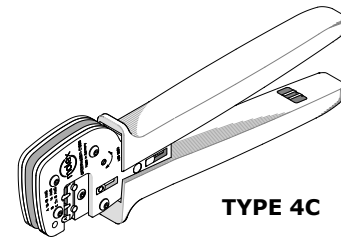


Order Number
213309-6000

molex

Application Tooling Specification



TYPE 4C

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.
- Tooling can be installed in the 63816-1915 Power Crimp Adapter, which is installed into the 63816-0270 (110 V) or 63816-0280 (220 V) Battery Powered Tools and the 63816-1900 Electric Crimp Machine.
- This tool is IPC/WHMA-A-620 Class 2 and RoHS compliant.

SCOPE

Products: Mega-Fit Wire-to-Wire Male and Female Crimp Terminals, 10 AWG.

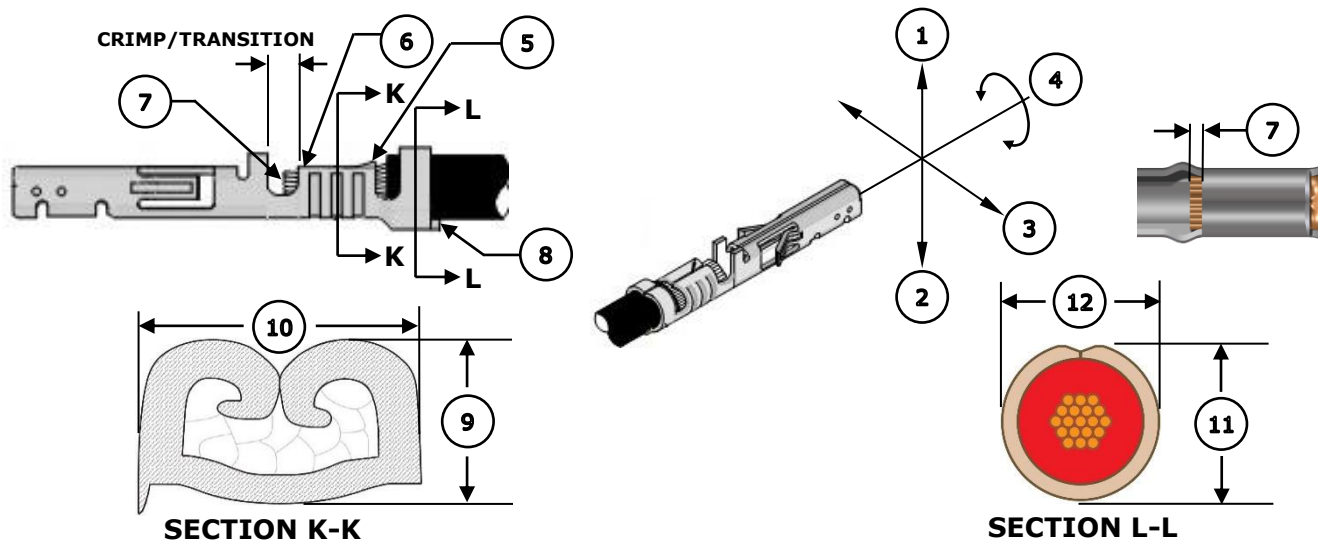
Terminal Series No.	Terminal Order No. (2)	Wire Size and Type		Insulation Diameter		Strip Length	
				IPC/WHMA-A-620 (1)			
		AWG	Type	mm	In.	mm	In.
76823	76823-0345	10	UL11028	3.40-3.60	.134-.142	4.8-5.4	.18-.21
105417	105417-0332						
105418	105418-0312						
	105418-1312						
172063	172063-0335						
	172063-1335						

(1) To achieve optimum IPC/WHMA-A-620 Class 2 insulation crimps, use this insulation OD range.
(2) Reeled terminals; user must cut terminals from reel; 0.20mm (.008") max cutoff tab.

Operation Note

Terminals crimped in this hand tool require a pre-form crimp. See the Operation section (page 3) for additional information.

DEFINITION OF TERMS



Note: Image above is a generic terminal representation. The actual terminals of the scope may look different.

