molex®

Tool Kit Order No. 63823-2470	**Application Tooling Specification Sheet**	**TYPE 4C** **Hand Crimp Tool Order No. 63823-2400**

FEATURES

- % A full cycle ratcheting hand tool ensures complete crimps
- % Ergonomically designed soft handles
- % Precisely designed crimping profiles with simple contact positioning
- % Easy handling due to outstanding force ratio
- ▪ Tool kits are easily installed into the Hand Crimp Tool or the 63816-0300 Power Crimp Head which is installed into the 63816-0200 (110 V) or the 63816-0250 (220 V) Battery Powered Tool.
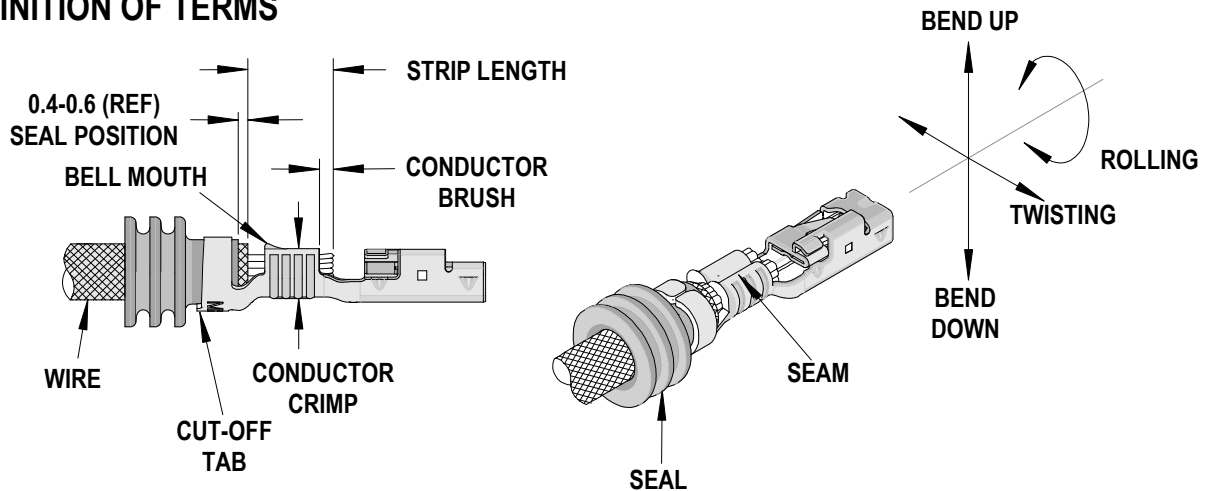- ▪ Many different Tool kits can be used with a single Battery Powered Tool.

SCOPE

Products: CTX280 SWS Receptacle Terminals: 0.5 - 1.0 mm^2 metric wires.

Terminal Series No.	Terminal Order No. ✳Reel Form Only				Wire Size and Type		✖Insulation Diameter		Strip Length	
					mm^2	Type	mm	In.	mm	In.
98675	98675-1001	98675-1005	98675-1011	98675-1015	0.5-1.0	T3ZHID	1.40-1.95	.055-.077	4.30-4.80	.169-.189
	98675-1041	98675-1045	98675-1051	98675-1055						
	98675-1061	98675-1065	98675-1101	98675-1105						
	98675-1111	98675-1115								
34865	34865-1001	34865-1005	34865-1041	34865-1045	0.5-1.0	T3ZHID	1.40-1.95	.055-.077	4.30-4.80	.169-.189
	34865-1061	34865-1065	34865-1101	34865-1105						
34808	34808-1001	34808-1005	34808-1041	34808-1045	0.5-1.0	T3ZHID	1.40-1.95	.055-.077	4.30-4.80	.169-.189
	34808-1061	34808-1065	34808-1101	34808-1105						
✖ See crimp specification for the individual Insulation Diameter. ✳Customer to cut off terminal from reel: 0.30mm (.012") maximum Cut-off Tab.										

