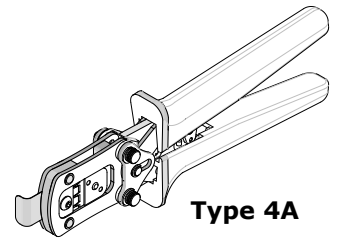


Order Number
63825-8800

molex®

Application Tooling Specification



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
- IPC/WHMA-A-620 Class 2 compliant as indicated and RoHS compliant
- Modular crimp head is removable and can be used in the Electric Crimp Machine (Order No. 63816-1500), accompanied by Battery Powered Crimp Adapter (Order No. 63816-0600)
- Can also be used in the Battery Powered Tool Order No. 63816-0270 (110 V) or 63816-0280 (220 V), accompanied by Battery Powered Crimp Adapter (Order No. 63816-0600)

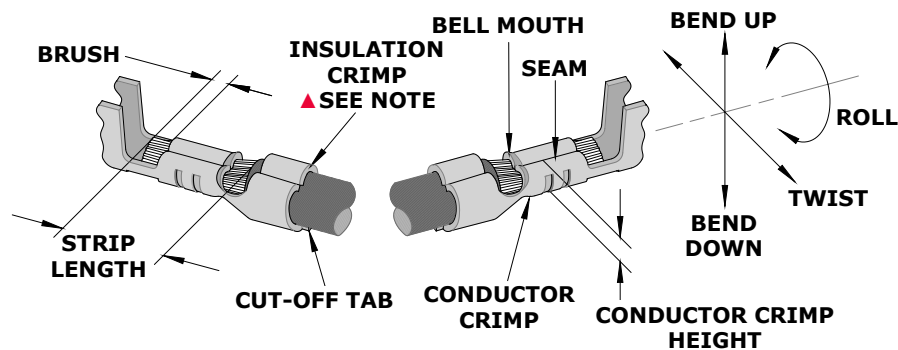
SCOPE

Products: SL Crimp Terminals, 24-30 AWG.

Terminal Series No.	Terminal Order No.				Wire Size	Insulation Diameter		Strip Length	
	Loose Piece		*Reel		AWG	mm	In.	mm	In.
50083	50083-8100	50083-8160	50083-8000	50083-8060	24-30	1.01-1.52	.040-.060	2.54-3.17	.100-.125
	50083-8114	50083-8170	50083-8114	50083-8070					
50087	50087-8100	50087-8130	50087-8000	50087-8060	24-30	1.01-1.52	.040-.060	2.54-3.17	.100-.125
	50087-8114	50087-8160	50087-8014	50087-8099					
			50087-8030						
70021	16-02-0108	40-08-0872	16-02-0077	16-02-0105	24-30	1.01-1.52	.040-.060	2.54-3.17	.100-.125
	16-02-0109		16-02-0078	40-08-0871					
	16-02-0110		16-02-0091						
70058	16-02-0096	70058-0096	16-02-0069	16-02-0150	24-30	1.01-1.52	.040-.060	2.54-3.17	.100-.125
	16-02-0097	70058-0097	16-02-0082	70058-0069					
	16-02-0098	70058-4096	16-02-0083	70058-0082					
	16-02-0140		16-02-0137	70058-0083					
	16-02-0151		16-02-0139	70058-4069					
71851	16-02-1109	16-02-0117	16-02-1112	16-02-0119	24-30	1.01-1.52	.040-.060	2.54-3.17	.100-.125
	16-02-1116	16-02-1117	16-02-1113	71851-0119					
*Customer to cut off terminal from reel. See crimp specifications for desired terminal series.									

CAUTION: Lubrication must be applied to the conductor punch to prevent terminal sticking.