CRIMP SPECIFICATION

Feature	Requirement						
1. Bend Up	3° Max						
2. Bend Down	3° Max						
3. Twist	4° Max						
4. Roll	8° Max						
5. Bell Mouth Rear	0.60-1.20mm (.024-.048")						
6. Bell Mouth Front	Not Applicable						
7. Conductor Brush	0.10-0.76mm (.004-.030")						
8. Cut-Off Tab	0.20mm (.008") Max						
Conductor Crimp	Terminal Order No. 76823-0345 172063-0335 172063-1335	Crimp Profile A	Wire Size 10 AWG	9. Crimp Height		10. Crimp Width (Ref)	
	105417-0332 105418-0312 105418-1312			B	2.40-2.50mm	.094-.098 in.	3.50mm
	Terminal Order No.	Wire Size			11. Crimp Height (Ref)		12. Crimp Width (Ref)
	76823-0345 105417-0332 105418-0312 105418-1312 172063-0335 172063-1335	10 AWG UL11028		4.15mm	.163 in.	4.17mm	.164 in.
Pull Force	Terminal Order No.	Wire Size	Minimum Pull Force		To be measured with no influence from the insulation crimp.		
	76823-0345 105417-0332 105418-0312 105418-1312 172063-0335 172063-1335	10 AWG	356 N	80 lb.			

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.

Note

Crimp specifications are provided with this document as reference only. Due to the wide range of wires, stranding, insulation diameters and durometers, actual crimp height measurements may vary slightly. An occasional destructive pull force test should be performed to check hand tool crimp. Pull force value must exceed the minimum pull force specifications listed.

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

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.

Pre-Forming the Terminal

Due to the size of the conductor grips of the terminals, a pre-form operation must be done before crimping wire in the terminal. The pre-form crimping profile is profile C (toward the outside of the tool). See Figure 1.

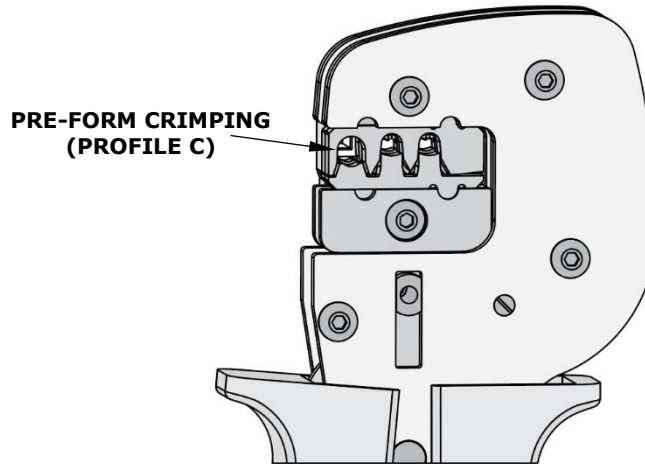


Figure 1

Use profile B to crimp male terminals (series 105417 and 105418).
Use profile A to crimp female terminals (series 76823 and 172063).

Follow the instructions below to pre-form the terminal:

1. Move the lock down and swing open the terminal locator. See Figure 2.
2. Push the tab to open the wire stop.
3. While holding the wire stop open, load the uncrimped terminal (male or female) into the first locator opening (Profile C). Make sure the terminal is pushed all the way into the opening.
4. Release the tab to close the wire stop.
5. Swing the terminal locator against the crimp tool and move the lock up. See Figure 2.
6. Pre-form the terminal by squeezing the tool handles until the ratchet mechanism releases. Release the handles to open the jaws.
7. Move the lock down, swing open the terminal locator and remove the pre-formed terminal.
8. Swing the empty locator against the crimp tool and move the lock up.

Crimping the Terminal

Make sure the terminal locator is against the hand crimp tool and the lock is up. For crimping, terminals must be loaded while the locator is closed and locked. The terminal locator may need to be pushed down slightly for terminals to load easily. See Figure 2.

1. To raise the wire stop, press the tab on the wire stop as shown in Figure 2. Insert the proper terminal into the nest opening and release the wire stop to lower it. When choosing the nest opening, remember that profile A is for female terminals and profile B is for male terminals. Make sure the terminal is fully seated in the nest opening.
2. Insert the proper pre-stripped wire over the terminal. Gently touch the wire stop with the end of the wire. See Figures 3 and 4.