DEFINITION OF TERMS

STRIP LENGTH

0.4-0.6 (REF)
SEAL POSITION

BELL MOUTH

CONDUCTOR BRUSH

WIRE

CONDUCTOR CRIMP

CUT-OFF TAB

SEAM

SEAL

BEND UP

ROLLING

TWISTING

BEND DOWN

CRIMP SPECIFICATION

Terminal Series No.			Bell mouth		▶ Conductor Brush		Bend up	Bend Down	Twist	Roll
			mm	In.	mm	In.	Degree Max.		Degree Max.	
98675	34808	34865	0.40-0.60	.016-.024	0.20-0.60	.008-.024	1	1	2	3
						▶ Not to exceed above the conductor crimp height.				

After crimping, the crimp profiles should measure the following:

Terminal Plating	Terminal Order No.			Wire Size	Conductor					Pull Force Minimum		Profile		
					Crimp Height		Crimp Width							
				mm²	mm	In.	mm	In.		N	Lb.	A	B	C
Standard Performance Tin	34808-1001	34808-1005	34865-1001	0.50	1.05-1.15	.041-.045	2.02-2.12	.079-.083		70.0	15.7	X		
	34865-1005	98675-1001	98675-1005											
	98675-1011	98675-1015												
High Performance Tin	34808-1041	34808-1045	34808-1101	0.50	1.07-1.13	.042-.044	2.02-2.12	.079-.083		70.0	15.7	X		
	34808-1105	34865-1041	34865-1045											
	34865-1101	34865-1105	98675-1041											
	98675-1045	98675-1051	98675-1055											
	98675-1101	98675-1105	98675-1111											
	98675-1115													
High Performance Silver	34808-1061	34808-1065	34865-1061	0.50	1.10-1.16	.043-.046	2.02-2.12	.079-.083		70.0	15.7	X		
	34865-1065	98675-1061	98675-1065											
Standard Performance Tin	34808-1001	34808-1005	34865-1001	0.75	1.13-1.23	.044-.048	2.02-2.12	.079-.083		90.0	20.2		X	
	34865-1005	98675-1001	98675-1005											
	98675-1011	98675-1015												
High Performance Tin	34808-1041	34808-1045	34808-1101	0.75	1.13-1.23	.044-.048	2.02-2.12	.079-.083		90.0	20.2		X	
	34808-1105	34865-1041	34865-1045											
	34865-1101	34865-1105	98675-1041											
	98675-1045	98675-1051	98675-1055											
	98675-1101	98675-1105	98675-1111											
	98675-1115													
High Performance Silver	34808-1061	34808-1065	34865-1061	0.75	1.08-1.18	.043-.047	2.02-2.12	.079-.083		90.0	20.2		X	
	34865-1065	98675-1061	98675-1065											
Standard Performance Tin	34808-1001	34808-1005	34865-1001	1.00	1.15-1.25	.045-.049	2.02-2.12	.079-.083		115.0	25.8			X
	34865-1005	98675-1001	98675-1005											
	98675-1011	98675-1015												
High Performance Tin	34808-1041	34808-1045	34808-1101	1.00	1.17-1.23	.046-.048	2.02-2.12	.079-.083		115.0	25.8			X
	34808-1105	34865-1041	34865-1045											
	34865-1101	34865-1105	98675-1041											
	98675-1045	98675-1051	98675-1055											
	98675-1101	98675-1105	98675-1111											
	98675-1115													
High Performance Silver	34808-1061	34808-1065	34865-1061	1.00	1.17-1.23	.046-.048	2.02-2.12	.079-.083		115.0	25.8			X
	34865-1065	98675-1061	98675-1065											
Seam note: Seam shall not be open and no wire allowed out of the crimping area														

Terminal Series No.			Wire Size	✗ Insulation Diameter		Single Wire Seal		Insulation			
								Crimp Height		Crimp Width	
			mm²	mm	In.	Order No.	Color	mm	In.	mm	In.
98675	34865	34808	0.50	1.40-1.60	.055-.063	See Note 3	See Note 3	4.30-4.50	.169-.177	4.95-5.05	.195-.199
			0.75	1.60-1.80	.063-.071			4.40-4.60	.173-.181	4.95-5.05	.195-.199
			1.00	1.75-1.95	.069-.077			4.50-4.70	.177-.185	4.95-5.05	.195-.199

▶ Tool Qualification Notes:
1. Pull Force should be measured with no influence from the insulation crimp.
2. The above specifications are guidelines to an optimum crimp.
3. See Product Application Specification AS-98675-002 for Applicable Seal number and Color.

