


molex[®]




DLHH MANUAL CRIMP TOOL
Operation Manual
Engineering No. DLHH-CS
Order No. 19286-0107











For Insulated and Non-Insulated Terminal and Splices Instruction Manual

- Description
- Operation
- Maintenance

Safety Warnings and Information

	<p>Read and understand all of the instructions and safety information in this manual before operating or servicing this tool.</p> <p style="text-align: center;"><u>Keep this manual available when using this tool.</u></p> <p>Replacement manuals are available for download at no charge at www.molex.com.</p>
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SAFETY ALERT SYMBOL	
<p>This symbol is used to call your attention to hazards or unsafe practices which could result in an injury or property damage. The signal word, defined below, indicates the severity of the hazard. The message after the signal word provides information for preventing or avoiding the hazard.</p>	
 DANGER	<p>DANGER: Indicates an imminently hazardous situation which, if not avoided, could result in death or serious injury.</p>
 WARNING	<p>WARNING: Indicates a potentially hazardous situation which, if not avoided, could result in death or serious injury.</p>
 CAUTION	<p>CAUTION: Indicates a potentially hazardous situation which, if not avoided, may result in minor or moderate injury. CAUTION: may also be used to alert against unsafe practices associated with events that could lead to personal injury.</p>

	<p> WARNING</p> <p>Never operate, service, install, or adjust this machine without proper instruction and without first reading and understanding the instructions in this manual and all applicable tool manuals</p>		<p> WARNING</p> <p>Electric shock hazard: This tool is not insulated. When using this unit near energized electrical lines, use proper personal protective equipment. Failure to observe this warning could result in severe injury or death</p>
	<p> WARNING</p> <p>Pinch points: Keep hands away from the crimping head when crimping. Failure to observe this warning could result in severe injury or death.</p>		<p> WARNING</p> <p>Always wear proper eye protection when Operating or servicing this equipment. Failure to wear eye protection could result in serious eye injury from flying debris</p>
<p> WARNING</p> <p style="color: red;">Molex cannot be responsible for damage or injury resulting from unsafe product use, lack of maintenance, or incorrect product and system application.</p>			
<p> CAUTION</p> <p>Never perform any service or maintenance other than as described in this manual. Never modify, alter or misuse the equipment Molex crimp specifications are valid only when used with Molex terminals, applicators and tooling. Failure to observe this precaution may result in injury and property damage</p>			

Tooling Technical Assistance

Molex offers tooling technical assistance for customers who may need some guidance for tooling adjustments. This support can be obtained by calling either of the two numbers listed below and asking for the Molex Tooling Group.

Call Toll Free 1-800-786-6539 (US) 1-630-969-4550 (Global).

This assistance is limited to the operation and set-up of a customer's Tool. Questions with regard to Molex connector products or how to identify the proper tooling and/ or tooling documentation should be directed to your local Molex personnel or Customer Service Representative.

When calling for service on the tool a copy of the Tooling Manual and Specific Applicator Tooling Specification Sheet should be present and a person that is familiar with the applicator should be present. Be sure the following information is supplied:

1. Customer name
2. Customer address
3. Person to contact such as (name, title, e-mail, and telephone number
4. Press order number (Lease number also if applicable)
5. Serial number (Lease number also if applicable)
6. Molex Connector product order number
7. Urgency of request
8. Nature of problem

Molex Application Tooling Group

2200 Wellington Court
Lisle, IL 60532, USA
Tel: +1 (630) 969-4550
Fax: +1 (630) 505-0049

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

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Section 1

General Description

- 1.1 Description
- 1.2 Features
- 1.3 Technical Specifications
- 1.4 Delivery Check
- 1.5 Tools

Principal Mechanical Parts of the 19286-0107 (DLHH-CS)

