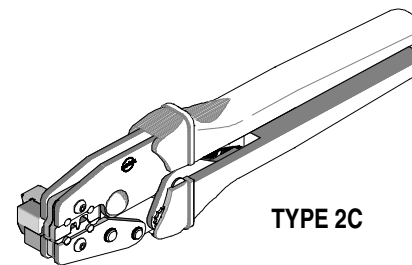




Hand Crimp Tool Specification Sheet Order No. 63811-7400



TYPE 2C

FEATURES

- A full cycle ratcheting hand tool ensures complete crimps
- Ergonomic soft grip handles for comfortable crimping
- A precision user-friendly terminal locator wire stop holds terminals in the proper crimping position
- This tool is IPC/WHMA-A-620 Class 2 and RoHS compliant

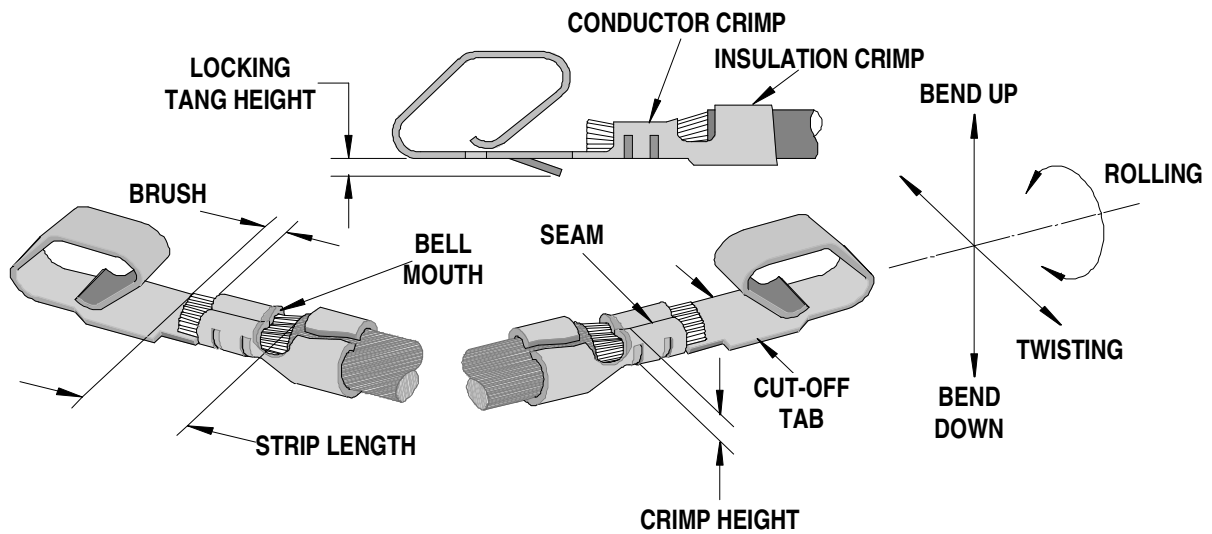
SCOPE

Products: 3.96mm (.156") Pitch KK® Crimp Terminal for 22-26 AWG

Terminal Series No.	Terminal Order No.				Wire Size		Insulation Diameter		Strip Length	
	Loose Piece		* Reel		AWG	mm ²	mm	In.	mm	In.
2578	08-50-0019	08-56-0122	08-50-0018	08-56-0161	22 - 26	0.35-0.12	1.20-1.52	.047-.060	2.54-3.17	.100-.125
	08-50-0062	08-56-0163	08-50-0061	08-56-0162						
	08-50-0066	08-58-0126	08-50-0065	08-58-0125						
	08-50-0108	08-60-0004	08-50-0107	08-59-0101						
	08-50-0112	08-65-0107	08-50-0111	08-60-0003						
	08-50-0134	08-65-0111	08-50-0133	08-65-0108						
	08-52-0117	08-65-0117	08-50-0504	08-65-0109						
	08-55-0106	40-01-1119	08-52-0116	08-65-0110						
	08-55-0132	40-07-1106	08-55-0105	08-65-0116						
	08-56-0108	50-29-1878	08-55-0121	40-01-1117						
			08-55-0123	40-07-1105						
			08-55-0137	50-29-1767						
			08-56-0107	50-29-1877						
		08-56-0121								
5168	08-70-0019	08-70-0099	08-70-0018	08-70-0098	22 - 26	0.35-0.12	1.20-1.52	.047-.060	2.54-3.17	.100-.125
7258	08-50-0185	08-58-0134	08-04-0001	08-56-0181	22 - 26	0.35-0.12	1.20-1.52	.047-.060	2.54-3.17	.100-.125
	08-52-0125	08-65-0122	08-50-0183	08-58-0133						
	08-56-0124	08-65-0127	08-50-0283	08-65-0121						
	08-56-0182		08-52-0124	08-65-0126						
		08-56-0123								

* Customer to cut off terminal from reel: .280mm (.110") maximum Cut-off Tab center.
* See Conditions on page 2.