Note:
A crimp height chart is provided with this manual as Reference Only. Due to the wide range of wires, strands, insulation diameters, and durometers, actual crimp height measurements may very slightly. An occasional, destructive, pull force test should be preformed to check hand tool crimp. Pull Force value must exceed the minimum pull force specifications listed.

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

INSTALLATION

To install the Tool Kit into the Power Crimp Head follow the steps below:

Figure 1

Figure 2
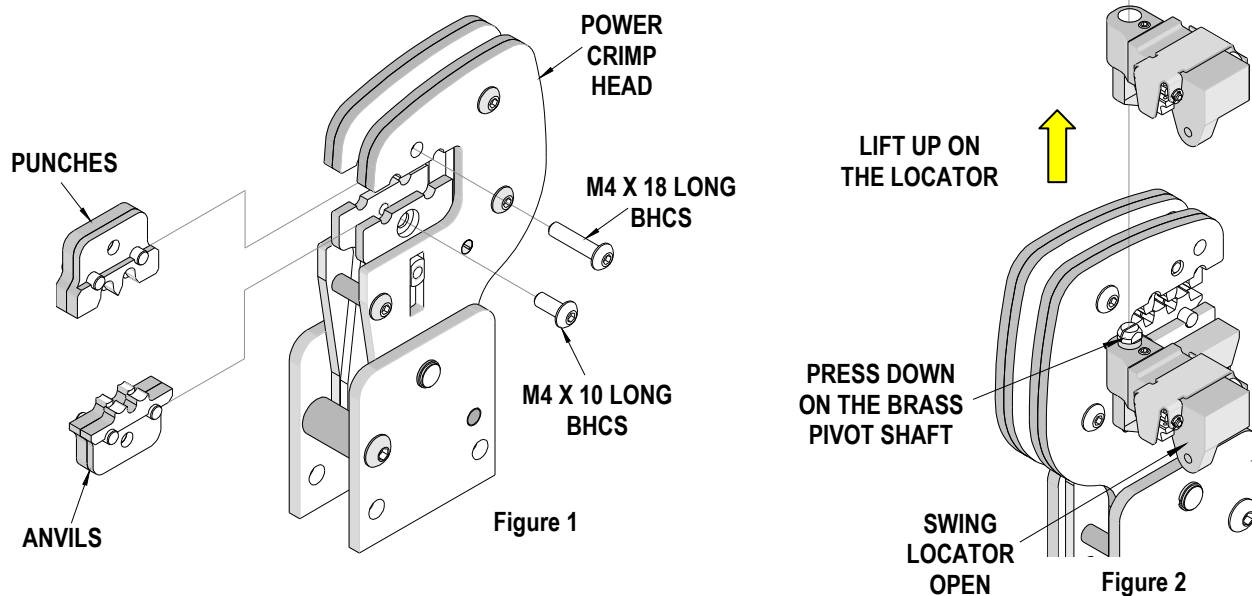
Anvils and Punches Installation

1. Insert the Anvils into the bottom slots of the nest. Install the M4 x 10 long BHCS and tighten in place.
2. Insert the Punches into the top slots of the nest. Install the M4 x 18 long BHCS and tighten in place. See Figure 1.

Locator Installation and Removal

Follow the steps below to install or replace the locator. See Figure 2.

To install the locator
1. Position the locator with the hole over the brass pivot shaft and snap it into place.