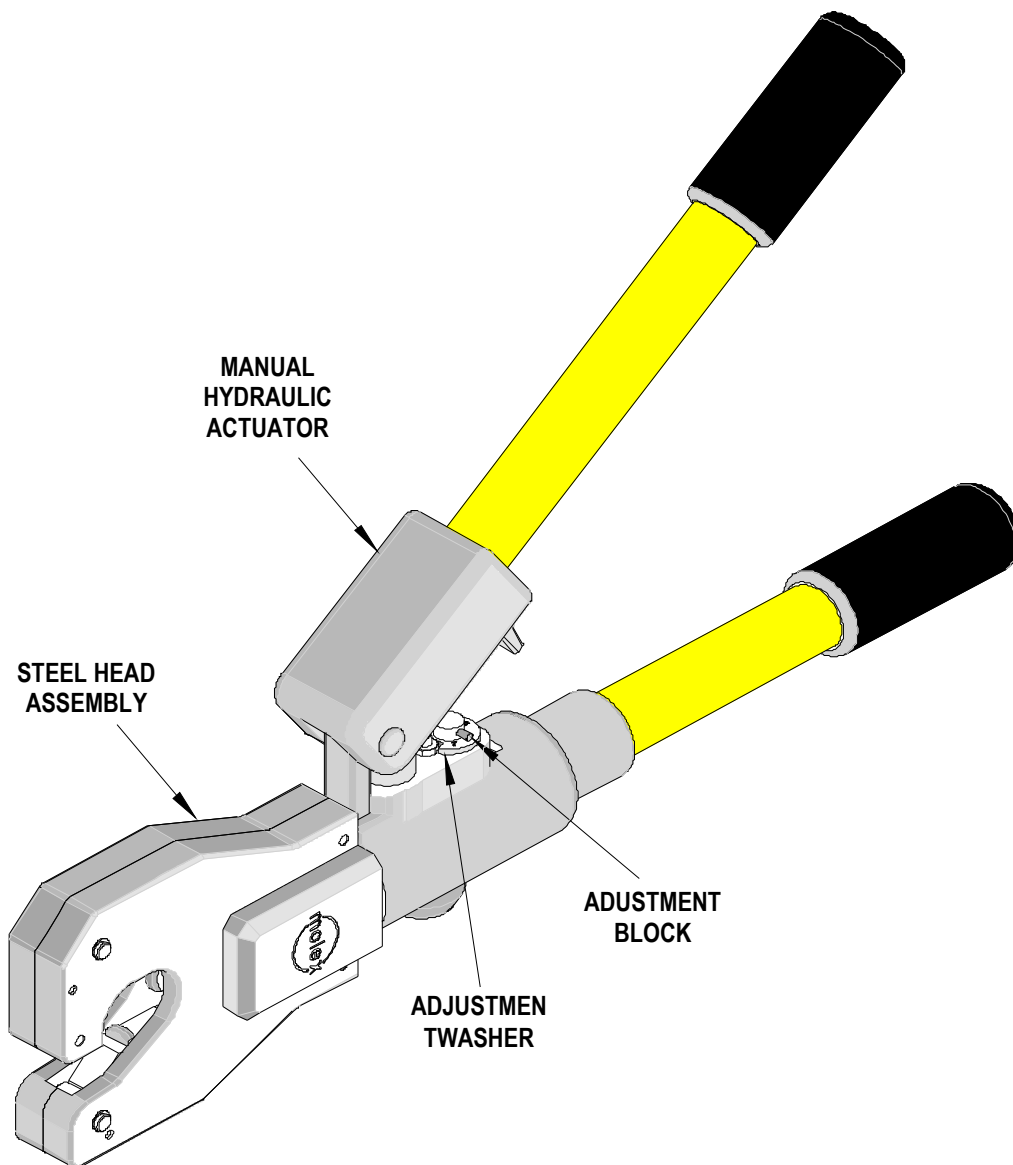


Figure 1-1

General Description

1.1 Description

(See Figure 1-1)

The Molex Manual Crimp Tool 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.

This tool is designed to crimp 8 to 4/0 AWG insulated and uninsulated terminals and splices.

This tool is also designed to crimp 6.2 tons of force on heavy duty compression terminals and connectors. These terminals are used for electrical and industrial applications.

