and depress the pump end of the pedal once more.
4. If the ram extends or pressure builds, the pump has been successfully primed.
5. If the pump does not respond, repeat the procedure, repeatedly jogging the air intake valve while holding the pedal in the RELEASE position.

A routine should be established to keep the pump as free from dirt as possible.

1. All unused couplers should be sealed with thread protectors.
2. All hose connections must be free of grit and grime.
3. Any equipment hooked up to the pump should also be kept clean.
4. Use only an approved, clean hydraulic oil, such as OTC 16355, in this unit and change as recommended (every 300 hours).

5.7 Periodic Cleaning

CAUTION: Always disconnect power supply before all maintenance

An example of a maintenance chart is shown below. Copy and use this chart to track the maintenance of your 19286-0065 or use this as a template to create you own schedule or use your company’s standard chart, if applicable.

Preventive Maintenance Chart

Daily: Clean. See Section 3.5.
As Required: Lubricate. See Section 3.1.

CHECK SHEET MONTH _____ YEAR _____

Week	Daily Use	Days of the Week							Solution
		MON	TUE	WED	THU	FRI	SAT	SUN	
1									
2									
3									
4									
Lubrication	1 drop per minute into the system								Use SAE No. 10 Oil
Change Hydraulic oil	300 Hours								Use OTC 16355
Bleeding Air From the System	After prolong use								Run the system thru several cycles.
Refilling Reservoir	10 hours or when needed								Use 215 SSU@100°F (otc 16355)
Cleaning	Hose connections free of grit and dirt. Pump kept clean								Use soft cloth

Schedule should be adjusted up or down depending on usage. Molex recommends that a log of preventive maintenance be kept with the tool.

Downloaded from Elcodis.com electronic components distributor

5.8 Spare Parts

Customers are responsible for maintaining the tool. Spare parts are available from Molex. Moving and functioning parts can be damaged or wear out over time and will require replacement. Molex recommends that the customer keep some or all of them in stock to reduce production down time. These parts are identified in the Parts List. See Section 6.

5.9 Perishable Parts

Customers are responsible for maintaining the 19286-0065. Perishable parts are those parts that come in contact with the product and will wear out over time. Molex recommends that all customers keep at least one set of the perishable tooling in stock at all times. This will reduce the amount of production down time.

5.10 Storage

When storing the 19286-0065 assembly, disconnect the air supply and store in a dry location. If the pump is disconnected from the dieless crimper, reinstall the dust cap on the cylinder inlet. When transporting, reinstall the red-vented cap on the pump reservoir.

Section 6

- 6.1. Parts Lists and Assembly Drawings
- 6.2. Troubleshooting

6.1 Main Parts List and Assembly Drawings

19286-0065 - Main Assembly Figure 6-1			
Item	Order No.	Description	Qty
1	19286-0041	Hydraulic Hose Assembly-6 Feet	1
2	19286-0049	Filter Regulator with Gauge	1
3	19286-0059	PuttPump Power Unit	1
4	19286-0103	Air Hose 1/4 NPT Male Fitting-10 Feet	1
5	19286-0106	Swivel Base Assembly	1 (Figure 6-2)
6	19286-0200	Steel Head Assembly	1 (Figure 6-3)
7	64016-0033	Hydraulic Cylinder	1
8	19078-0478	Steel head with Cylinder	Ref
-	63700-4979	Retract Spring for Item 7	Ref (Repair Part)