To remove the locator
1. Open the crimp hand tool.
2. Swing the existing locator open and away from the hand tool.
3. Firmly press down on the brass pivot shaft with your thumb, while pulling the locator up. Slip the locator off the top of the brass pivot shaft.
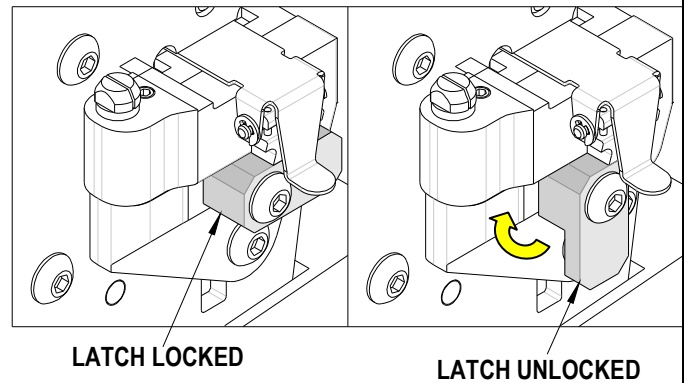
LATCH LOCKED   **LATCH UNLOCKED**

Figure 3

OPERATION

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.
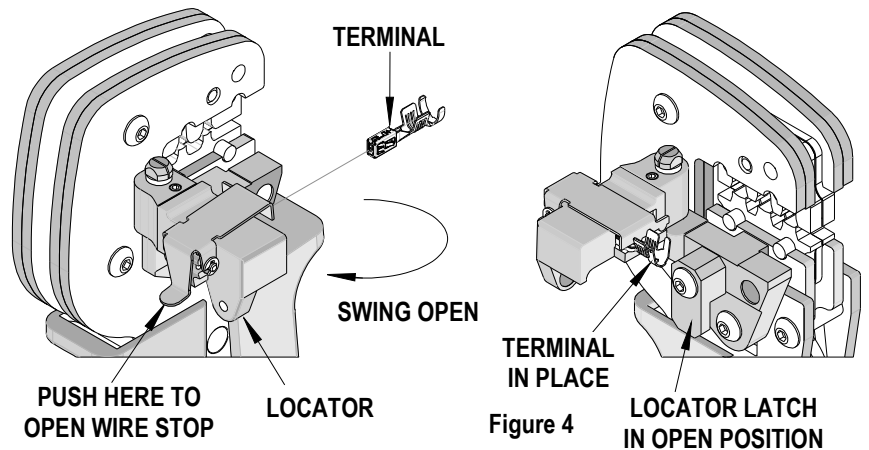
Crimping Terminals
1. Select the desired terminal listed in the preceding charts.
2. Turn the Locator Lock Latch down to unlock. See Figure 3.
3. Swing the terminal locator away from the crimp tool shown in Figure 4.
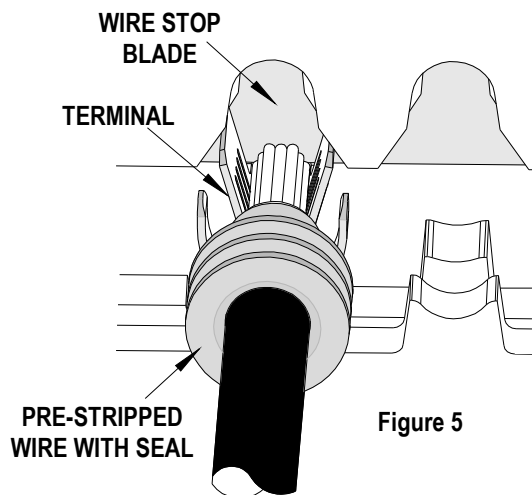
TERMINAL