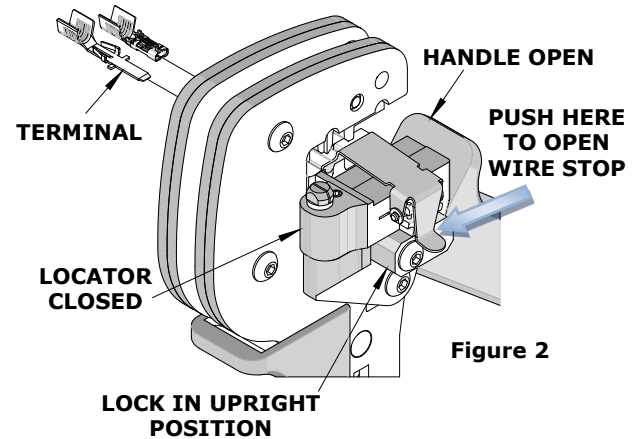


Figure 2

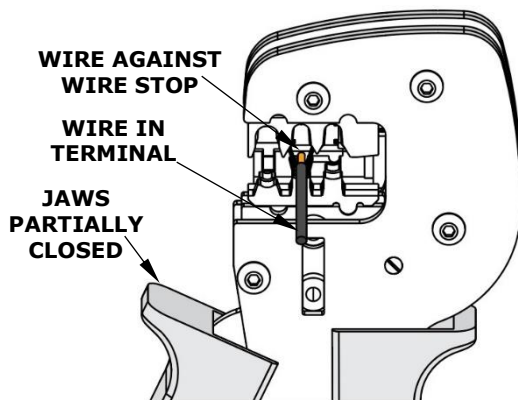


Figure 3

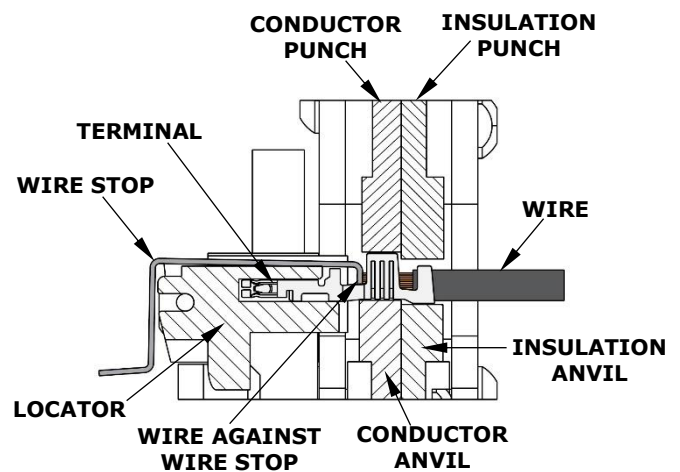


Figure 4

3. While keeping the wire against the wire stop, crimp the terminal by squeezing the tool handles until the ratchet mechanism releases. Release handles to open the jaws.

Note: The full-cycle ratchet action will not release the tool until it has been fully closed.

4. Remove the crimped terminal from the terminal locator by pressing the tab on the wire stop and gently pulling on the wire.
5. Visually inspect the crimped terminal for proper crimp location and crimp height.

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 a 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 a 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 5 for lubrication points.
4. Store the tool in a clean and dry area when it is not in use.

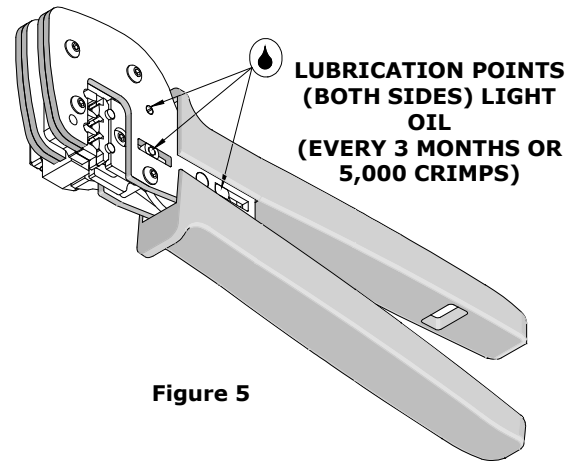


Figure 5

Miscrimps or Jams (Hand Crimp Tool Only)

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 9.