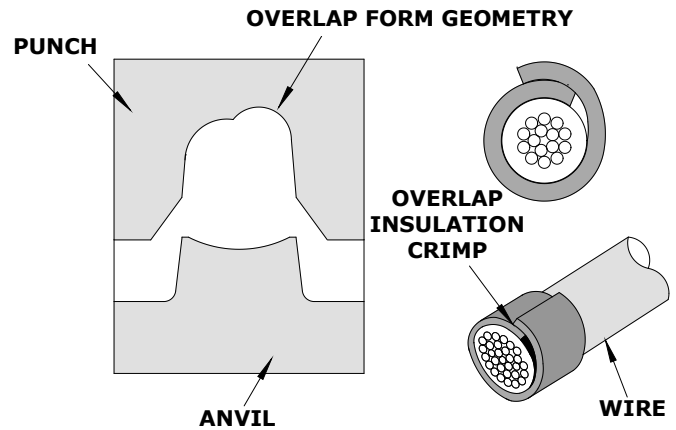
DEFINITION OF TERMS



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

▲ Insulation Crimp Note

Because of the terminal's insulation grip design or insulation diameter range, this tool uses overlap form geometry in the insulation punch. This produces an overlap insulation crimp (A-620-compliant). Although the insulation punch profile may appear lopsided, this is a normal condition for this tool. See figure to the right. Some tools with multiple crimp pockets may not have the overlap profile on all pockets.



CRIMP SPECIFICATIONS

Terminal Series No.	Bell Mouth		Cut-Off Tab Maximum				Conductor Brush	
	mm	In.	Front		Rear		mm	In.
50083	0.20-0.50	.008-.020	0.15	.006	0.30	.012	0.00-1.00	.000-.039
50087	0.20-0.50	.008-.020	0.15	.006	0.30	.012	0.00-1.00	.000-.039
70021	0.20-0.50	.008-.020	0.13	.005	0.13	.005	0.00-1.00	.000-.039
70058	0.20-0.50	.008-.020	0.13	.005	0.08	.003	0.00-1.00	.000-.039
71851	0.20-0.50	.008-.020	0.13	.005	0.08	.003	0.00-1.00	.000-.039

Terminal Series No.	Bend Up	Bend Down	Twist	Roll	Seam
	Degree		Degree		
50083	3	3	3	8	Seam shall not be open and no wire allowed out of the crimping area
50087	3	3	3	8	
70021	3	3	3	8	
70058	3	3	3	8	
71851	3	3	3	8	

After crimping, the conductor profiles should measure the following:

Terminal Series No.	Wire Size AWG	Conductor Crimp				Insulation Crimp				Pull Force Minimum		Profile			
		Height		Width (Ref.)		Height (Ref.)		Width (Ref.)		N	Lb.	24	26	28	30
		mm	In.	mm	In.	mm	In.	mm	In.						
50083	24	0.79-0.87	.031-.034	1.05	.041	1.60	.063	1.60	.063	29.4	6.61	X			
	26	0.74-0.81	.029-.032	1.05	.041	1.58	.062	1.58	.062	19.6	4.41		X		
	28	0.71-0.78	.028-.031	1.05	.041	1.55	.061	1.58	.062	9.8	2.20			X	
	30	0.67-0.74	.026-.029	1.05	.041	1.55	.061	1.57	.062	4.9	1.10				X
50087	24	0.79-0.87	.031-.034	1.05	.041	1.60	.063	1.60	.063	29.4	6.61	X			
	26	0.74-0.81	.029-.032	1.05	.041	1.58	.062	1.58	.062	19.6	4.41		X		
	28	0.71-0.78	.028-.031	1.05	.041	1.55	.061	1.58	.062	9.8	2.20			X	
	30	0.67-0.74	.026-.029	1.05	.041	1.55	.061	1.57	.062	4.9	1.10				X
70021	24	0.79-0.84	.031-.033	1.05	.041	1.60	.063	1.60	.063	28.9	6.50	X			
	26	0.74-0.79	.029-.031	1.05	.041	1.58	.062	1.58	.062	17.8	4.00		X		
	28	0.71-0.76	.028-.030	1.05	.041	1.55	.061	1.58	.062	11.1	2.50			X	
	30	0.66-0.71	.026-.028	1.05	.041	1.55	.061	1.57	.062	6.7	1.50				X
70058	24	0.79-0.84	.031-.033	1.05	.041	1.60	.063	1.60	.063	28.9	6.50	X			
	26	0.74-0.79	.029-.031	1.05	.041	1.58	.062	1.58	.062	17.8	4.00		X		
	28	0.71-0.76	.028-.030	1.05	.041	1.55	.061	1.58	.062	11.1	2.50			X	
	30	0.66-0.71	.026-.028	1.05	.041	1.55	.061	1.57	.062	6.7	1.50				X
71851	24	0.79-0.84	.031-.033	1.05	.041	1.60	.063	1.60	.063	28.9	6.50	X			
	26	0.74-0.79	.029-.031	1.05	.041	1.58	.062	1.58	.062	17.8	4.00		X		
	28	0.71-0.76	.028-.030	1.05	.041	1.55	.061	1.58	.062	11.1	2.50			X	
	30	0.66-0.71	.026-.028	1.05	.041	1.55	.061	1.57	.062	6.7	1.50				X

