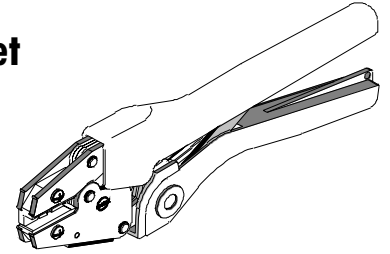




**Hand Crimp Tool**  
**Operating Instruction And Specifications Sheet**  
**Part No. 64001-2500**  
**Eng. No. RHT 2080**  
**(Replaces 19285-0011)**



## FEATURES

- A full cycle ratcheting hand tool ensures complete crimps
- Long handles for comfortable crimping with reduced crimping force
- A precision user-friendly terminal locator wire stop holds terminals in the proper crimping position

## SCOPE

Nylon closed end connectors 8 AWG

### Testing

#### Mechanical

The tensile test, or pull test, is a means of evaluating the mechanical properties of the crimped connections. The following charts show the UL specifications for various wire sizes. The tensile strength is shown in pounds and indicates the minimum acceptable force to break or separate the terminal from the conductor.

Wire Size (AWG)	UL – 486 C
8	45

\* UL – 486 C – Closed end connectors and Wire Nuts.

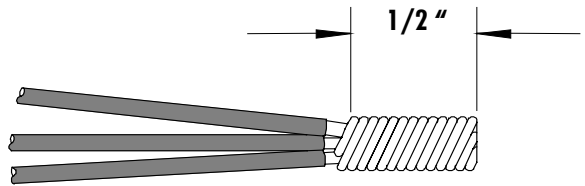
The following is a partial list of the product part numbers and their specifications that this tool is designed to run. We will be adding to this list and an up to date copy is available on [www.molex.com](http://www.molex.com).

Wire Size: 8 AWG 8.50 mm <sup>2</sup>				
Terminal No.	Terminal Eng No. (REF)	Wire Strip Length		Wire Combinations
		In	mm	
19160-0024	NC-8	Varies	Varies	See Chart 1

# OPERATION

## Wire Preparation

For stranded wire strip leads to approximately 7/8 of an inch. Twist the wire combination even and tight. Trim stripped pre-twisted area to 1/2 of an inch and insert into connector and crimp. For more information follow the Quality Crimping Handbook.



## CHART 1

Wire Combinations for Nylon- Insulated Closed End Connectors Part No. 191600024 (NC-8)							
Wire Type	Wire Gauge (AWG)						Rating
	8	10	12	14	16	18	
Stranded only	1			1			UL & CSA
Stranded only	1				1		UL & CSA
Stranded only	1				1		UL & CSA
Stranded only	1					2	UL & CSA
Stranded only		2					UL & CSA
Stranded only		1	1				UL & CSA
Stranded only		1	1				UL & CSA
Stranded only		1		2			UL & CSA
Stranded only		1			4		UL & CSA
Stranded only		1			2		UL & CSA
Stranded only		1			1		UL & CSA
Stranded only		1				6	UL & CSA
Stranded only		1				5	UL & CSA
Stranded only		1				4	UL & CSA
Stranded only		1				3	UL & CSA
Stranded only		1				2	UL & CSA
Stranded only		1				1	UL & CSA
Stranded only			3				UL & CSA
Stranded only			2				UL & CSA
Stranded only			2	2			UL & CSA
Stranded only			2		3		UL & CSA
Stranded only			2		2		UL & CSA
Stranded only			2		1		UL & CSA
Stranded only			2			4	UL & CSA
Stranded only			2			3	UL & CSA
Stranded only			2			2	UL & CSA
Stranded only			2			1	UL & CSA
**Stranded only			1	4			UL & CSA
Stranded only			1	3			UL & CSA
Stranded only			1	2			UL & CSA
Stranded only			1	1			UL & CSA
Stranded only			1		5		UL & CSA
Stranded only			1		4		UL & CSA
Stranded only			1		3		UL & CSA
Stranded only			1		2		UL & CSA
Stranded only			1			8	UL & CSA
Stranded only			1			7	UL & CSA
Stranded only			1			6	UL & CSA
Stranded only			1			5	UL & CSA
Stranded only			1			4	UL & CSA
Stranded only			1			3	UL & CSA
Stranded only			1			2	UL & CSA
Stranded only			1			1	UL & CSA
Stranded only				5			UL & CSA
Stranded only				4			UL & CSA
Stranded only				4			UL & CSA
Stranded only				4			UL & CSA
Stranded only				4			UL & CSA
Stranded only				4	2		UL & CSA
Stranded only				4	1		UL & CSA

