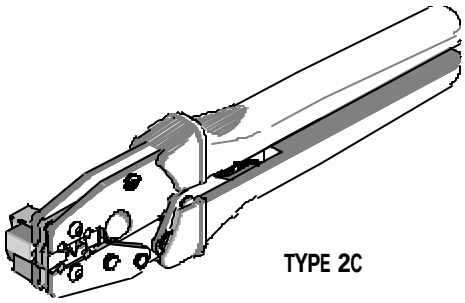
HAND CRIMP TOOL SPECIFICATION SHEET Order No. 63811-3300 (Replaces 11-01-0008 HTR1719C)

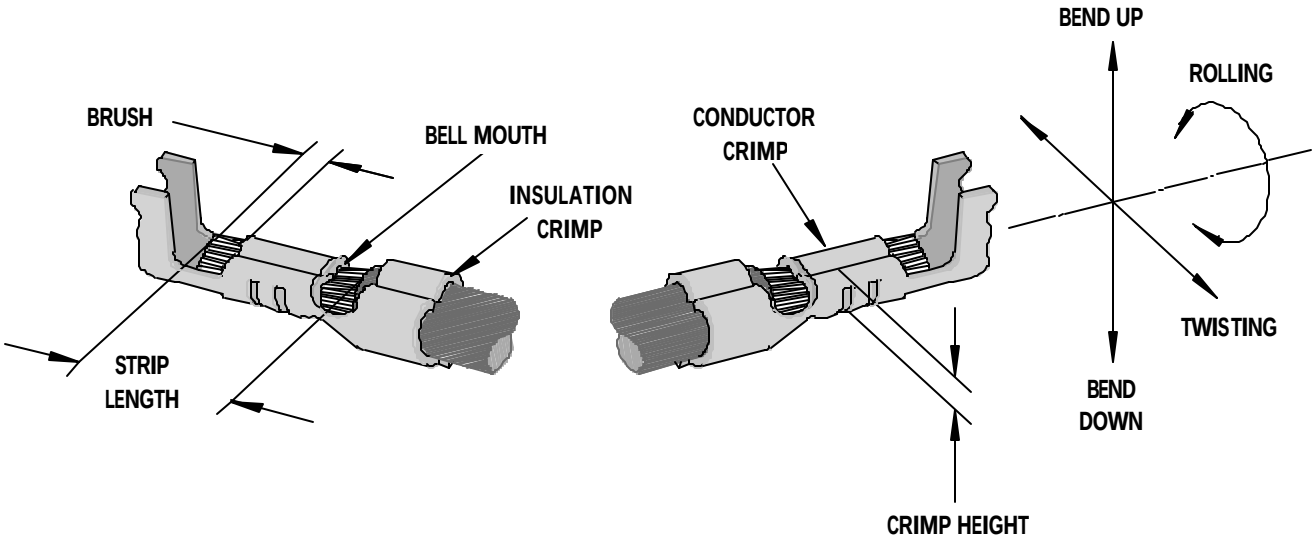


TYPE 2C

SCOPE

Terminal Series No.	Wire Size		Insulation Diameter		Strip Length	
	AWG	mm²	mm	In.	mm	In.
1560	18-24	0.82-0.20	1.52-3.05	.060-.120	2.41-3.04	.095-.120
1561	18-24	0.82-0.20	1.52-3.05	.060-.120	2.41-3.04	.095-.120
1786	18-24	0.82-0.20	1.52-3.05	.060-.120	2.41-3.04	.095-.120
1787	18-24	0.82-0.20	1.52-3.05	.060-.120	2.41-3.04	.095-.120
1799	18-24	0.82-0.20	1.52-3.05	.060-.120	2.41-3.04	.095-.120
1943	18-24	0.82-0.20	1.52-2.79	.060-.110	2.41-3.04	.095-.120
4529	18-24	0.82-0.20	1.52-3.05	.060-.120	2.41-3.04	.095-.120
5005	18-24	0.82-0.20	1.30-3.00	.051-.118	2.30-2.95	.090-.116
5006	18-24	0.82-0.20	1.30-3.00	.051-.118	2.30-2.95	.090-.116
6770	18-24	0.82-0.20	1.52-3.05	.060-.120	2.41-3.04	.095-.120
6772	18-24	0.82-0.20	1.52-3.05	.060-.120	2.41-3.04	.095-.120
7291	18-24	0.82-0.20	1.52-3.05	.060-.120	2.41-3.04	.095-.120
8662	18-24	0.82-0.20	1.52-2.79	.060-.110	2.41-3.04	.095-.120
8960	18-24	0.82-0.20	1.52-2.79	.060-.110	2.41-3.04	.095-.120

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 5).

