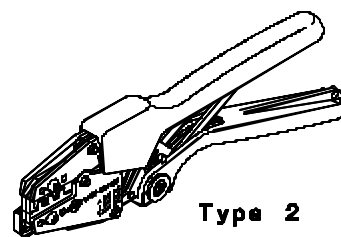




# TOOLING SPECIFICATION SHEET HAND CRIMP TOOL Part No. 63811-3500



## SCOPE

Terminal Series No	Wire Size		Insulation Diameter		Strip Length	
	Awg	mm <sup>2</sup>	mm	in	mm	in
42023	14-20	2.00-0.50	1.52-3.30	.060-.130	3.96 - 5.53	.156 - .218
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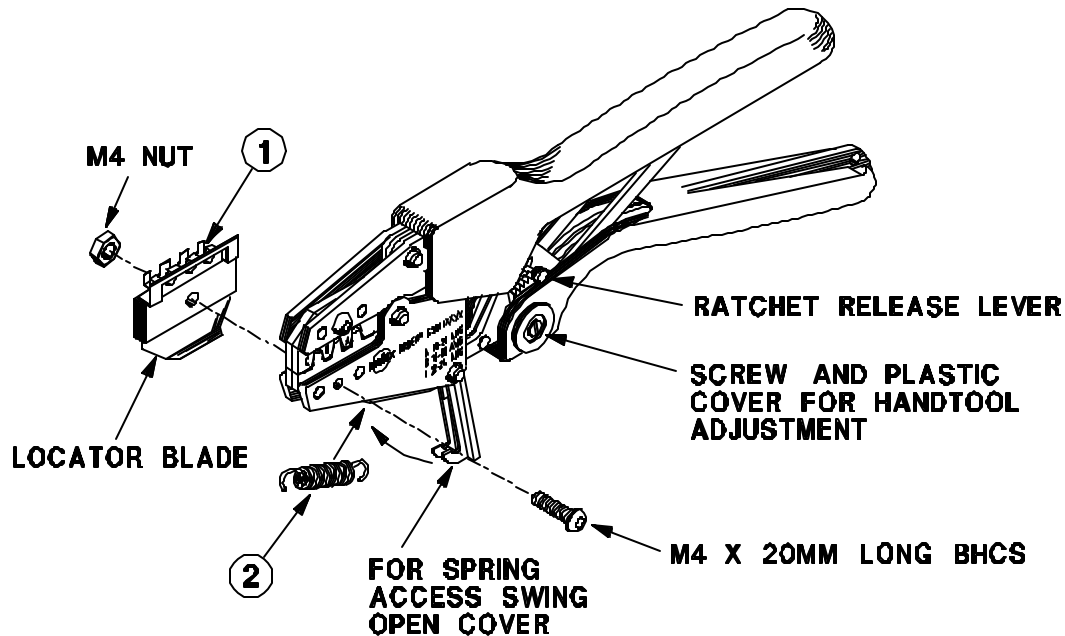
## CONDITIONS

After crimping, the conductor profile should measure the following. (see notes on page 2)

Terminal Series No.	Wire Size		Crimp Height (Ref)		Pull Force Min.		Punch Width		Profile		
	Awg	mm <sup>2</sup>	mm	in	N	Lbs.	Ref. mm	Cond. Ins.	A	B	C
42023	14	2.00	1.55-165	.061-.065	222.4	50.00	2.70	3.20	X		
42023	16	1.30	1.40-1.50	.055-.059	133.4	30.00	2.50	3.20		X	
42023	18	0.80	1.30-1.40	.051-.055	88.9	20.00	2.20	2.80			X
42023	20	0.50	1.30-1.40	.051-.055	57.8	13.00	2.20	2.80			X
42024	14	2.00	1.55-165	.061-.065	222.4	50.00	2.70	3.20	X		
42024	16	1.30	1.40-1.50	.055-.059	133.4	30.00	2.50	3.20		X	
42024	18	0.80	1.30-1.40	.051-.055	88.9	20.00	2.20	2.80			X
42024	20	0.50	1.30-1.40	.051-.055	57.8	13.00	2.20	2.80			X

## PARTS LIST

Item Number	Order Number	Description	Qty
1	63811-3575	Locator **	1
2	11-11-0368	Spring (Main)	1



\*\* Not all tools are equipped with a locator or locator blade.