●To achieve IPC/WHMA-A-620 Class 2 Crimps, the following overall wire insulation diameter ranges are recommended:
Profile 24: 1.25-1.40mm (.049-.055") **Profile 26:** 1.15-1.35mm (.045-.053")
Profile 28: 1.10-1.30mm (.043-.051") **Profile 30:** 1.10-1.25mm (.043-.049")

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.

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. 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 are damaged or worn, a new tool must be purchased.
5. Pull force should be used as the final criterion for an acceptable crimp. Pull force is measured with no influence from the insulation crimp. The insulation should be stripped long (.50") 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 hand crimp tools.

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.

1. With the hand tool in the open position, pivot the terminal locator open by pulling on the locator knob and lift the wire stop blade. See Figure 1.
2. Insert the terminal into the correct profile until the terminal is fully seated and stops. Make sure the wire stop blade is fully in up position.
3. Gently pivot the locator closed.
4. Bring down the wire stop blade. Make sure the wire stop blade is fully seated on the terminal, behind the conductor grip section.

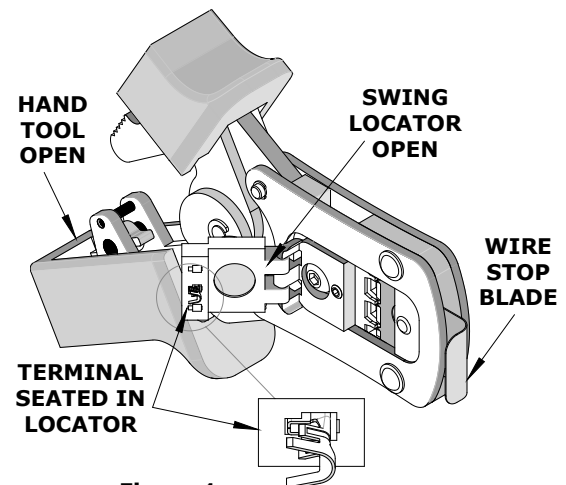


Figure 1

5. Slide the pre-stripped wire into the terminal. Make sure to aim the wire brush toward the tip point on the wire stop blade. See Figure 2. Align the wire so that it is parallel and sitting into the terminal. Maintain a light and constant pressure on the wire that is seated in the terminal at all times. (Do not let go of the wire.) Be sure to hold the wire and terminal in place until the terminal is fully crimped. See Figure 3.

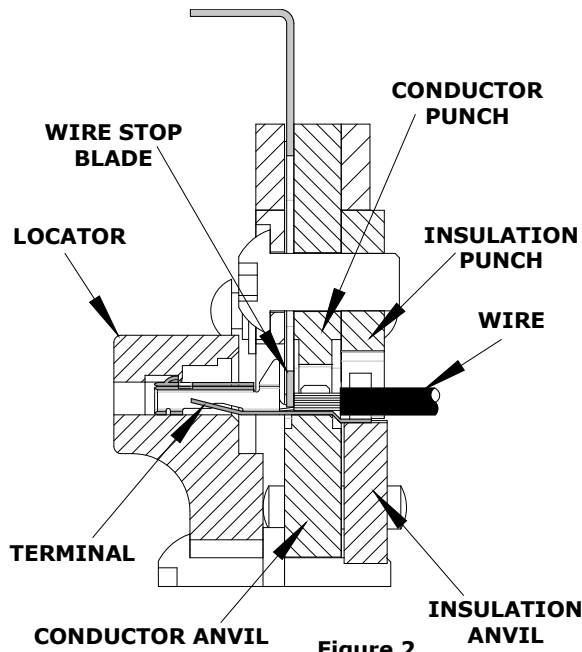


Figure 2

6. Close the tool until the ratchet releases. The tool handles will then spring open.
7. Lift up on the wire stop blade.
8. Carefully remove the crimped terminal. Pivot the terminal locator slightly out if necessary. See Figure 4.

