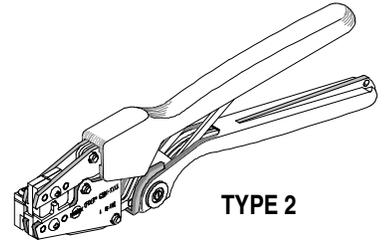




# Hand Crimp Tool Specification Sheet Order No. 63811-2000



## FEATURES

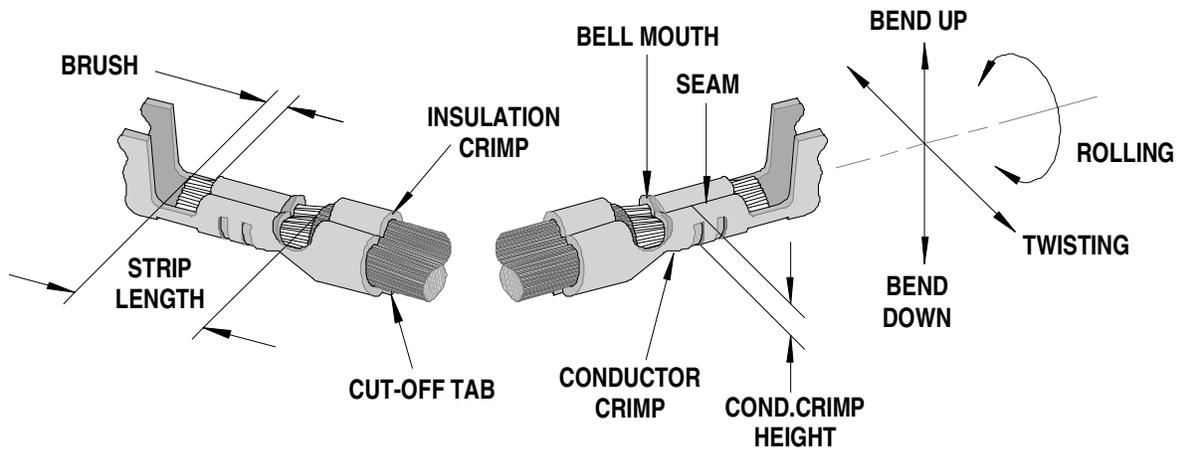
- Small handle spread which make this style tool ideally suited for end users
- Ratchet with safety release that ensures consistent performance
- A precision user-friendly terminal locator wire stop holds terminals in the proper crimping position

## SCOPE

Products: Star Ring Terminal-Power Tap Connector, 18 AWG.

Terminal Series No.	Terminal Order No.		Wire Size		Insulation Diameter		Strip Length	
	Loose Piece	Reel	AWG	mm <sup>2</sup>	mm	In.	mm	In.
44247	44247-0001	44247-0002	18	0.80	2.79	0.110	3.18-4.75	.125-.187

## DEFINITION OF TERMS



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

**CONDITIONS:**

After crimping, the conductor profiles should measure the following (see notes on page 3).

Terminal Series No.	Wire Size		Conductor Crimp				Pull Force Minimum	
	AWG	mm <sup>2</sup>	Height (Ref)		Width (Ref)		N	Lb.
			mm	In.	mm	In.		
44247	18	0.80	1.25 - 1.35	.049 - .053	2.30	.090	89.0	20.00

**OPERATION**

Open the tool by first closing the jaws sufficiently for the ratchet mechanism to release.

**Crimping Terminals**

1. Position the terminal onto the nest and push the ring of the terminal inside the locator until it stops. See Figure 1.
2. Partially close the tool to hold the terminal in place.
3. Insert the properly stripped wire into the terminal. See Figure 2 and 3. Cycle the tool.
4. Remove the crimped terminal. Inspect for proper crimp location, and check for insulation closure.

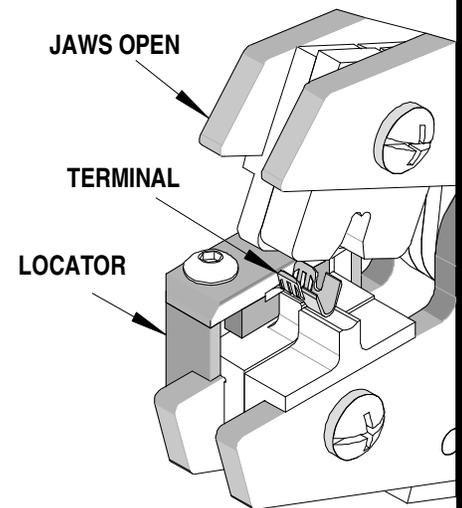


Figure 1

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

**Maintenance**

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

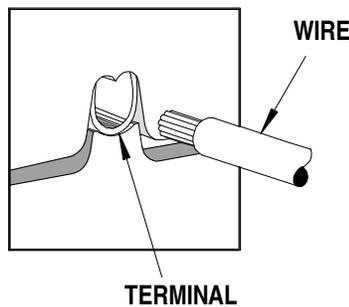


Figure 2

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.

