

# HAND CRIMP TOOL SPECIFICATION SHEET Order No. 63811-7000



# FEATURES

- A full cycle ratcheting hand tool ensures complete crimps
- Ergonomic soft grip handles for comfortable crimping
- A precision user-friendly terminal locator wire stop holds terminals in the proper crimping position
- This tool is IPC/WHMA-A-620 Class 2 and RoHS compliant

## SCOPE

<u>Products:</u> Disk Drive Power Connection System Crimp Terminal 14-22 AWG.

Terminal	Terminal Order No.			Wire Size		Insulation Diameter		Strip Length		
Series No.	Loose	Piece	*Reel		AWG	mm²	mm	ln.	mm	ln.
	02-08-1202	02-08-1237	02-08-1201	02-08-1334	14-16	2.00-1.30	2.75-3.56	.109140	4.75-5.54	.187218
8980	02-08-1235	02-08-1335	02-08-1234	02-08-1236	18-20	0.80-0.50	2.00-2.90	.079114	4.75-5.54	.187218
	02-08-1204	02-08-1337	02-08-1203	02-08-1336	18-22	0.80-0.35	1.52-2.30	.060090	4.75-5.54	.187218
*Follow the Cut-Off Tab specifications on Applicator specification sheets.										
These Terminals cannot be removed from the reel by manual cutting.										
An applicator must be used or the terminals will not function properly.										

## **DEFINITION OF TERMS**



The above terminal drawing is a generic terminal representation. It is not an image of a terminal listed in the scope.

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# CONDITIONS:

After crimping, the conductor profiles should measure the following (see notes on page 5).

	Wire Size		C	Pull Force		Profile					
Terminal Series No.			Height (Ref.)		Width (Ref.)		Minimum		1 TONIC		
	AWG	2 2	mm	In.	mm	In.	Ν	Lb.	A	В	С
	18	0.80	1.00-1.10	.040044	1.92	.076	89.0	20.0	Χ		
8980	20	0.50	1.00-1.10	.040044	1.92	.076	71.2	16.0	Х		
	22	0.35	1.00-1.10	.040044	1.92	.076	44.5	10.0	Х		
	14	2.00	1.25-1.35	.049053	2.32	.091	266.9	60.0		Х	
8980	16	1.30	1.25-1.35	.049053	2.32	.091	133.4	30.0		Х	
0000	18	0.80	1.20-1.30	.047051	2.20	.087	89.0	20.0			Х
	20	0.50	1.20-1.30	.047051	2.20	.087	71.2	16.0			Х

### OPERATION

**CAUTION:** Install only Molex terminals listed above with this tool. Do not crimp hardened objects as damage can occur to the tool or die.

Open the tool by squeezing the handles together, at the end of the closing stroke, the ratchet mechanism will release the handles, and the hand tool will spring open.

### **Crimping Terminals**

- 1. Select the desired terminal listed in the preceding charts.
- 2. Swing the terminal locator away from the crimp tool shown in Figure 2. Some terminals with large insulation grips may interfere with the crimp tooling when swinging the locator into position. The terminal must then be loaded into the locator in the closed/crimp position.



- 4. Return the locator to its original position. Insert the proper wire over the terminal. Some large O.D. wires may need to be placed into the terminal before closing the tool. Gently touch the wire stop with the end of the wire. See Figure 3.
- 5. Compress the terminal by squeezing the tool handles until the ratchet mechanism cycle has been completed. Release handles to open the jaws.

Note: The tamper proof ratchet action will not release the tool until it has been fully closed.

- 6. Remove the crimped terminal from the terminal locator by pressing down on the wire stop and gently pulling on the wire. The terminal locator can be in either position.
- 7. Visually inspect the crimped terminal for proper crimp location.

**JAWS OPEN** 

LOCATOR

Figure 1



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SWING LOCATOR OPEN

Figure 4

### Maintenance

It is recommended that each operator of the tool be made aware of, and responsible for, the following maintenance steps:

- 1. Remove dust, moisture, and other contaminants with a clean brush, or soft, lint free cloth.
- 2. Do not use any abrasive materials that could damage the tool.
- 3. Make certain all pins; pivot points and bearing surfaces are protected with a thin coat of high quality machine oil. Do not oil excessively. The tool was engineered for durability but like any fine piece of equipment it needs cleaning and lubrication for a maximum service life of trouble free crimping



lubrication for a maximum service life of trouble free crimping. Light oil such as 30 weight automotive oil used at the oil points, every 5,000 crimps or 3 months, shown in Figure 6 will significantly enhance the tool life.