SWING OPEN

PUSH HERE TO OPEN WIRE STOP   **LOCATOR**

TERMINAL IN PLACE

Figure 4   **LOCATOR LATCH IN OPEN POSITION**

WIRE STOP BLADE

TERMINAL

PRE-STRIPPED WIRE WITH SEAL   **Figure 5**

CONDUCTOR PUNCH   **INSULATION PUNCH**

WIRES AGAINST LOCATOR STOP   **SEAL**

LOCATOR   **WIRE**

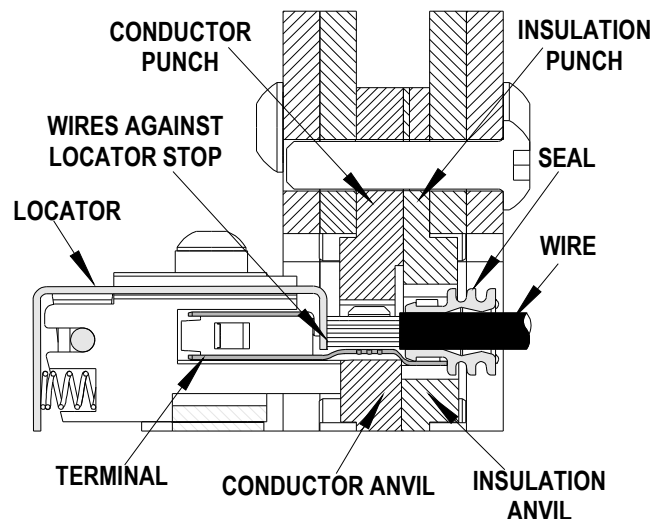**TERMINAL**   **CONDUCTOR ANVIL**   **INSULATION ANVIL**

Figure 6

4. Press down on the wire stop on the locator as shown in Figure 4. Insert the proper terminal into the proper nest opening. Make sure when choosing the nest opening, it will correspond with the correct profile on the hand tool.

5. Return the locator to closed position.
6. Turn the Locator Lock Latch up to lock. Make sure that the terminal is visually centered over the punch.
7. Insert the proper wire with the seal over the terminal.
8. Gently touch the wire stop with the end of the wire and align the seal with the grips on the terminal. See Figure 5 and 6.

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

9. Compress the terminal by squeezing the tool handles until the ratchet mechanism cycle has been completed. Release handles to open the jaws.
10. Unlock the locator latch and swing the locator open.
11. Remove the crimped terminal from the terminal locator by pressing down on the wire stop and gently pulling on the wire.
12. Visually inspect the crimped terminal for an acceptable crimp.

For the Battery Power Tool:
1. Cycle the Battery Power Tool to crimp the terminal to the wire.
2. Remove the crimped terminal from the terminal locator by pressing down on the wire stop and gently pulling on the wire.
3. Visually inspect the crimped terminal for an acceptable crimp.

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 in the tool head are protected with a thin coat of high quality machine oil. Do not oil excessively. This 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. The use of light oil, such as 30 weight automotive oil, every 5,000 crimps or monthly, will significantly enhance the tool life and ensure a stable calibration. See Figure 7A or 7B for lubrication points.
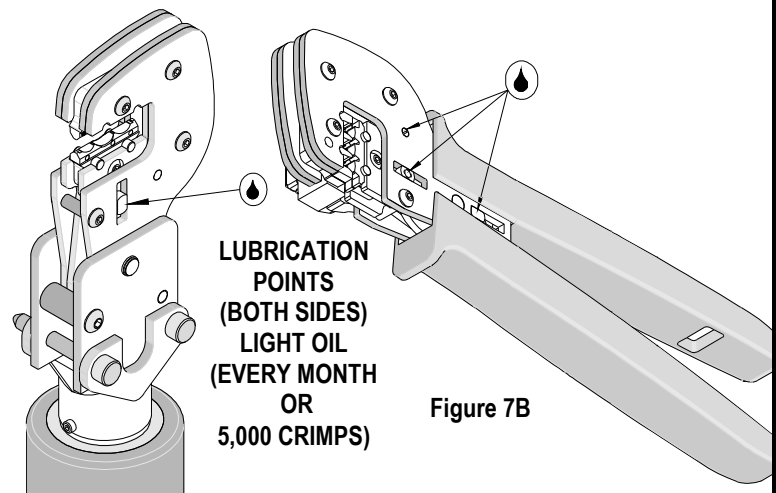4. Store the tool in a clean and dry area when not in use.

LUBRICATION POINTS (BOTH SIDES) LIGHT OIL (EVERY MONTH OR 5,000 CRIMPS)

Figure 7B

Figure 7A

Miscrimps or Jams for Crimp Hand Tools Only (See Figure 10)

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 rotating the small slotted screw marked with an arrow. See Figure 10.