1.2 Features

- Hand-held tool with 360 ° swivel head that permits use in confined areas
- Crimps a wide range of terminals for production flexibility
- External pressure adjustment allows operator to change settings easily
- Insulated fiberglass handles reduce shock hazard
- Steel carrying case included to prevent damage to the tool
- Versatile, lightweight and portable

1.3 Technical Specification

Dimensions

Width: 146mm (5.75")
Length: 559mm (22.0")

Weight

5.22kg (11.5lbs)

Force Output

6.2 tons @ 10,000 PSI

Handle Test Voltage (When New)

20 KV between grips and metal head

1.4 Delivery Check

Carefully remove the Manual Crimp Tool from its shipping container and determine that the following items are included in the package.

- ✓ Manual Crimp Tool
- ✓ Steel Carrying Case
- ✓ TM-192860107 Operation Manual

1.5 Tools

The following tools are recommended for setup and adjustments to the applicator in this press

1. Metric standard hex wrench set
2. Adjustable wrench
3. Wire stripper / cutter

Section 2

Terminal Specifications and Crimping Operation

- 2.1 Scope
- 2.2 Terminal Specifications Chart
- 2.3 Crimping Terminals

2.1 Scope

Heavy Duty Compression Terminals and Connectors 8 to 4/0 AWG. Standard and Long Barrel 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

*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.

2.2 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
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

Wire Size: 8 AWG 8.50mm ²					
Terminal No.	Terminal Eng No. (REF)	Wire Strip Length		Insulation Diameter Maximum	
		In	mm	In	mm
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
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

Wire Size: 8 AWG 8.50mm ²					
Terminal No.	Terminal Eng No. (REF)	Wire Strip Length		Insulation Diameter Maximum	
		In	mm	In	mm
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
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

Wire Size: 8 AWG 8.50mm ²					
Terminal No.	Terminal Eng No. (REF)	Wire Strip Length		Insulation Diameter Maximum	
		In	mm	In	mm
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

Wire Size: 6 AWG 16.50mm ²					
Terminal No.	Terminal Eng No. (REF)	Wire Strip Length		Insulation Diameter Maximum	
		In	mm	In	mm
19193-0206	E-357-08	.468	11.88	N/A	N/A
19193-0209	E-357-10	.468	11.88	N/A	N/A
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
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

Wire Size: 4 AWG 25.00mm ²					
Terminal No.	Terminal Eng No. (REF)	Wire Strip Length		Insulation Diameter Maximum	
		In	mm	In	mm
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
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: 2 AWG 35.00mm ²					
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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
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

Wire Size: 2 AWG 35.00mm ²					
Terminal No.	Terminal Eng No. (REF)	Wire Strip Length		Insulation Diameter Maximum	
		In	mm	In	mm
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
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
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

Wire Size: 2/0 AWG 70.00mm ²					
Terminal No.	Terminal Eng No. (REF)	Wire Strip Length		Insulation Diameter Maximum	
		In	mm	In	mm
19063-0134	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
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

Wire Size: 3/0 AWG 95.00mm ²					
Terminal No.	Terminal Eng No. (REF)	Wire Strip Length		Insulation Diameter Maximum	
		In	mm	In	mm
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

2.3 Crimping Terminals

Before crimping, set the recommended adjustable bypass setting to the recommended number shown in the Adjustment Setting Chart below for the terminal size being used.

Adjustment Settings	
Wire Size (AWG)	Pressure Setting
8	3.0
6	3.5
4	4.0
2	4.5
1	6.0
1/0	6.0
2/0	6.5
3/0	7.0
4/0	7.0



WARNING: Electric shock hazard:

This tool is not insulated. When using this unit near energized electrical lines, use proper personal protective equipment. Failure to observe this warning could result in severe injury or death

1. The operation of the Manual Crimp Tool crimps terminals and sleeves that connect to wires up to 4/0. Up to 6.2 tons of force closes 3 moving indentors against one fixed indenter to assure compression consistency throughout the connection.



WARNING: Never place fingers into the tooling nest.