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.	Wire Size		Conductor Crimp Height (Ref)		Punch Width (Ref)				Pull Force Minimum		Profile	
	AWG	mm ₂	mm	In.	Conductor		Insulation		N	Lb.	A	B
					mm	In.	mm	In.				
2578	22	0.35	.94-1.04	.037-.041	1.56	.061	1.94	.076	44.0	10.0	X	
	24	0.20	.84-.94	.033-.037	1.56	.061	1.56	.061	29.0	6.5		X
	26	0.12	.84-.94	.033-.037	1.56	.061	1.56	.061	18.0	4.0		X
5168	22	0.35	.94-1.04	.037-.041	1.56	.061	1.94	.076	44.0	10.0	X	
	24	0.20	.84-.94	.033-.037	1.56	.061	1.56	.061	29.0	6.5		X
	26	0.12	.84-.94	.033-.037	1.56	.061	1.56	.061	18.0	4.0		X
7258	22	0.35	.94-1.04	.037-.041	1.56	.061	1.94	.076	44.0	10.0	X	
	24	0.20	.84-.94	.033-.037	1.56	.061	1.56	.061	29.0	6.5		X
	26	0.12	.84-.94	.033-.037	1.56	.061	1.56	.061	18.0	4.0		X

OPERATION

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

1. Select the desired terminal listed in the preceding charts.
2. Swing the terminal locator away from the crimp tool shown in Figure 2. Some terminals with large insulation grips may interfere with the crimp tooling when swinging the locator into position. The terminal must then be loaded into the locator in the closed/crimp position.
3. When using the locator, 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.
4. Return the locator to its original position.
5. Insert the proper wire over the terminal. Some large O.D. wires may need to be placed into the terminal before closing the tool. 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. Release handles to open the jaws.

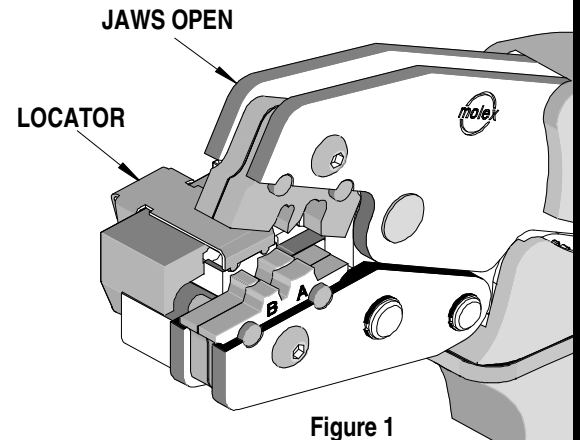


Figure 1

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

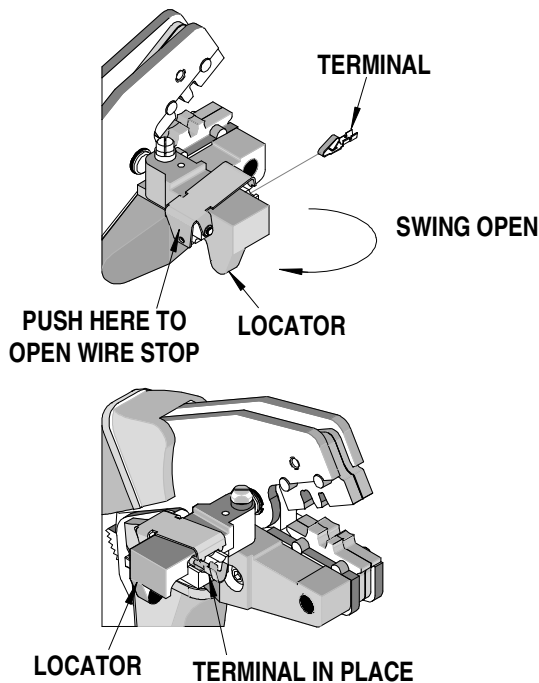
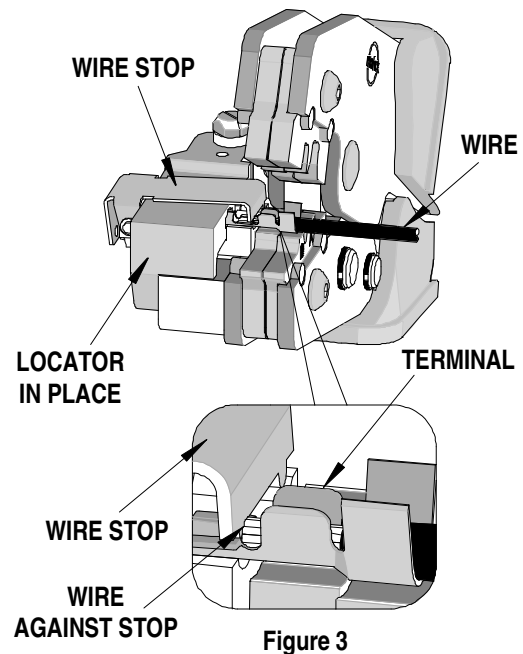