Terminal Series No.	Hand Tool Locator	Wire Size		Conductor Crimp Height (REF)		Conductor Crimp Width (Ref)		Pull Force Min.		Profile	
		AWG	mm^2	mm	In.	mm	In.	N	Lb.	A	B
1560	1	18	0.82	1.02-1.12	.040-.044	1.95	.077	89.0	20.00	X	
1560	1	20	0.52	0.87-0.97	.034-.038	1.95	.077	66.8	15.00		X
1560	1	22	0.32	0.87-0.97	.034-.038	1.95	.077	44.5	10.00		X
1560	1	24	0.20	0.87-0.97	.034-.038	1.95	.077	35.6	8.00		X
1561	1	18	0.82	1.02-1.12	.040-.044	1.95	.077	89.0	20.00	X	
1561	1	20	0.52	0.87-0.97	.034-.038	1.95	.077	66.8	15.00		X
1561	1	22	0.32	0.87-0.97	.034-.038	1.95	.077	44.5	10.00		X
1561	1	24	0.20	0.87-0.97	.034-.038	1.95	.077	35.6	8.00		X
1786	1	18	0.82	1.02-1.12	.040-.044	1.95	.077	89.0	20.00	X	
1786	1	20	0.52	0.87-0.97	.034-.038	1.95	.077	66.8	15.00		X
1786	1	22	0.32	0.87-0.97	.034-.038	1.95	.077	44.5	10.00		X
1786	1	24	0.20	0.87-0.97	.034-.038	1.95	.077	35.6	8.00		X
1787	1	18	0.82	1.02-1.12	.040-.044	1.95	.077	89.0	20.00	X	
1787	1	20	0.52	0.87-0.97	.034-.038	1.95	.077	66.8	15.00		X
1787	1	22	0.32	0.87-0.97	.034-.038	1.95	.077	44.5	10.00		X
1787	1	24	0.20	0.87-0.97	.034-.038	1.95	.077	35.6	8.00		X
1799	2	18	0.82	1.02-1.12	.040-.044	1.95	.077	111.3	25.00	X	
1799	2	20	0.52	0.87-0.97	.034-.038	1.95	.077	66.8	15.00		X
1799	2	22	0.32	0.87-0.97	.034-.038	1.95	.077	53.4	12.00		X
1799	2	24	0.20	0.87-0.97	.034-.038	1.95	.077	35.6	8.00		X
1943	1	18	0.82	1.02-1.12	.040-.044	1.95	.077	111.3	25.00	X	
1943	1	20	0.52	0.87-0.97	.034-.038	1.95	.077	66.8	15.00		X
1943	1	22	0.32	0.87-0.97	.034-.038	1.95	.077	53.4	12.00		X
1943	1	24	0.20	0.87-0.97	.034-.038	1.95	.077	35.6	8.00		X
4529	1	18	0.82	1.02-1.12	.040-.044	1.95	.077	89.0	20.00	X	
4529	1	20	0.52	0.87-0.97	.034-.038	1.95	.077	66.8	15.00		X
4529	1	22	0.32	0.87-0.97	.034-.038	1.95	.077	44.5	10.00		X
4529	1	24	0.20	0.87-0.97	.034-.038	1.95	.077	35.6	8.00		X
5005	1	18	0.82	1.02-1.12	.040-.044	1.95	.077	98.0	22.00	X	
5005	1	20	0.52	0.87-0.97	.034-.038	1.95	.077	66.8	15.00		X
5005	1	22	0.32	0.87-0.97	.034-.038	1.95	.077	53.4	12.00		X
5005	1	24	0.20	0.87-0.97	.034-.038	1.95	.077	35.6	8.00		X
5006	1	18	0.82	1.02-1.12	.040-.044	1.95	.077	98.0	22.00	X	
5006	1	20	0.52	0.87-0.97	.034-.038	1.95	.077	66.8	15.00		X
5006	1	22	0.32	0.87-0.97	.034-.038	1.95	.077	53.4	12.00		X
5006	1	24	0.20	0.87-0.97	.034-.038	1.95	.077	35.6	8.00		X

CONDITIONS: (Continued)