Warranty

This hand tool is for electrical terminal crimping purposes only. This hand 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, Molex will repair or exchange the tool 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 use 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 when operating or maintaining this tool.
4. Use only the Molex terminals specified for crimping with this tool.

CAUTION: Repetitive use of this tool should be avoided.

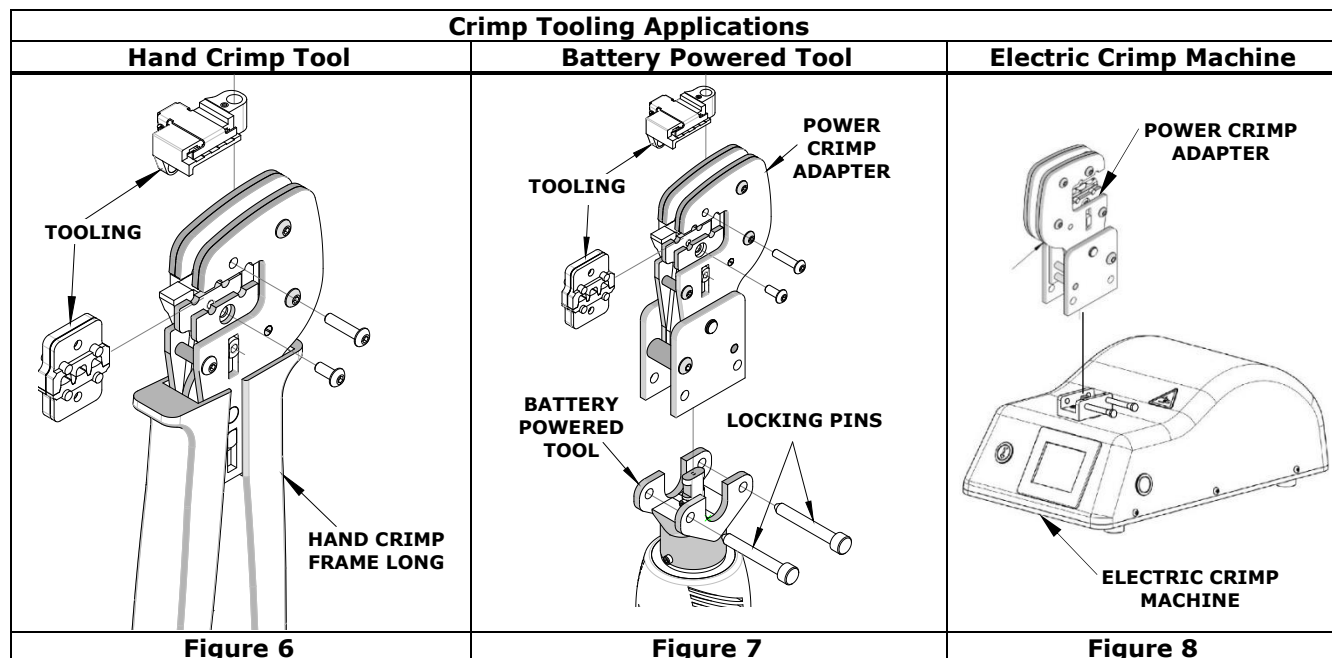
CERTIFICATION

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 that has been stripped 12.7mm (1/2") long so that 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 website 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.
- The tool frame is very difficult to disassemble and reassemble. Customer repair is not recommended.

The chart below shows all applications for this crimp tooling:

Tool Order No.	Tool Description	Adapter Order No.	Adapter Description	Figure No.
63810-1000	Hand Crimp Frame (Long)	—	—	6
63816-0270	Battery Power Tool (110 V)	63816-1915	Power Crimp Adapter	7
63816-0280	Battery Power Tool (220 V)	63816-1915	Power Crimp Adapter	7
63816-1900	Electric Crimp Machine	63816-1915	Power Crimp Adapter	8



WARNING: NEVER operate, service or 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.

