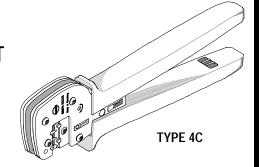


# HAND CRIMP TOOL **SPECIFICATION SHEET**

Order No. 63811-5300



### **FEATURES**

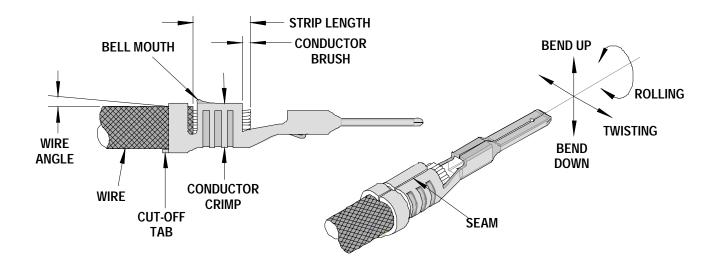
- A full cycle ratcheting hand tool ensures complete crimps
- Ergonomically designed soft handles
- Precisely designed crimping profiles with simple contact positioning
- Easy handling due to outstanding force ratio

### **SCOPE**

Products: MX150L<sup>TM</sup> 10-12 AWG

Terminal Series No.	Terminal (	Wire Size		Insulation Diameter		Strip Length		
Terriniai Series No.	Loose Piece	Reel	AWG	mm²	mm	ln.	mm	ln.
19431	19431-0016	19431-0001	10-12	5.26-3.31	3.90-4.85	.153191	5.50-6.20	.217244
19434	19434-0003	19434-0001	10-12	5.26-3.31	3.90-4.85	.153191	5.50-6.20	.217244
Customer to cut off terminal from reel: 0.50mm (.020") maximum Cut-off Tab.								

### **DEFINITION OF TERMS**



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#### **CRIMP SPECIFICATION**

Terminal Series No.	Bell Mouth		Bend up I	Twist Roll		Conductor Brush		Wire Angle	
Terriniai Series No.	mm	ln.	Degree		Degree		mm	ln.	Degree
19431	0.25-1.25	.010049	2	3	4	8	0.10-0.50	.004020	5° Max
19434	0.25-1.25	.010049	2	3	4	8	0.10-0.50	.004020	5° Max
Seam: Seam shall not be open and no wire allowed out of the crimping area.									

#### **CONDITIONS:**

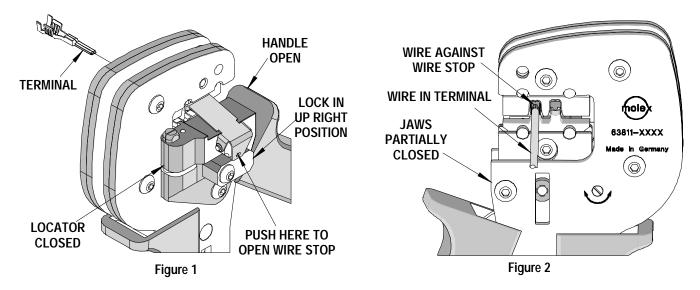
After crimping, the conductor profiles should measure the following (See notes on page 4).

Terminal	Wire Size		Conductor				Insulation				Pull Force	
Series No.		Crimp Height (Ref)		Crimp Width (Ref)		Crimp Height (Ref)		Crimp Width (Ref)		Minimum		
Series No.	AWG	mm <sup>2</sup>	mm	ln.	mm	ln.	mm	ln.	mm	ln.	N	Lb.
19431	10	5.26	2.45-2.55	.096100	3.70-3.90	.146154	5.00 Max	.197 Max	5.10-5.30	.201209	356.0	0.08
17431	12	3.31	2.05-2.15	.081085	3.70-3.90	.146154	4.50 Max	.177 Max	5.00-5.20	.197205	311.5	70.0
19434	10	5.26	2.45-2.55	.096100	3.70-3.90	.146154	5.00 Max	.197 Max	5.10-5.30	.201209	356.0	80.0
19434	12	3.31	2.05-2.15	.081085	3.70-3.90	.146154	4.50 Max	.177 Max	5.00-5.20	.197205	311.5	70.0

#### **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.



### **Crimping Terminals**

Swing the terminal locator against the crimp tool and turn the lock up to lock the locator. Terminals can be loaded easily while the locator is against the crimp tool and locked. The spring-loaded locator needs to be in the up position for terminals to load easily.