Wire Combinations for Nylon- Insulated Closed End Connectors Part No. 191600024 (NC-8)							
Wire Type	Wire Gauge (AWG)						Rating
	8	10	12	14	16	18	
Stranded only				3			UL & CSA
Stranded only				3	3		UL & CSA
Stranded only				3	2		UL & CSA
Stranded Only				3	1		UL only
Stranded only				3		5	UL & CSA
Stranded only				3		4	UL & CSA
Stranded only				3		3	UL & CSA
Stranded only				3		2	UL & CSA
Stranded only				3		1	UL & CSA
Stranded only				2	4		UL & CSA
Stranded only				2	3		UL & CSA
Stranded only				2	2		UL & CSA
Stranded only				2	1		UL & CSA
Stranded only				2		7	UL & CSA
Stranded only				2		6	UL & CSA
Stranded only				2		5	UL & CSA
Stranded only				2		4	UL & CSA
Stranded only				2		3	UL & CSA
Stranded only				2		2	UL & CSA
Stranded only				1	6		UL & CSA
Stranded only				1	5		UL & CSA
Stranded only				1	4		UL & CSA
Stranded only				1	3		UL & CSA
Stranded only				1		10	UL & CSA
Stranded only				1		9	UL & CSA
Stranded only				1		8	UL & CSA
Stranded only				1		7	UL & CSA
Stranded only				1		6	UL & CSA
Stranded only				1		5	UL & CSA
Stranded only				1		4	UL & CSA
Stranded only					7		UL & CSA
Stranded only					7	1	UL & CSA
Stranded only					6		UL & CSA
Stranded only					6	3	UL & CSA
Stranded only					6	2	UL & CSA
Stranded only					6	1	UL & CSA
Stranded only					5		UL & CSA
Stranded only					5	4	UL & CSA
Stranded only					5	3	UL & CSA
Stranded only					5	2	UL & CSA
Stranded only					5	1	UL & CSA
Stranded only					4		UL & CSA
Stranded only					4	6	UL & CSA
Stranded only					4	5	UL & CSA
Stranded only					4	4	UL & CSA
Stranded only					4	3	UL & CSA
Stranded only					4	2	UL & CSA

Wire Combinations for Nylon- Insulated Closed End Connectors Part No. 191600024 (NC-8)							
Wire Type	Wire Gauge (AWG)						Rating
	8	10	12	14	16	18	
Stranded only					4	1	UL & CSA
Stranded only					3	8	UL & CSA
Stranded only					3	7	UL & CSA
Stranded only					3	6	UL & CSA
Stranded only					3	5	UL & CSA
Stranded only					3	4	UL & CSA
Stranded only					3	3	UL & CSA
Stranded only					3	2	UL & CSA
Stranded only					2	9	UL & CSA
Stranded only					2	8	UL & CSA
Stranded only					2	7	UL & CSA
Stranded only					2	6	UL & CSA
Stranded only					2	5	UL & CSA
Stranded only					2	4	UL & CSA
Stranded only					1	11	UL & CSA
Stranded only					1	10	UL & CSA

Wire Combinations for Nylon- Insulated Closed End Connectors Part No. 191600024 (NC-8)								
Wire Type	Wire Gauge (AWG)						Rating	
	8	10	12	14	16	18		
Stranded only					1	9	UL & CSA	
Stranded only					1	8	UL & CSA	
Stranded only					1	7	UL & CSA	
Stranded only					1	6	UL & CSA	
Stranded only					1	5	UL & CSA	
Stranded only							12	UL & CSA
Stranded only							11	UL & CSA
Stranded only							10	UL & CSA
Stranded only							9	UL & CSA
Stranded only							8	UL & CSA
Stranded only							7	UL & CSA

\*\* - Rated 300 Volts all others 600 Volts

### Crimping Terminals

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

1. Hold hand tool with the locator facing up. Insert the closed end connector in the correct slot (8). Make sure that the shoulder of the connector is resting on the locator plate (See Figure 1).
2. Close the hand tool jaws until the connector is held snug in place. Load the connector with the desired wire combination (See Figure 2 and 3). Complete the crimp by closing the hand tool handles until they release.