Terminal Series No.	Hand Tool Locator	Wire Size		Conductor Crimp Height (REF)		Conductor Crimp Width (Ref)		Pull Force Min.		Profile	
		AWG	mm^2	mm	In.	mm	In.	N	Lb.	A	B
6770	1	18	0.82	1.02-1.12	.040-.044	1.95	.077	89.0	20.00	X	
6770	1	20	0.52	0.87-0.97	.034-.038	1.95	.077	66.8	15.00		X
6770	1	22	0.32	0.87-0.97	.034-.038	1.95	.077	44.5	10.00		X
6770	1	24	0.20	0.87-0.97	.034-.038	1.95	.077	35.6	8.00		X
6772	1	18	0.82	1.02-1.12	.040-.044	1.95	.077	89.0	20.00	X	
6772	1	20	0.52	0.87-0.97	.034-.038	1.95	.077	66.8	15.00		X
6772	1	22	0.32	0.87-0.97	.034-.038	1.95	.077	44.5	10.00		X
6772	1	24	0.20	0.87-0.97	.034-.038	1.95	.077	35.6	8.00		X
7291	1	18	0.82	1.02-1.12	.040-.044	1.95	.077	89.0	20.00	X	
7291	1	20	0.52	0.87-0.97	.034-.038	1.95	.077	66.8	15.00		X
7291	1	22	0.32	0.87-0.97	.034-.038	1.95	.077	44.5	10.00		X
7291	1	24	0.20	0.87-0.97	.034-.038	1.95	.077	35.6	8.00		X
8662	1	18	0.82	1.02-1.12	.040-.044	1.95	.077	111.3	25.00	X	
8662	1	20	0.52	0.87-0.97	.034-.038	1.95	.077	66.8	15.00		X
8662	1	22	0.32	0.87-0.97	.034-.038	1.95	.077	44.5	10.00		X
8662	1	24	0.20	0.87-0.97	.034-.038	1.95	.077	31.4	7.00		X
8960	1	18	0.82	1.02-1.12	.040-.044	1.95	.077	111.3	25.00	X	
8960	1	20	0.52	0.87-0.97	.034-.038	1.95	.077	66.8	15.00		X
8960	1	22	0.32	0.87-0.97	.034-.038	1.95	.077	44.5	10.00		X
8960	1	24	0.20	0.87-0.97	.034-.038	1.95	.077	31.4	7.00		X

OPERATION

Caution: Install only Molex terminals listed above with this tool. Do not crimp hardened objects 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.

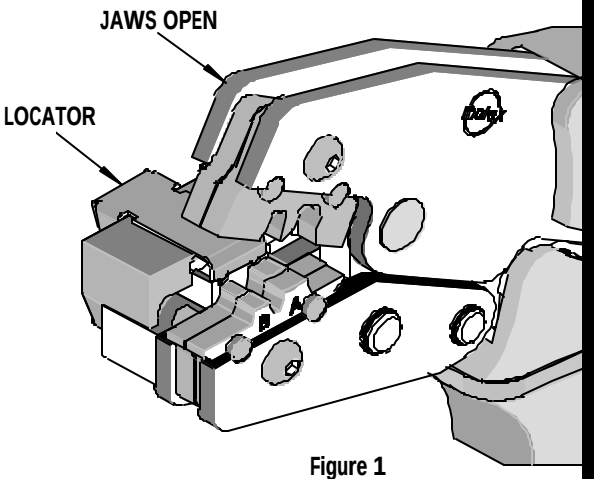


Figure 1

Crimping Terminals

1. Select the desired terminal listed in the preceding charts. Make sure that the proper locator is mounted on the tool.
2. Swing the terminal locator away from the crimp tool shown in Figure 2.
3. When using 63811-3375 (Locator No. 1), press down on the wire stop on the locator as shown in Figure 2. Insert the proper terminal into the proper nest opening. Make sure when choosing the nest opening, it will correspond with the A or B profile on the hand tool. Partially close the tool until the terminal is held in place.