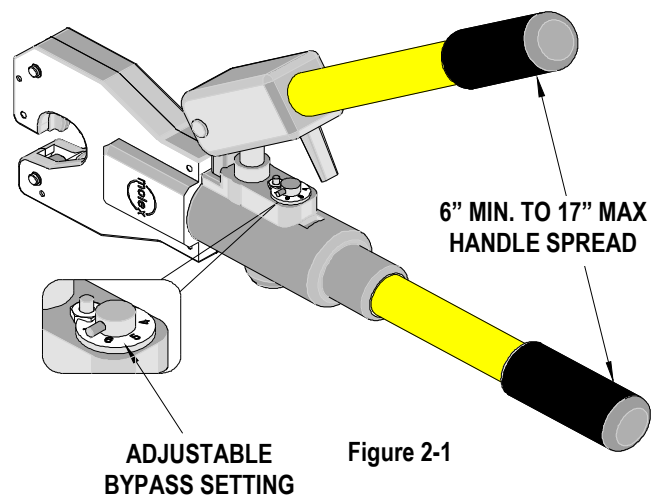


Figure 2-1

2. Position terminal between indentors and pump tool handle to hold terminal in place. Fully insert the wire or cable into barrel of terminal. Be sure the terminal is properly positioned in the center of the indentors. See Figure 2-2.
3. Continue to pump the tool handle and completely crimp the terminal. These tools have a built in bypass cartridge that will automatically activate when full pressure is reached. There will be a noticeable decrease in the handle pressure when the bypass is reached. A high pitched squeaking sound is normal when the tool is operating in the high pressure stage. The crimping process is done in small increments gradually allowing the steel head to fully crimp the terminal into the wire or cable.
4. To release the tool, lift pump handle and rotate clockwise until handle stops. With handle twisted, push down so the pin on the handle contacts the release pin on the tool body. See Figure 2-3. The ram will retract and the tool is ready to begin its next cycle. In the event the tool will not release due to excess flash, hold release pin down with handle and carefully pry tool jaws apart. See Figure 2-3.
5. Remove the crimp and inspect for proper crimp location.

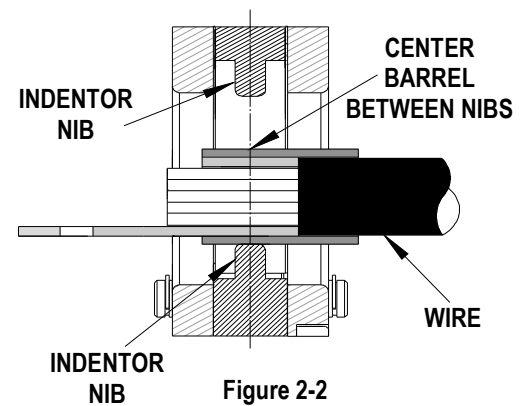


Figure 2-2

Notes:

Indentor hang up is common with all types of compression tools. Should this occur, the jaws can easily be separated by holding the pump handle in the release position while prying the jaws apart.



WARNING: Never attempt to hit the terminal or tool jaw with hammer as this will damage terminal and tool.

If tool fails to advance upon receipt or after an extended period of storage, invert tool and rap compression head sharply on ground. The suction valve check ball can become stuck after extended storage or during shipment, not allowing the tool to advance.

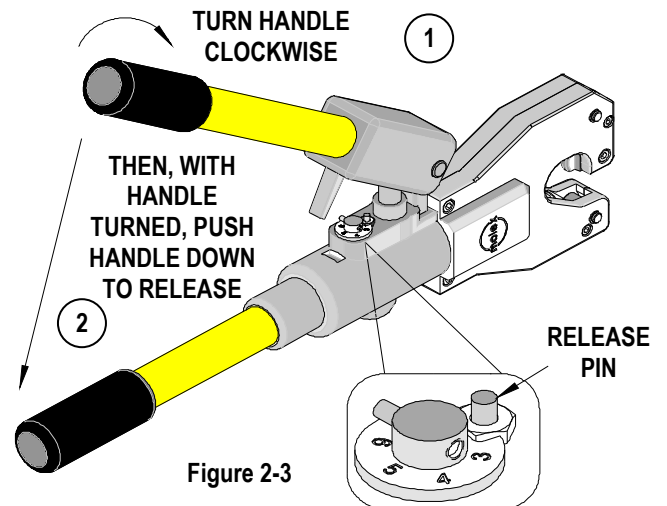


Figure 2-3

Section 3

Maintenance

- 3.1 General
- 3.2 Periodic Cleaning
- 3.3 Spare Parts
- 3.4 Perishable Parts
- 3.5 Storage

3.1 Periodic Cleaning



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

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

An example of a maintenance chart is shown below. Copy and use this chart to track the maintenance of your 19286-0107 Manual Crimp Tool or use this as a template to create you own schedule or use your company’s standard chart, if applicable.