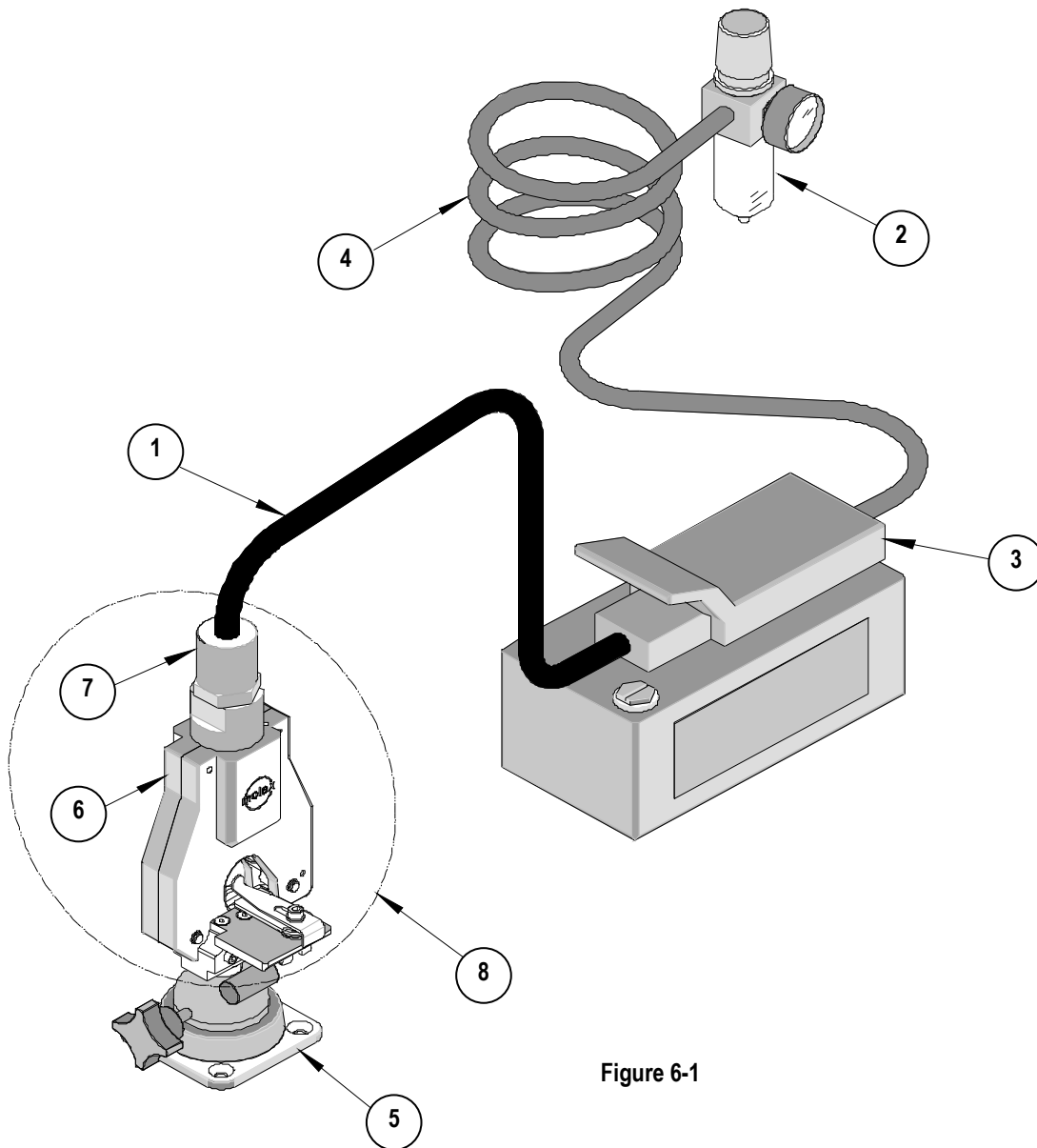


Figure 6-1

Swivel Base Parts List

19286-0106-Swivel Base Figure 6-2			
Item	Order No.	Description	Qty
1	19286-0016	Pivot Base	1
2	19286-0029	Base Adapter	1
3	19286-0030	Locator Mounting Base	1
4	19286-0037	Locator Half Adjustable	2
5	19286-0038	Adjustable Wire Stop	1
6	N/A	M5 by 20 Long SHCS	2**
7	N/A	M6 by 30 Long SHCS	1**
8	N/A	M6 by 55 Long SHCS	1**
9	N/A	M6 Nut	1**
10	N/A	M6 Wing Nut	1**
11	N/A	M6 Flat Washer	2**
12	N/A	M5 by 12 Long FHCS	2**
13	N/A	1/4 Flat Washer	5**