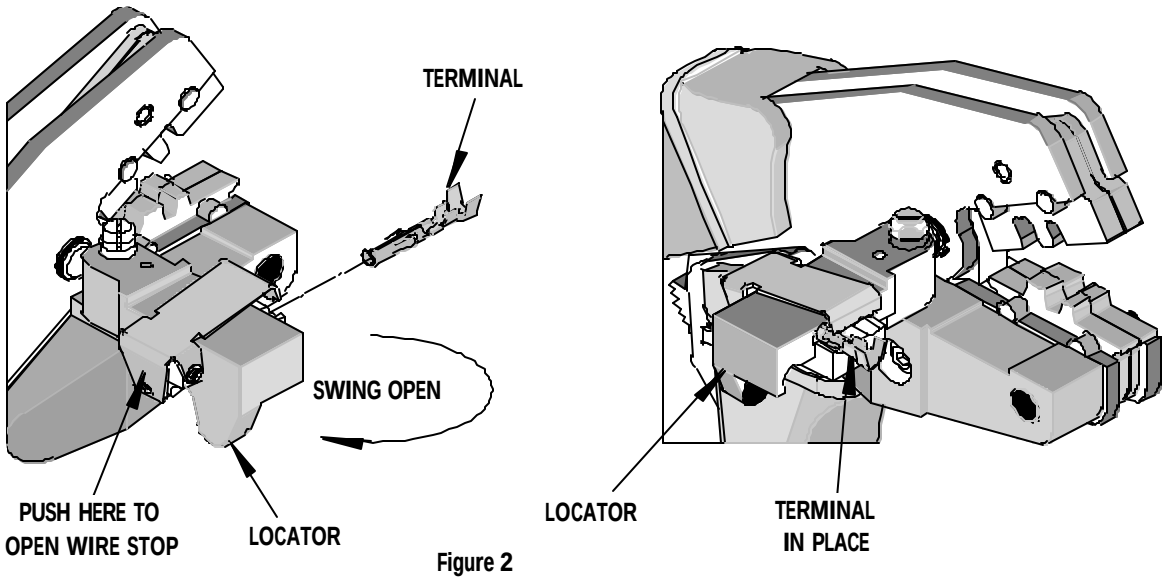


Figure 2

4. Return the locator to its original position.
5. Insert the proper wire over the terminal. Gently touch the wire stop with the end of the wire. See Figure 3.
6. 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.

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

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 on pages 2 and 3.

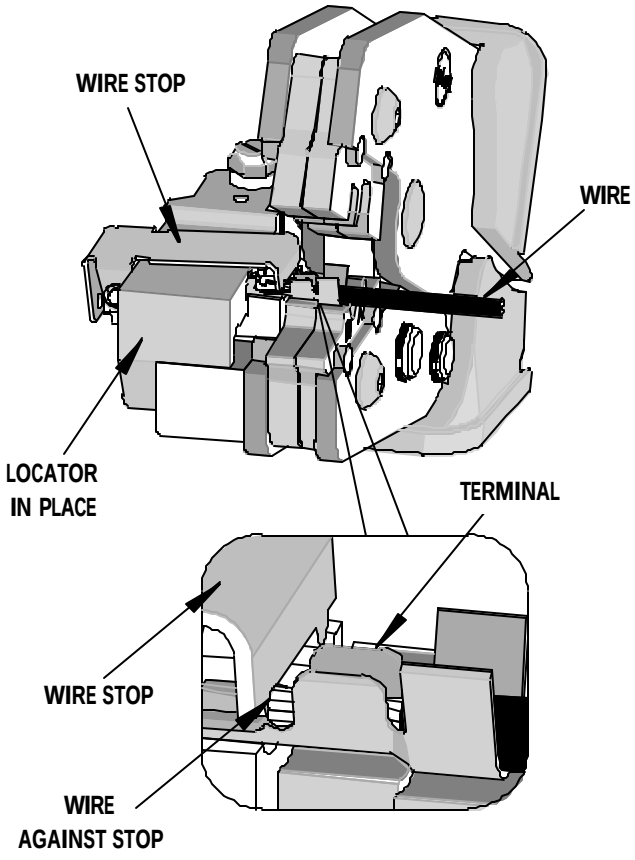


Figure 3

Locator Change Over

Two styles of locators are provided with the crimp hand tool 63811-3300. They are locator no. 1 (63811-3375), which is black and locator no.2 (63811-3376), which is gray. Make sure the desired style of locator is installed for the proper terminal and wire. Follow the steps below to change the locators.

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. See Figure 4.
4. Replace it with the desired locator by putting over the brass pivot shaft and snapping it into place.