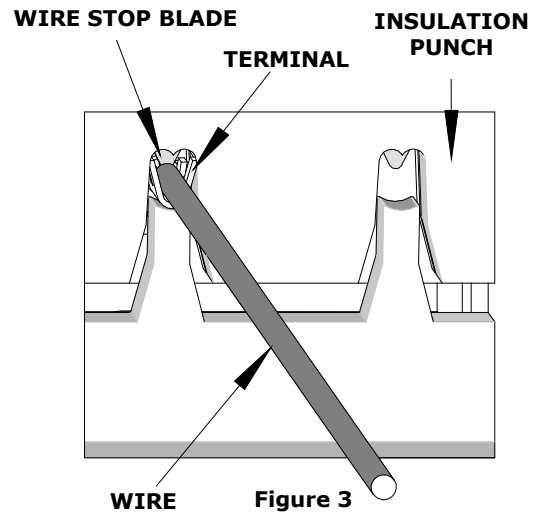
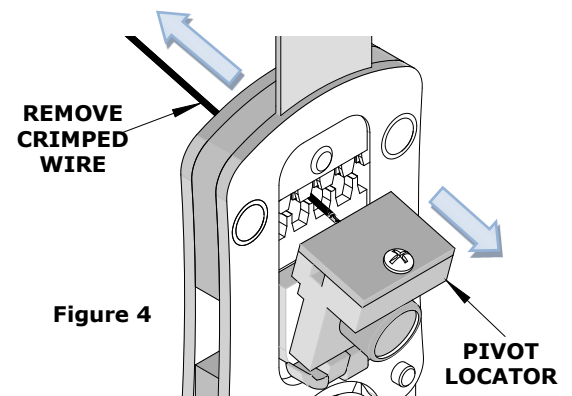


Figure 3



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

Note: To maintain good brush control and a consistent bell mouth, the crimping instructions must be followed.

TERMINAL LOCATOR REPLACEMENT

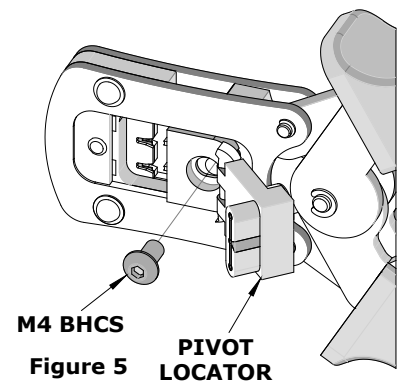
This section describes the procedure for changing locators.

Removal

1. With the tool in the open position, pivot the terminal locator outward.
2. Remove the M4 BHCS. See Figure 5.

Installation

1. Place the replacement locator on the hand tool. Install the M4 BHCS. See Figure 5.
2. Tighten the screw enough to hold the locator. Make sure the locator can still float freely with hand pressure.
3. Insert the proper terminal into the correct profile slot until the terminal is fully seated and stops. Then, gently pivot the locator closed.



Hand Crimp Tool For SL Crimp Terminals

4. With hand pressure, slowly slide the locator to the correct position. See Figure 6.
5. Gently pivot the locator open without disturbing the location.
6. Hold the locator firmly in place and slowly tighten the M4 BHCS.