** Available from an industrial supply company such as MSC (1-800-645-7270).

Swivel Base Assembly

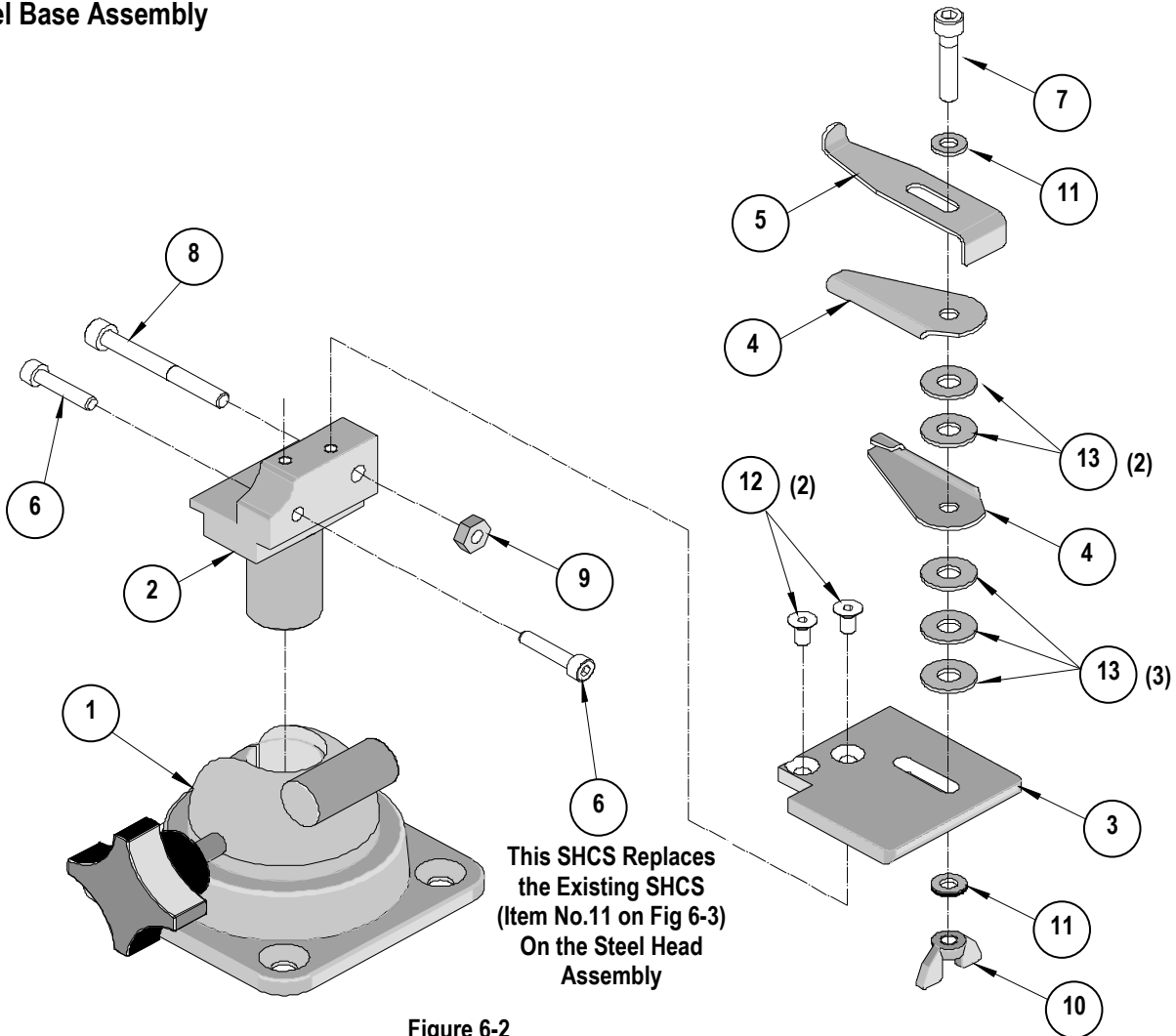


Figure 6-2

Steel Head Parts List

19286-0200-Steel Head Figure 6-3			
Item	Order No.	Description	Qty
1	19078-0754	Pivot Pin with Snap Rings	2 K
2	19078-0764	Fixed Jaw	1
3	19078-0765	Tool Cover "A" Steel	1
4	19078-0766	Tool Cover "B" Steel	1
5	19228-0386	Pivot Roller	2 K
6	19228-0387	Spring, Side Jaw (DHL UC-6)	2 K
7	19228-0390	Linear Bearing Assembly	2 K
8	19228-0391	Spring Guide Pin	2 K
9	19286-0023	Jaw Movable - Side	2
10	19286-0024	Jaw Movable - Top	1
11	N/A	M5 by 25 Long SHCS	2** K
12	N/A	M6 by 25 Long SHCS	3** K
13	N/A	2.5mm by 8 Long Roll Pin	2** K
REF	64000-0095	Repair Kit all "K" Items	