Warranty
This tool kit is for electrical terminal crimping purposes only. This tool kit 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 kit free of charge. This repair or exchange will not be applicable to altered, misused, or damaged tools.

> **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.

> **CAUTION:** Repetitive use of this tool should be avoided.

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.

% When the hand tool is no longer capable of achieving minimum pull force, it should be taken out of service and replaced.

% This tool is very difficult to disassemble and reassemble. Customer repair is not recommended.

The chart below shows all applications for this Tool Kit.

Tool Kit Order No.	Tool Order no.	Tool Description	Power Head Order No.	Adapter Description	Figure No.
63823-2470	63810-1050	Hand Crimp Frame (Short)	N/A	N/A	8
	63810-1000	Hand Crimp Frame (Long)	N/A	N/A	8
	63816-0200	Battery Power Tool (110 V)	63816-0300	Power Crimp Head	9
	63816-0250	Battery Power Tool (220 V)	63816-0300	Power Crimp Head	9

Applications for the Tool Kit

Hand Crimp Tool — Figure 8

Battery Powered Tool — Figure 9
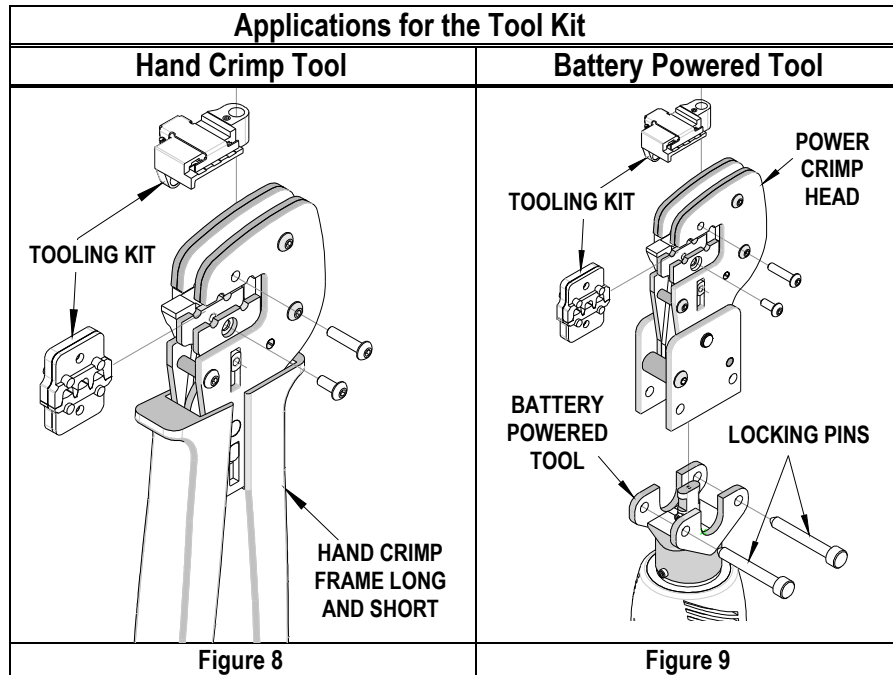
WARNING: *NEVER* operate service, install tool kits, or adjust the Power Crimp Head without proper instruction and without first reading and understanding the instructions in the proper Manual or Specification Sheet. See Chart above for the correct Manual or Specification Sheet.

WARNING: *NEVER* install tooling or service this tool while it is into any power source. Make sure the power is turned off.

CAUTION: Keep fingers away from the crimping area when operating this tool. It may cause severe injury.

CAUTION: Wear safety glasses when operating or serving this tool.