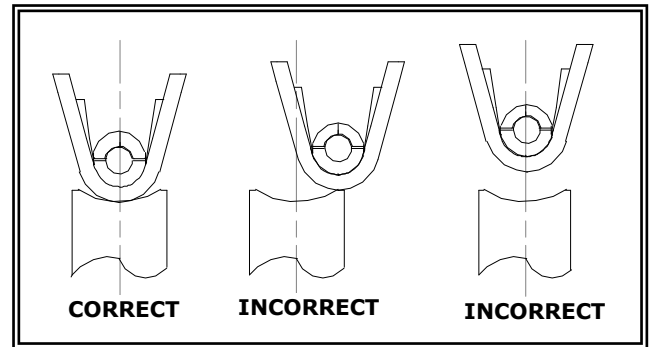


Figure 6

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 are protected with a thin coat of high-quality machine oil. Do not oil excessively. The tool was engineered for durability, but like any other equipment, it needs cleaning and lubrication for a maximum service life of trouble-free crimping. Light oil (such as 30 weight automotive oil) used at the oil points every 5,000 crimps or 3 months will significantly enhance the tool life.
4. Wipe excess oil from the hand tool, particularly from the crimping area. Oil transferred from the crimping area onto certain terminations may affect the electrical characteristics of an application.
5. When the 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

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 10.

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, Molex 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.

CAUTION: Repetitive use of this tool should be avoided.

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 at all times.
4. Use only the Molex terminals specified for crimping with this tool.

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

APPLICATIONS FOR THE MODULAR CRIMP HEAD

WARNING: NEVER operate, service, install or adjust this modular crimp head without proper instruction and without first reading and understanding the instructions in the proper manual or specification sheet. See chart below for the correct manual or specification sheet.

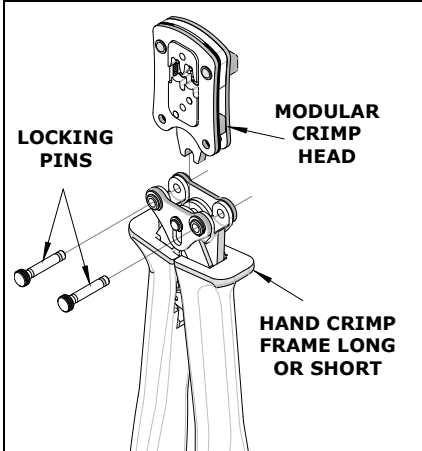
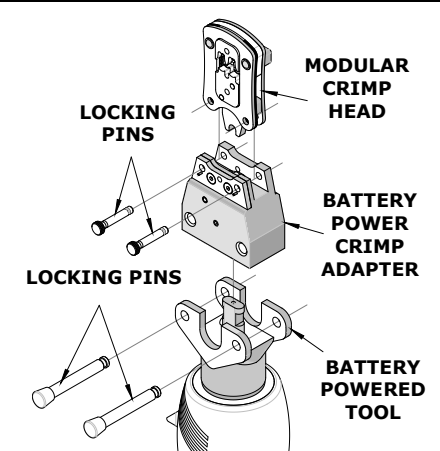
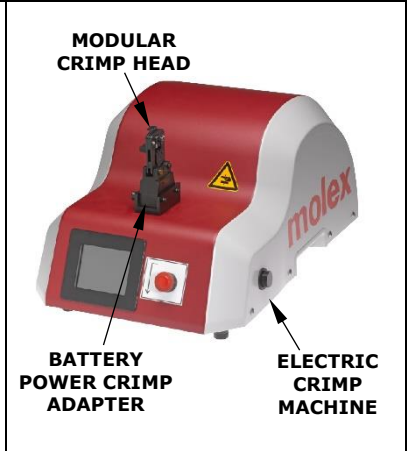
WARNING: NEVER install tooling or service this tool while it is plugged into any power source. Disconnect the power by unplugging, or turn off the actuator from its power source.

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.