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

Steel Head Assembly

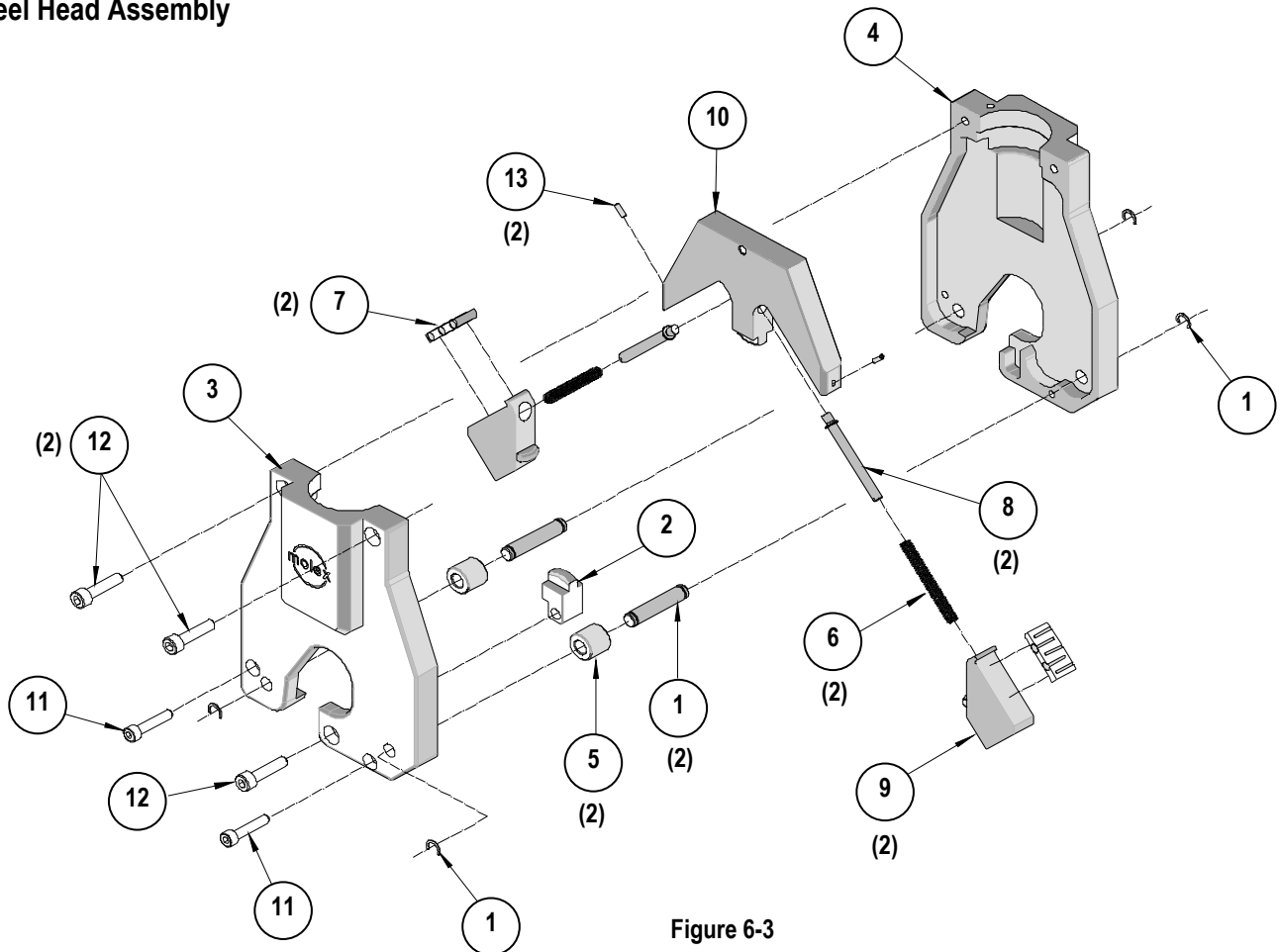


Figure 6-3

6.2 Troubleshooting

Symptom	Cause	Solution
Pump reciprocates but no oil delivery. (Ram will not extend)	▪ Low oil level.	Replenish oil reservoir.
	▪ Pump not primed.	Depress air intake valve and hydraulic release valve simultaneously.
	▪ Check oil filter for contamination.	Invert pump. Fill intake filter with oil. Depress pedal end marked "pump."
Low oil delivery. (Ram extends slowly)	▪ Reservoir not vented	Remove filter and clean.
	▪ Inadequate air supply: 1. Check air input supply. 2. Contamination, check air side of pump. Thoroughly inspect the slot in the air cylinder tube.	1. Should be 20 CFM minimum. 2. Clean and reassemble.
Pump will not build to maximum pressure. (No visible leakage)	▪ Hydraulic failure: 1. Check the oil filter for contamination. 2. Air in hydraulic system.	1. Clean and reinstall. 2. Bleed the system as described in "PREVENTATIVE MAINTENANCE" Section.
	▪ Check the air supply.	100 PSI is required to obtain maximum pressure.
Pump builds pressure but will not hold system pressure.	▪ Check hydraulic connections.	Refit as needed.

Americas Headquarters
Lisle, Illinois 60532 U.S.A.
1-800-78MOLEX
amerinfo@molex.com

Far East North Headquarters
Yamato, Kanagawa, Japan
81-462-65-2324
feninfo@molex.com

Far East South Headquarters
Jurong, Singapore
65-6-268-6868
fesinfo@molex.com

European Headquarters
Munich, Germany
49-89-413092-0
eurinfo@molex.com

Corporate Headquarters
2222 Wellington Ct.
Lisle, IL 60532 U.S.A.
630-969-4550
Fax: 630-969-1352

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

For more information use the Crimping Testing and Inspection Handbook for Industrial (Closed Barrel products).

There is no charge for this book, which can be found on the Molex Website (www.molex.com) or contact you local Molex sales engineer.