Always clean tool after use and keep moving parts clear of dirt and debris.

Preventive Maintenance Chart

Daily: Clean. See Section 5.2.

CHECK SHEET MONTH _____ YEAR _____

Week	Daily Use	Days of the Week							Solution
		MON	TUE	WED	THU	FRI	SAT	SUN	
1									
2									
3									
4									
Cleaning	Daily								After use

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

3.2 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 5.

3.3 Perishable Parts

Customers are responsible for maintaining the Manual Crimp Tool. 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.

3.4 Storage

When storing the this tool, store in the steel carrying case in a dry location.

Section 5

- 4.1 Main Parts Lists and Assembly Drawings
- 4.2 Steel Head Parts Lists and Assembly Drawings
- 4.3 Troubleshooting

4.1 Main Parts List and Assembly Drawings

19286-0107 - Main Assembly Figure 5-1			
Item	Order No.	Description	Quantity
1	19286-0009	Adjustment Washer for DLHH	1
2	19286-0010	Adjustment Block for DLHH	1
3	19286-0200	Steel Head Assembly	1 (Figure 5-2)
4	64016-0043	Manual Hydraulic Actuator (DLHP)	1
5	N/A	#8-32 by 3/4" Long Socket Set Screw	1**

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

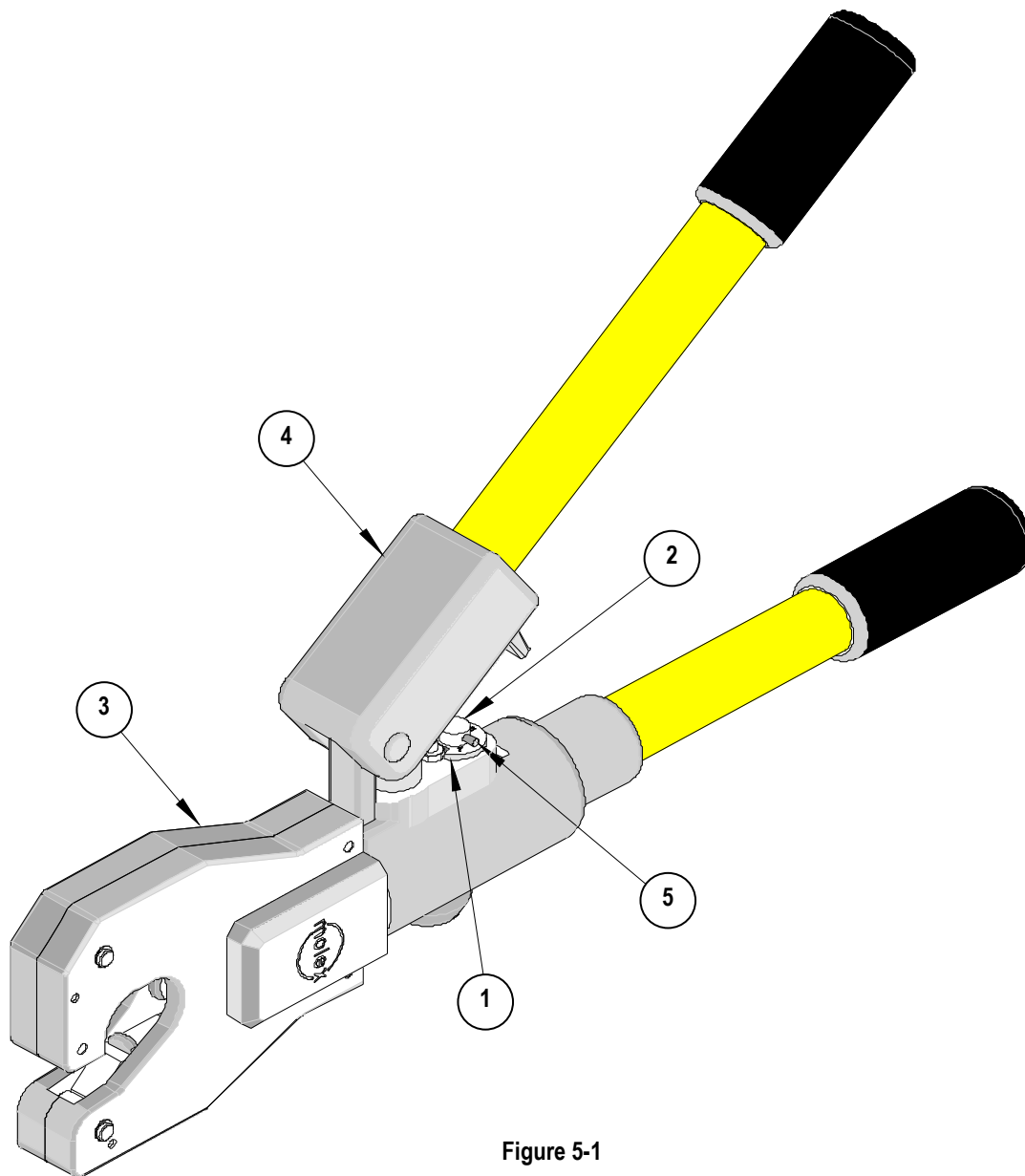


Figure 5-1

4.2 Steel Head Parts List

19286-0200-Steel Head Figure 5-2			
Item	Order No.	Description	Quantity
REF	64000-0095	Repair Kit all "K" Items	---
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 (DLH 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	64016-0024	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