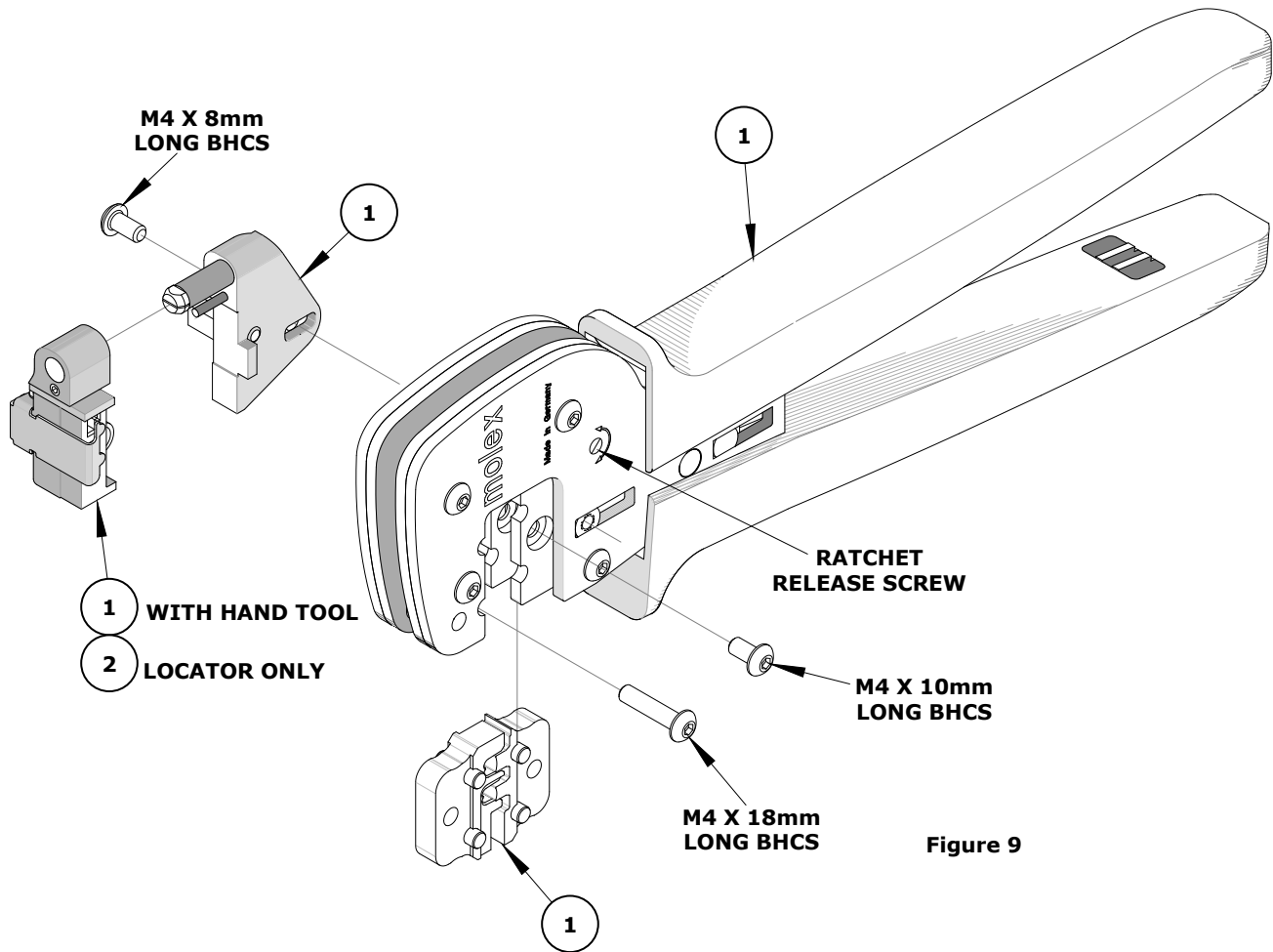
WARNING: NEVER install tooling or service this tool while it is connected to any power source. Make sure the power is turned off.

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

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

HAND TOOL PARTS LIST

Item Number	Order Number	Description	Quantity
1	213309-6000	Hand Crimp Tool	1
2	213309-6075	Terminal Locator	1



Application Tooling Support

Phone: (402) 458-TOOL (8665)
E-Mail: toolingsupport@molex.com
Website: www.molex.com/applicationtooling

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