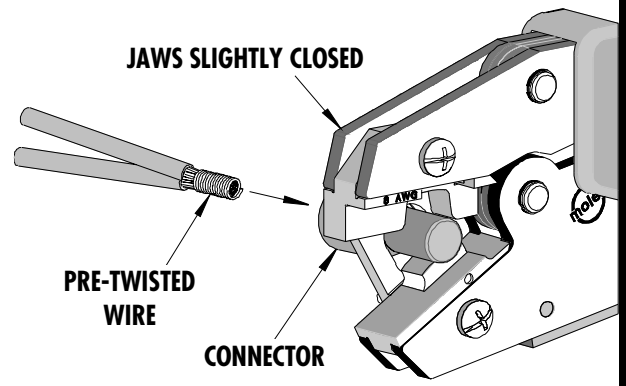


Figure 2

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

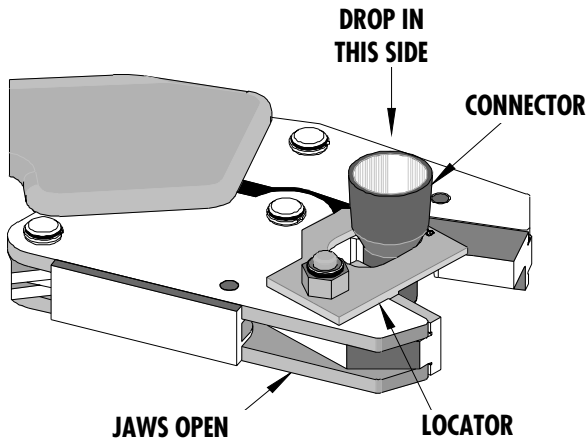


Figure 1

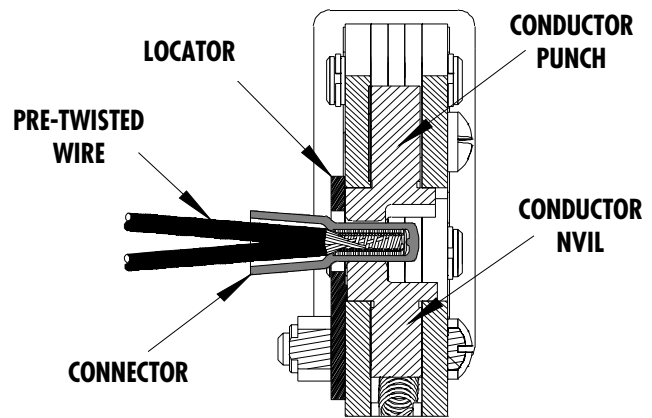


Figure 3

3. Remove the crimp and inspect for proper crimp location, and check for insulation closure. Molex offers a Crimp Inspection Handbook for closed barrel industrial product. See our website or contact your sales engineer.

**Note:** Whenever crimping without the locator, make sure the seam of the terminal is oriented up or down in the tool if using unbrazed product, as this will provide higher pull force values.

## 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 64001-2500 (RHT-2080) 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 weight automotive oil used at the oil points shown in Figure 4, every 5,000 crimps or 3 months will significantly enhance the tool life and ensure a stable calibration.
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.