*Fig. 1*

### Notes:

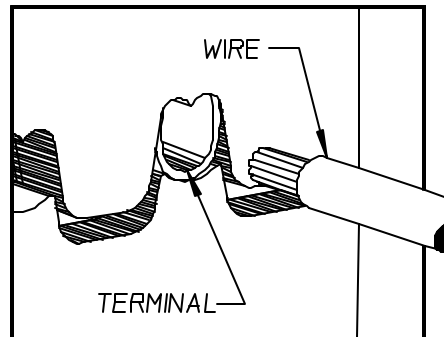
1. This tool should only be used for the terminals and wire gauges specified on this sheet.
2. This tool is not adjustable for crimp height, however crimp force is adjustable. (see instructions on page 4.) Variations in tools, terminals, wire strandings and insulation types may effect crimp height.
3. This tool is intended for standard conductor sizes. It may not give a good insulation crimp support for all insulation sizes and types.
4. Molex does not repair handtools (see warranty on page 4). The replacement parts listed are the only parts available for repair. If the handles or crimp tooling is damaged or worn, a new tool must be purchased.
5. Pull force should be used as the final criteria for an acceptable crimp. Pull force is measured with no influence from the insulation crimp. The insulation should be stripped long (1/2 in.) so the insulation grips on the terminal do not grip the insulation on the wire or the conductor. Refer to the Molex Quality Crimping Handbook 63800-0029 for additional information on crimping and crimp testing.
6. Molex does not certify crimp handtools.
7. Hand held crimping tools are intended for low volume, prototyping or repair requirements only.

**Caution:** Repetitive use of this tool should be avoided.

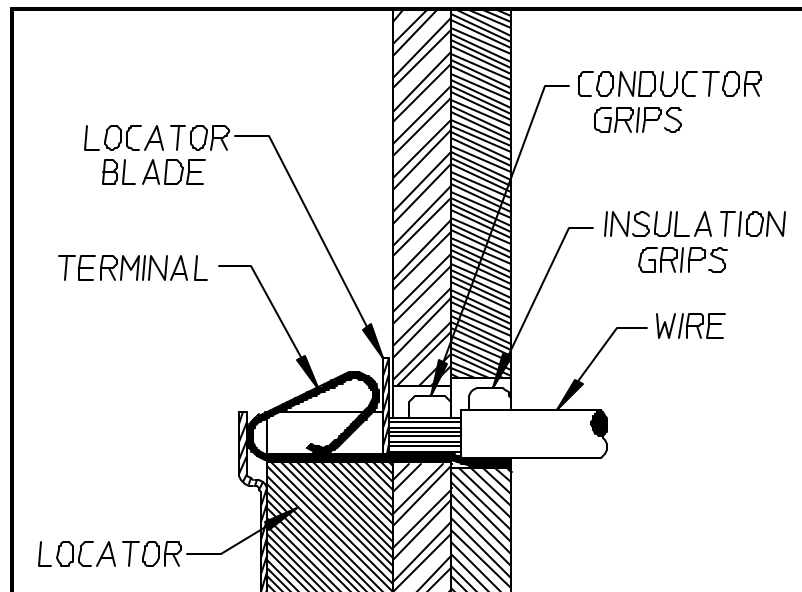
## Crimping Instructions

1. Open the tool by squeezing the handles together, at the end of the closing stroke, the ratchet mechanism will release the handles and the tool will spring open.
2. Lift the locator blade and place the terminal into the correct die profile (A or B), release the locator blade. Not all tools are equipped with a locator or locator blade.
3. Partially close the tool until the terminal is held in place. (see Fig. 2)
4. Place a wire into the terminal and up against the locator blade (see Fig. 3). On tools without locators line the wire up with the conductor and insulation grips visually.
5. Close the tool until the ratchet releases. (see Fig. 4)
6. Lift the locator blade or wire stop and carefully remove the crimped terminal.

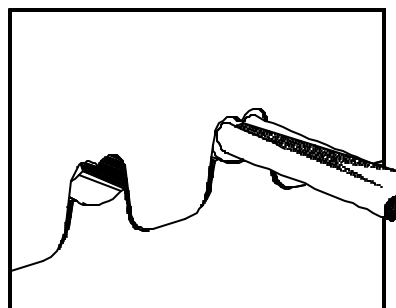
*Fig. 2*



*Fig. 3*



*Fig. 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.
4. 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 (see Fig. 1)**

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 lifting the ratchet release lever.

## **How To Adjust Tool Crimp Force (see Fig. 1)**

It may be necessary over the life of the tool to adjust the tool crimping force. Listed below are the steps required to adjust the crimping force of the handtool to obtain proper crimp conditions.

1. Remove the screw and plastic cover washer. Note the setting wheel position.
2. Lift the setting wheel off the axle. Turn the eccentric axle with a screwdriver.
3. Turning the eccentric axle counterclockwise will increase handle force.
4. Replace the setting wheel to the axle, aligning the nearest notch in the setting wheel to the dowel pin.
5. Replace the plastic cover washer and screw.
6. Check to the crimp specifications after tool crimp force is adjusted.

## **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 exchange the tool free of charge. This 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.

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