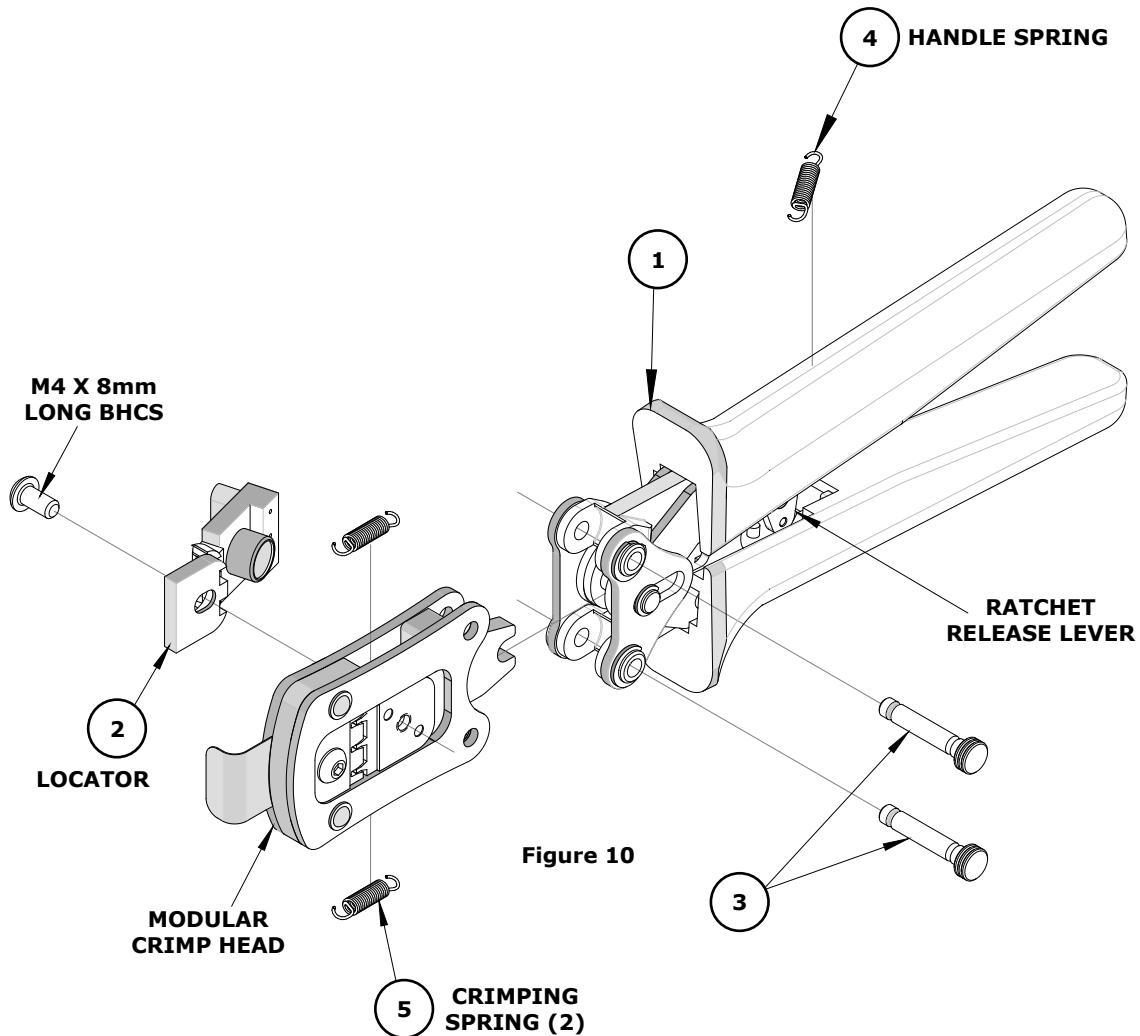
The chart below shows all applications for this modular crimp head:

Tool Order No.	Tool Description	Adapter Order No.	Adapter Description	Figure No.
63816-0000	Hand Crimp Frame (Short)	—	—	6
63816-0050	Hand Crimp Frame (Long)	—	—	6
63816-0270	Battery Power Tool (110 V)	63816-0600	Battery Power Crimp Adapter	7
63816-0280	Battery Power Tool (220 V)	63816-0600	Battery Power Crimp Adapter	7
63816-1500	Electric Crimp Machine	63816-0600	Battery Power Crimp Adapter	8

Applications for the Modular Crimp Head		
Hand Crimp Tool	Battery Powered Tool	Electric Crimp Machine
		
Figure 6	Figure 7	Figure 8

PARTS LIST

Item	Order Number	Description	Quantity
1	63816-0000	Hand Crimp Frame (Short)	1
2	63825-8875	Locator	1
3	63816-0001	Locking Pin	2
4	63600-0525	Handle Spring	1
5	63600-0520	Crimping Spring	2



Application Tooling Support

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