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

4.2 Steel Head Assembly

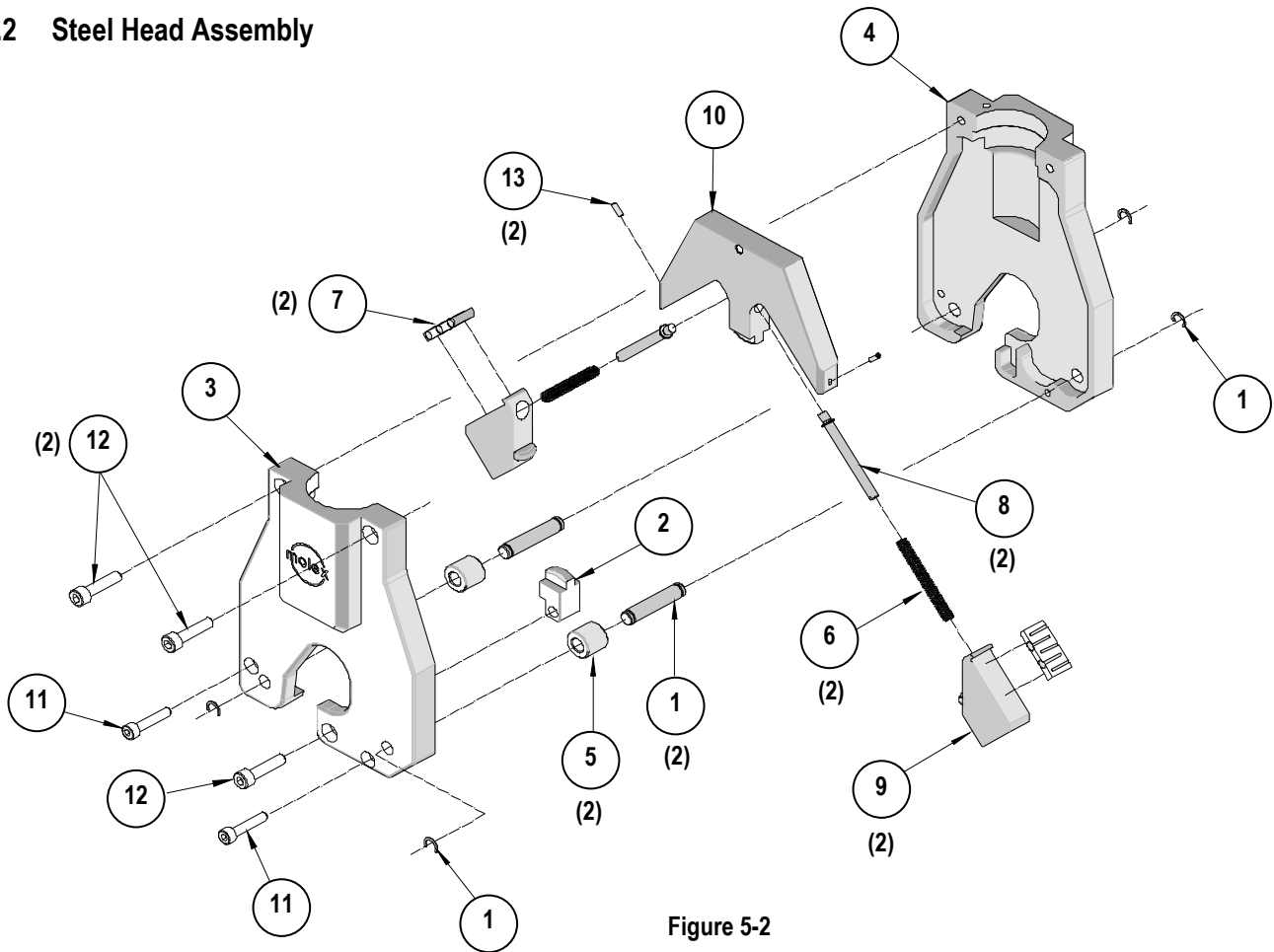


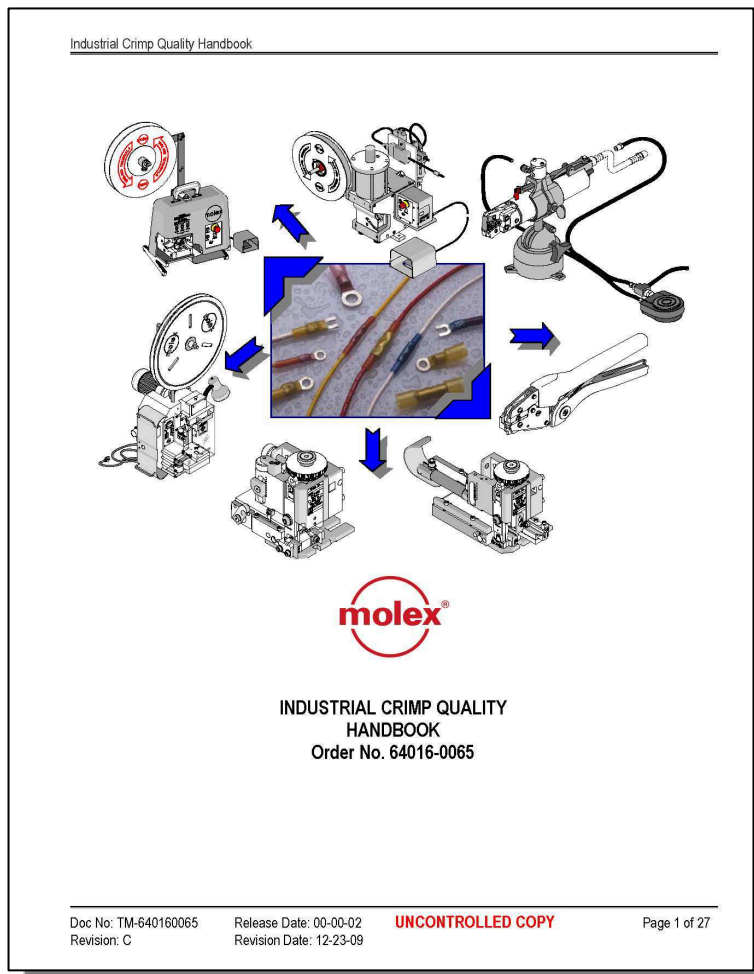
Figure 5-2

4.3 Troubleshooting

Symptom	Cause	Solution
Tool fails to advance when pump is actuated	<ul style="list-style-type: none"> Suction valve is sticking 	Rap the tool head sharply on the ground.
Tool operation is binding, sluggish	<ul style="list-style-type: none"> Crimp tool head is dirty 	Clean all moving parts.
Tool is operating but terminals are over or under crimp	<ul style="list-style-type: none"> Improper bypass setting 	Set bypass per Section 3.3 (Adjustable Settings Chart).

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.



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