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- 1. To raise the wire stop, press the tab on the wire stop as shown in Figure 1. Insert the proper terminal into the nest opening and release the wire stop to lower it.
- 2. Insert the proper pre-striped wire over the terminal. Gently touch the wire stop with the end of the wire. See Figure 2 and 3.
- 3. Compress the terminal by squeezing the tool handles until the ratchet mechanism cycle has been completed. Release handles to open the jaws.

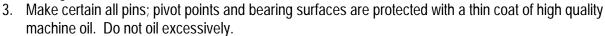
Note: The tamper proof ratchet action will not release the tool until it has been fully closed.

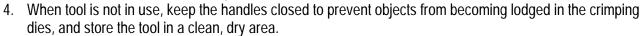
- 4. Remove the crimp terminal from the terminal locator by pressing the tab on the wire stop and gently pulling on the wire.
- 5. Visually inspect the crimped terminal for proper crimp location and crimp height.

### Maintenance

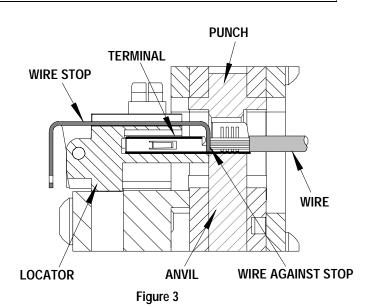
It is recommended that each operator of the tool be made aware of, and responsible for, the following maintenance steps:

- 1. Remove dust, moisture, and other contaminants with a clean brush, or soft, lint free cloth.
- 2. Do not use any abrasive materials that could damage the tool.





closed. The tool will open easily by rotating the small slotted screw marked with an arrow. See Figure 4.



### Miscrimps or Jams (See Figure 4)

## Should this tool ever become stuck or jammed in a partially closed position, **Do Not** force the handles open or

### 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.

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#### Notes:

- 1. This tool should only be used for the terminals and wire gauges specified on this sheet.
- 2. This tool is not adjustable. Variations in tools, terminals, wire stranding and insulation types may affect crimp height. A crimp height chart is provided with this manual as <u>Reference Only</u>.
- 3. 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.
- 4. An occasional destructive pull force test should be performed to check hand tool crimp. Pull force should be used as the final criteria for an acceptable crimp. Pull force values <u>Must</u> exceed the Minimum pull force specifications listed on pages 2 and 3. Refer to Molex Quality Crimping Handbook 63800-0029 for additional information on crimping and crimp testing.
- 5. Molex does not certify crimp hand tools.
- 6. This tool is very difficult to disassemble and reassemble. Customer repair is not recommended.

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

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### **PARTS LIST**

Item Number	Order Number	Description	Quantity
1	63811-4773	Locator Base with Lock	1
2	63811-5375	Locator	1

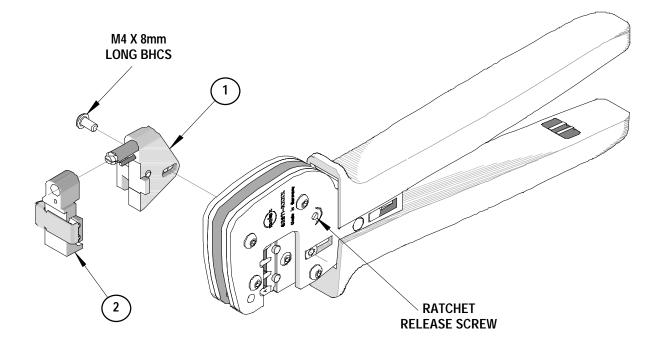


Figure 4

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