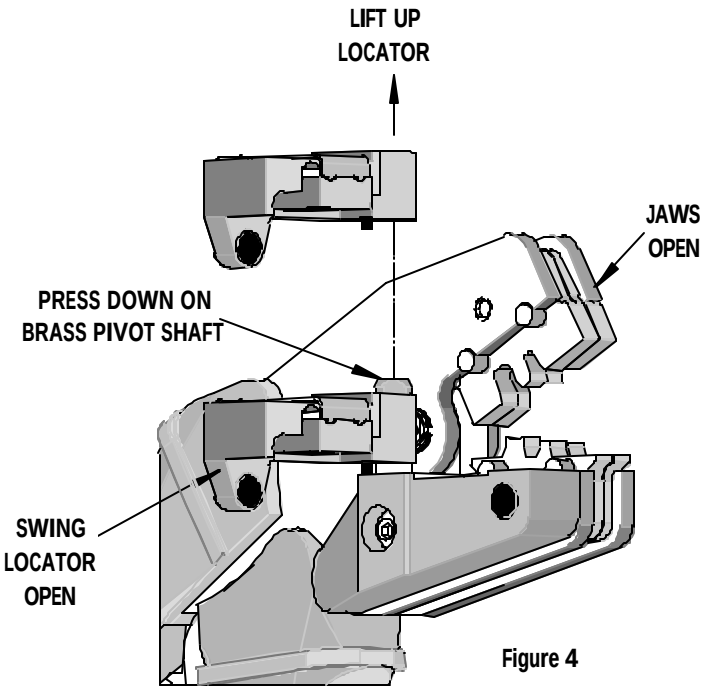


Figure 4

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 63811-3300 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. A light oil such as 30 weights automotive oil used at the oil points shown in Figure 6, every 5,000 crimps or 3 months, 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.

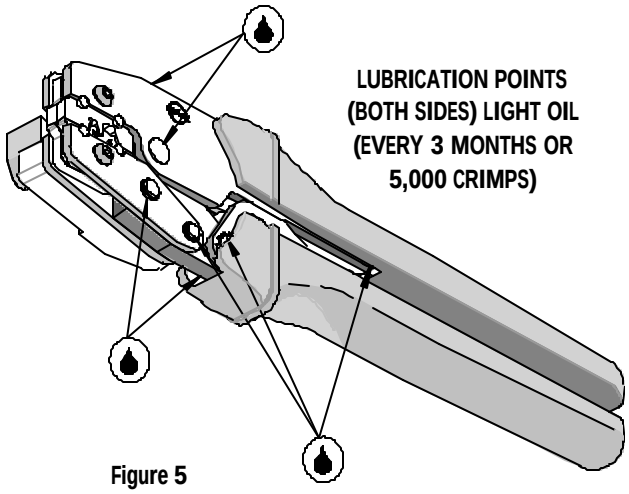


Figure 5

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 counter.
2. Remove the locking screw. The wrench set (63810-0101), is not supplied. It is sold separately from the hand tool. See our website or contact your sales engineer.
3. Turning the eccentric axle counter-clockwise (CCW) will 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 after tool handle preload force is adjusted.

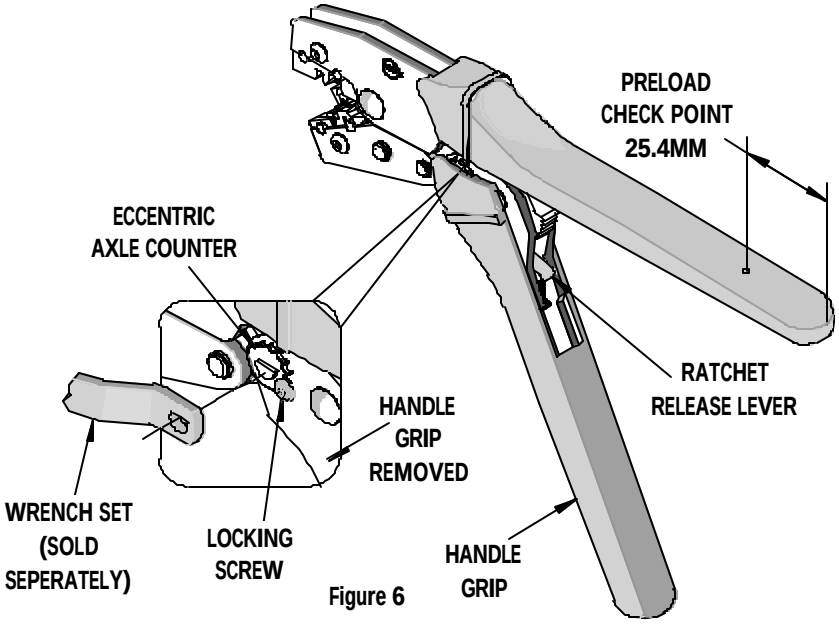


Figure 6

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.