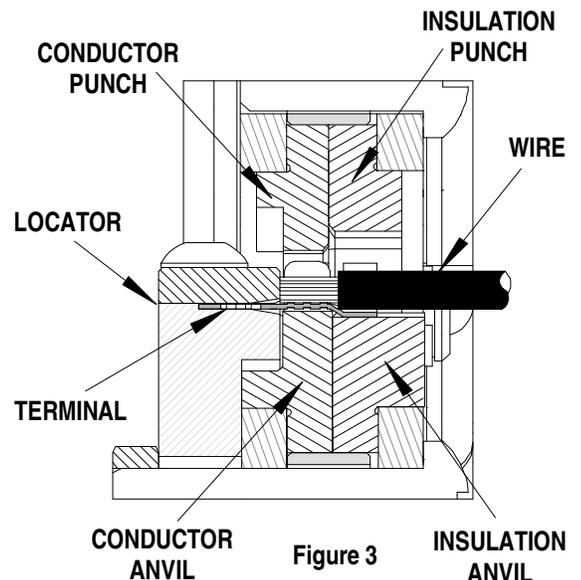


Figure 3

## 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 lifting the ratchet release lever. See Figure 4.

## How to Adjust Tool Crimp Force (See Figure 4)

It may be necessary over the life of the tool to adjust tool-crimping force. Listed below are the steps required to adjust the crimping force of the hand tool 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 counter-clockwise 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 would 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.

Hand held crimping tools are intended for low volume, prototyping, or repair requirements only.

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

## 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 above). Variations in tools, terminals, wire stranding and insulation types may affect crimp height.
3. This tool is intended for standard conductor sizes. It may not give a good insulation crimp support for all insulation sizes.
4. Molex does not repair hand tools (see warranty above) 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 wire insulation or the conductor. Refer to Molex Quality Crimping Handbook 63800-0029 for additional information on crimping and crimp testing.
6. Molex does not certify crimp hand tools.

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

**PARTS LIST**

Item Number	Order Number	Description	Quantity
1	63811-2075	Locator Assembly**	1
2	64000-0076	Repair Kit (Not included)	0

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

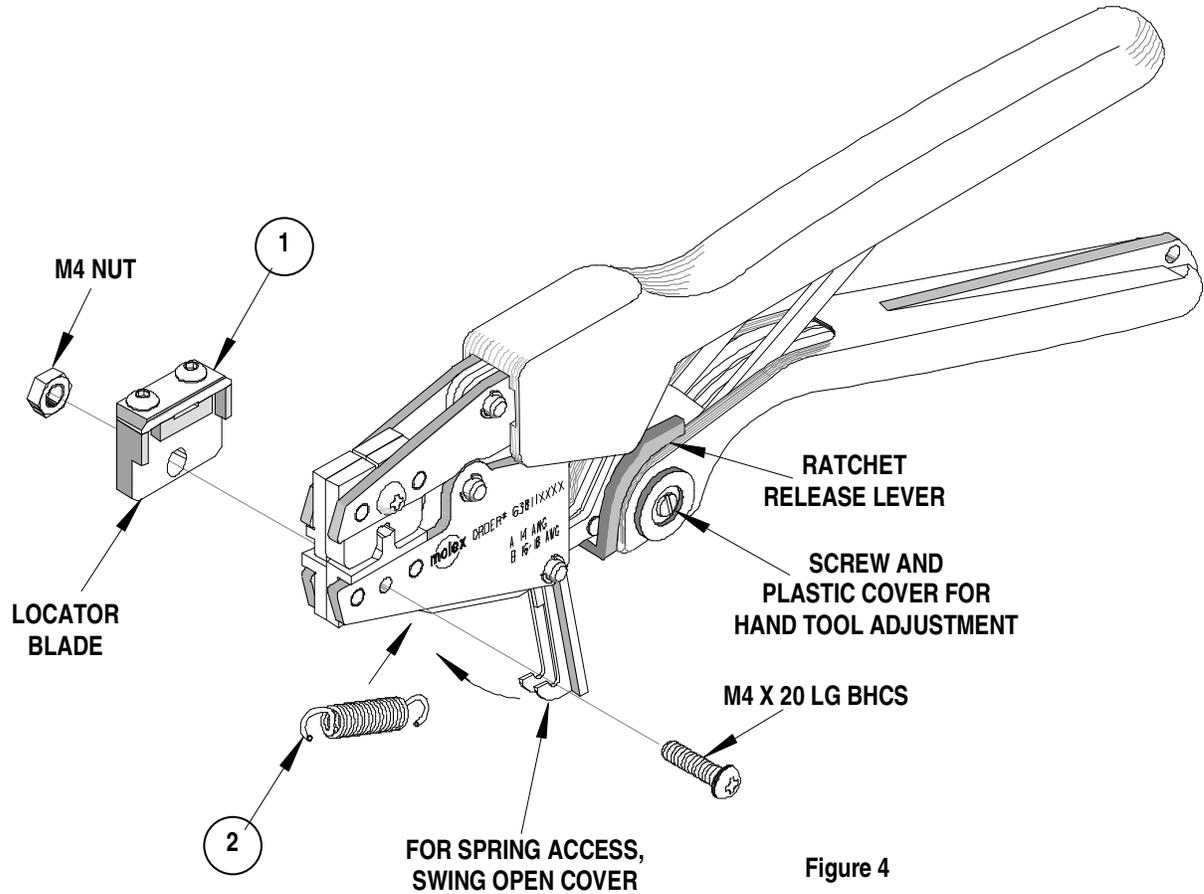


Figure 4

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