HAND TOOL PARTS LIST

Item Number	Order Number	Description	Quantity
1	63810-1000	Hand Crimp Frame (Long)	1
2	63823-2470	Tool Kit with Locator	1
3	63823-2475	Locator (only)	REF

M4 X 8mm LONG BHCS

RATCHET RELEASE SCREW

M4 X 10mm LONG BHCS

M4 X 18mm LONG BHCS

2) WITH TOOL KIT

3) LOCATOR ONLY
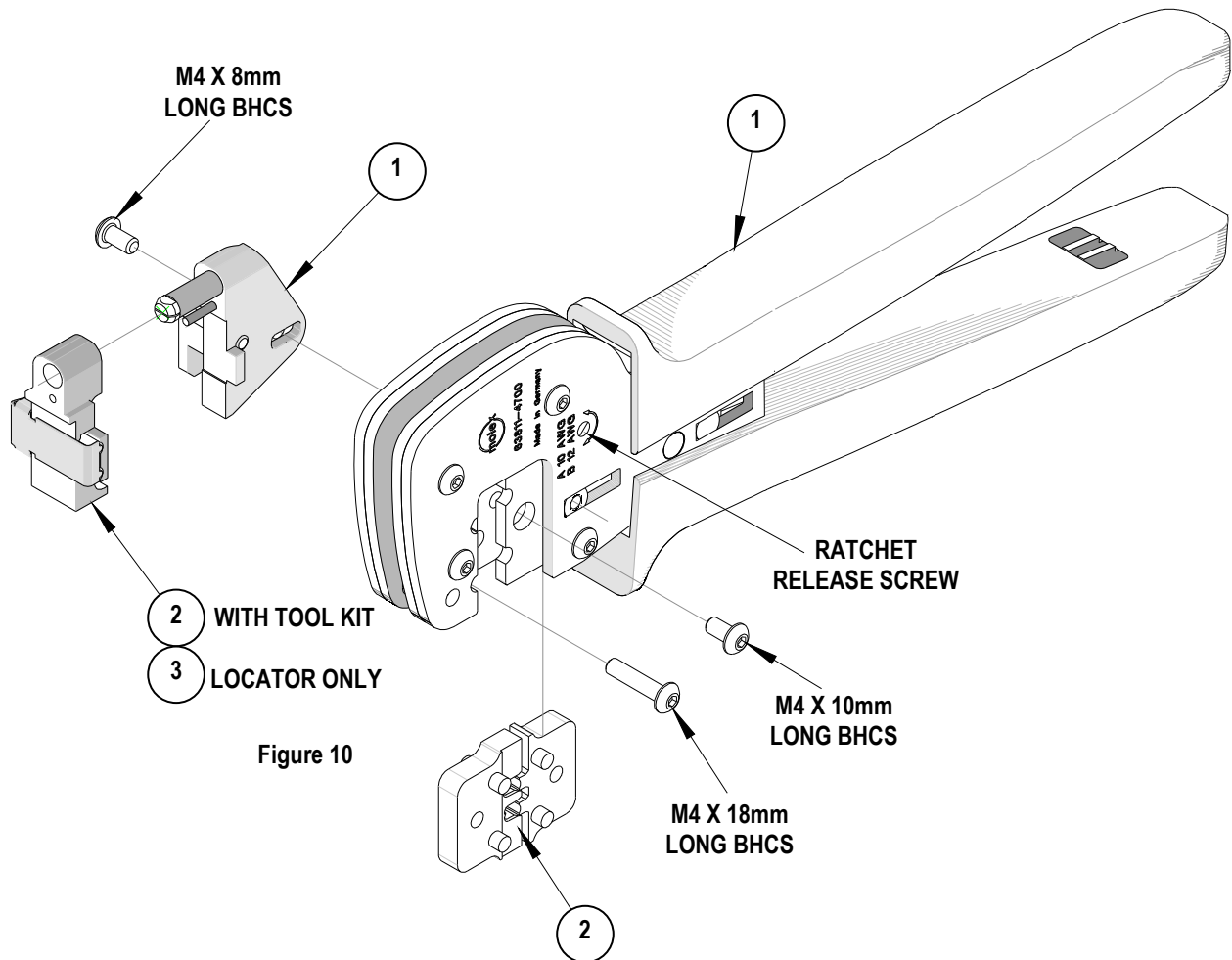
Figure 10

POWER HEAD PARTS LIST

Item	Order No	Engineering No.	Description	Quantity
1	63816-0300	63816-0300	Power Crimp Head	1
2	63823-2470	63823-2470	Tool Kit	1

M4 by 8 Long
BHCS

M4 by 18 Long
BHCS

M4 by 10 Long
BHCS

Figure 11

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