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 Molex Terminal specified for crimping with the 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.

- Qualified to pull force only crimp a wire stripped to 12.7mm (1/2").
- 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
1	63810-0101	Wrench Set (Not included)	0
2	63810-0102	Locator Base Assembly	1
3	63810-0103	Repair Kit (Not included)	0
4	63811-3375	Locator #1-Black	1
5	63811-3376	Locator #2-Gray	1

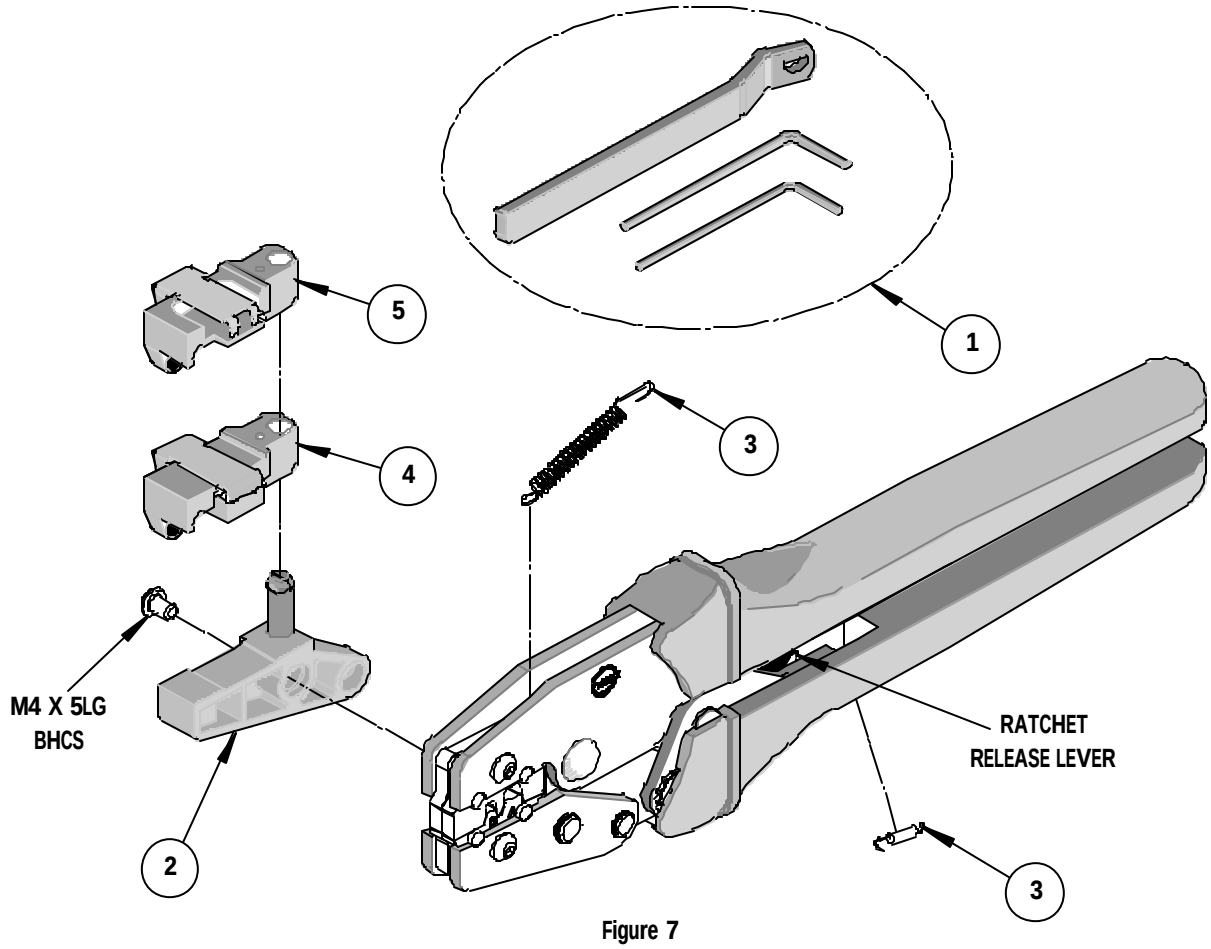


Figure 7

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