Figure 2



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

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 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 on page 2.

Locator Replacement

See the parts list on the last page of this document for the proper locator order number. Follow the steps below to replace the locator.

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 proper locator by putting over the brass pivot shaft and snapping it into place.

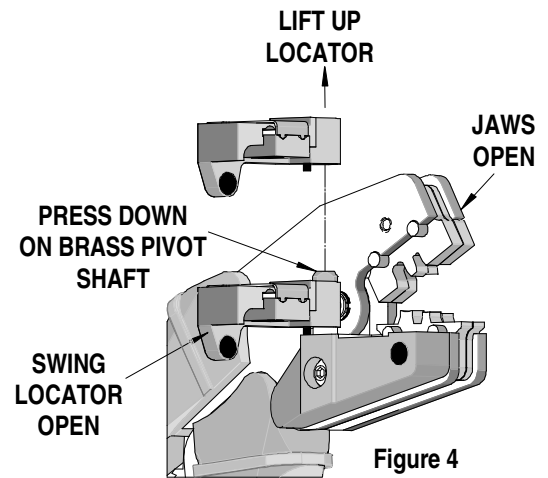


Figure 4

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 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. Light oil such as 30 weight automotive oil used at the oil points, every 5,000 crimps or 3 months, shown in Figure 6 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.

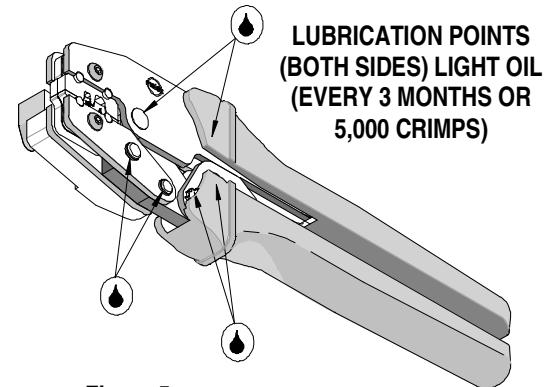


Figure 5

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 and setting wheel.
2. Remove the locking screw with a 2mm hex wrench. The wrench set (63810-0101), is not supplied. It is sold separately from the hand tool.
3. Turn the eccentric axle and setting wheel with the wrench or pliers Counter-clockwise (CCW) to 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 or conduct a pull test after tool handle preload force is adjusted.

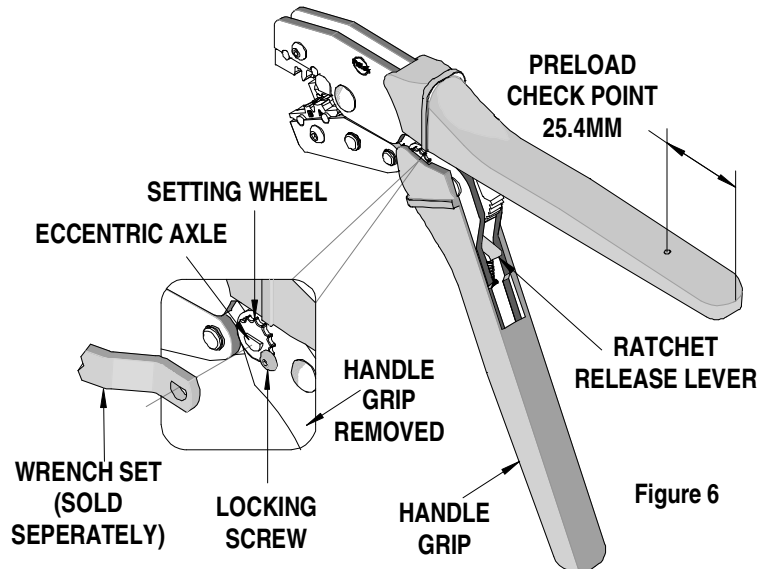


Figure 6

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.

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 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.