- 4. Wipe excess oil from hand tool, particularly from crimping area. Oil transferred from the crimping area onto certain terminations may affect the electrical characteristics of an application.
- 5. When tool is not in use, keep the handles closed to prevent objects from becoming lodged in the crimping dies, and store the tool in a clean, dry area.

## **Miscrimps or Jams**

Should this tool ever become stuck or jammed in a partially closed position, **Do Not** force the handles open or closed. The tool will open easily by pressing the ratchet release lever. See Figure 6.

# How to Adjust Tool Preload (See Figure 6)

This hand tool is factory preset to 25-45 LBS. preload. It may be necessary over the life of the tool to adjust tool handle preload force. Listed below are the steps required to adjust the crimping force of the hand tool to obtain proper crimp conditions:



- 1. Remove or fold back the handle grip from the handle to expose the eccentric axle and setting wheel.
- 2. Remove the locking screw with a 2mm hex wrench. The wrench set (63810-0101), is not supplied. It is sold separately from the hand tool.
- 3. Turn the eccentric axle and setting wheel with the wrench or pliers Counter-clockwise (CCW) to increase handle force.
- 4. Replace the locking screw, aligning the nearest notch in the setting wheel to locking screw.
- 5. Replace the handle grip.
- 6. Check the crimp specifications or conduct a pull test after tool handle preload force is adjusted.

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### Warranty

This tool is for electrical terminal crimping purposes only. This tool is made of the best quality materials. All vital components are long life tested. All tools are warranted to be free of manufacturing defects for a period of 30 days. Should such a defect occur, we will repair or exchange the tool free of charge. This repair or exchange will not be applicable to altered, misused, or damaged tools. This tool is designed for hand use only. Any clamping, fixturing, or use of handle extensions voids this warranty.

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

## **CAUTIONS:**

- 1. Manually powered hand tools are intended for low volume or field repair. This tool is NOT intended for production use. Repetitive use of this tool should be avoided.
- 2. Insulated rubber handles are not protection against electrical shock.
- 3. Wear eye protection at all times.
- 4. Use only the Molex terminals specified for crimping with this tool.

### Certification

Molex does not certify or re-certify commercial grade hand tools but rather supplies the following guidelines for customers to re-certify hand tools.

- % This tool is qualified to pull force only. To re-certify, crimp a terminal to a wire, which has been stripped 12.7mm (1/2") long, so there is no crimping of the insulation. Pull the terminal and wire at a rate no faster than 25mm (1.00") per minute. See the Molex web site for the Quality Crimp Handbook for more information on pull testing.
- % If the tool does not meet minimum pull force values, handle preload should be increased and the pull test rerun, (See How To Adjust Preload).
- % When the hand tool is no longer capable of achieving minimum pull force, it should be taken out of service and replaced.

# PARTS LIST

Item Number	Order Number	Description	Quantity	
REF	63811-7000	Hand Crimp Tool	Figure 7	
1	63810-0101	Wrench Set (Not included)	0	
2	63810-0102	Locator Base Assembly	1	
3	63810-0103	Repair Kit (Not included)	0	
4	63811-7075	Locator	1	



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Общество с ограниченной ответственностью «МосЧип» ИНН 7719860671 / КПП 771901001 Адрес: 105318, г.Москва, ул.Щербаковская д.З, офис 1107

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#### Офис по работе с юридическими лицами:

105318, г.Москва, ул.Щербаковская д.З, офис 1107, 1118, ДЦ «Щербаковский»

Телефон: +7 495 668-12-70 (многоканальный)

Факс: +7 495 668-12-70 (доб.304)

E-mail: info@moschip.ru

Skype отдела продаж: moschip.ru moschip.ru\_4

moschip.ru\_6 moschip.ru\_9