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, which has been stripped 12.7mm (1/2") long, so 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 web site for the Quality Crimp Handbook for more information on pull testing.
- % 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
REF	63811-7400	Hand Crimp Tool	Figure 7
1	63810-0101	Wrench Set (Not included)	0
2	63810-0102	Locator Base Assembly	1
3	63810-0103	Repair Kit (Not included)	0
4	63811-7475	Locator	1

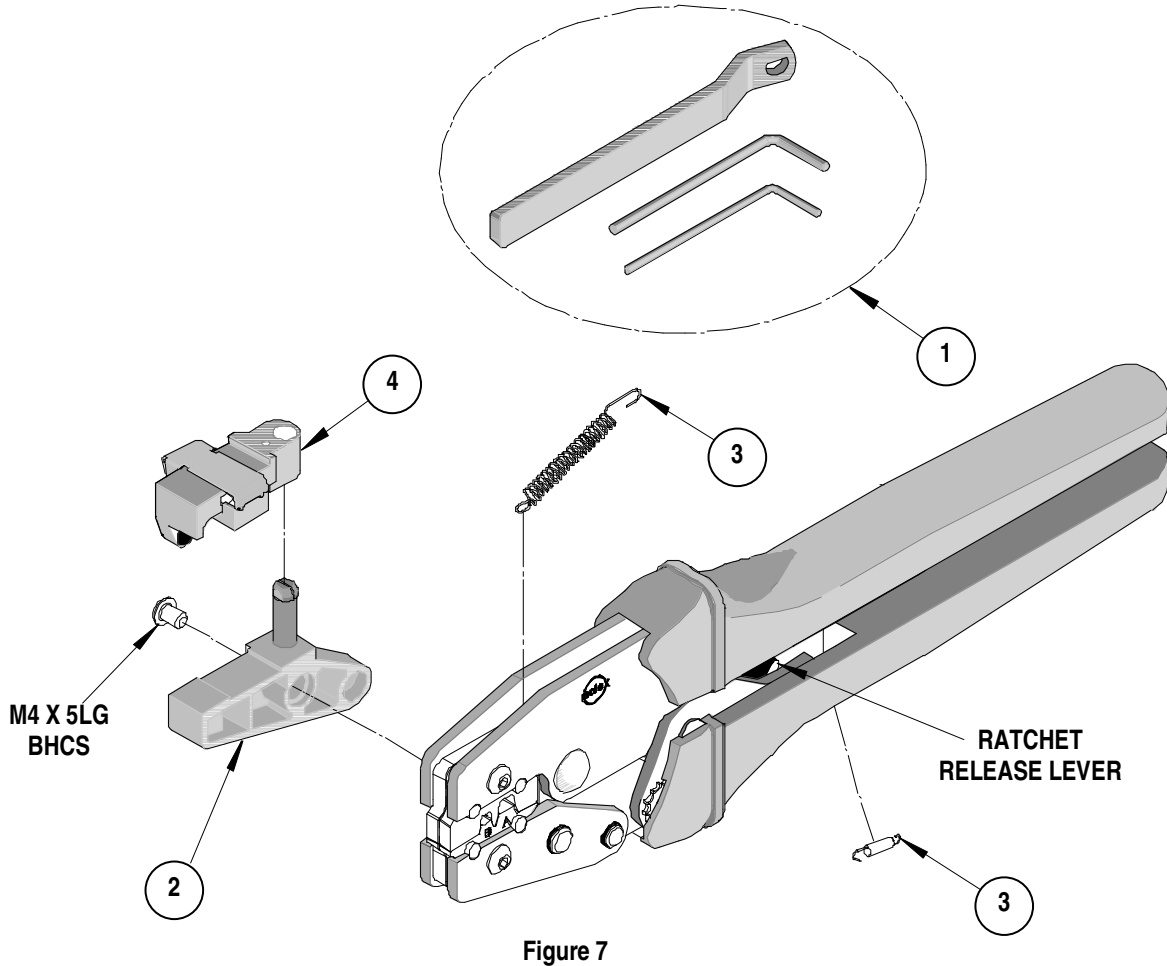


Figure 7

Americas Headquarters
 Lisle, Illinois 60532 U.S.A.
 1-800-78MOLEX
 amerinfo@molex.com

Far East North Headquarters
 Yamato, Kanagawa, Japan
 81-462-65-2324
 feninfo@molex.com

Far East South Headquarters
 Jurong, Singapore
 65-6-268-6868
 fesinfo@molex.com

European Headquarters
 Munich, Germany
 49-89-413092-0
 eurinfo@molex.com

Corporate Headquarters
 2222 Wellington Ct.
 Lisle, IL 60532 U.S.A.
 630-969-4550
 Fax: 630-969-1352

Visit our Web site at <http://www.molex.com>