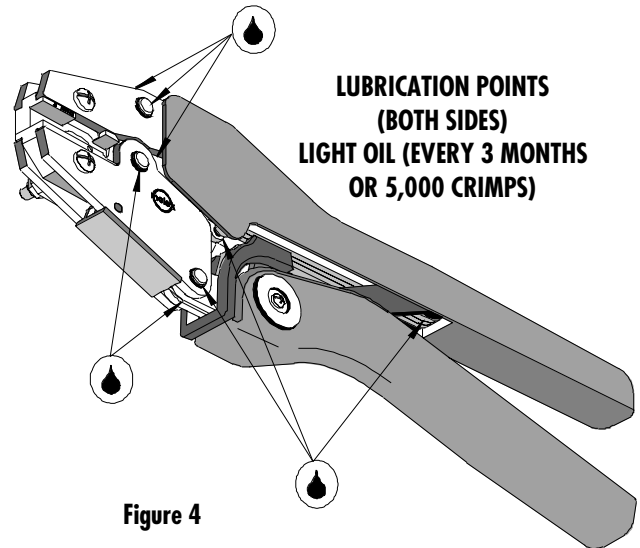


Figure 4

## 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 5.

## How To Adjust Tool Preload (See Figure 5)

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 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 (CCW) 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 the crimp specifications after tool handle preload force is adjusted.

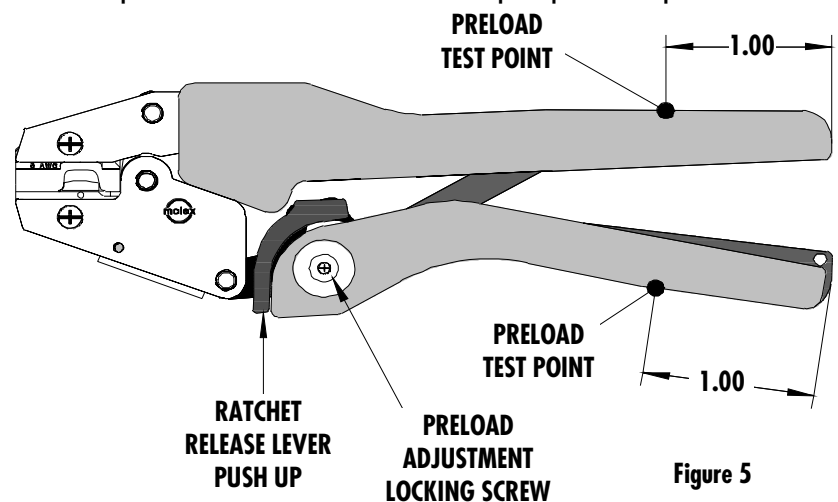
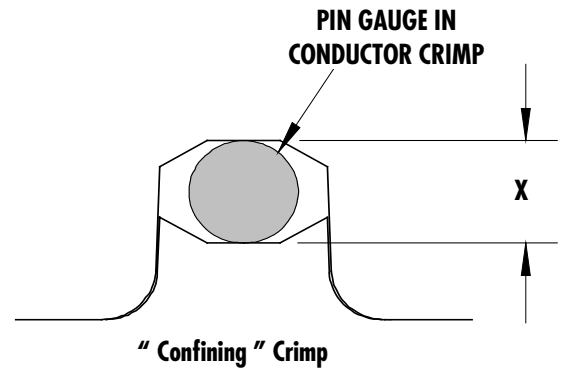


Figure 5

### Tool Calibration

A Certificate of Calibration (see last page) was supplied with the tool. To recalibrate this tool, pin gauge measurements should be taken in each conductor nest and compared to this chart. The tool should be lubricated prior to recalibration to ensure consistent measurements. Handle preload is factory set to 25-45 LBS. See How to Adjust Tool Preload (See Figure 5) to recalibrate.



Wire Range		"X" Dimension Conductor Crimp		
Awg	mm <sup>2</sup>	Mean	Go	No Go
8	8.50	.140	.136	.146

### 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.

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

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

**PARTS LIST**

Item	Order No	Description	Quantity
	<b>64001-2500</b>	<b>Hand Crimp Tool</b>	<b>(Fig. 6)</b>
1	64000-0076	Repair Kit (Springs, Pins and E-Rings)	1
2	63810-0000	Handle	1
3	64001-2575	Locator Assembly	1
4	64001-2570	Tooling Kit	1
<b>Tooling Kit Only</b>			
5	64001-2501	Conductor Punch	1
6	64001-2502	Conductor Anvil	1

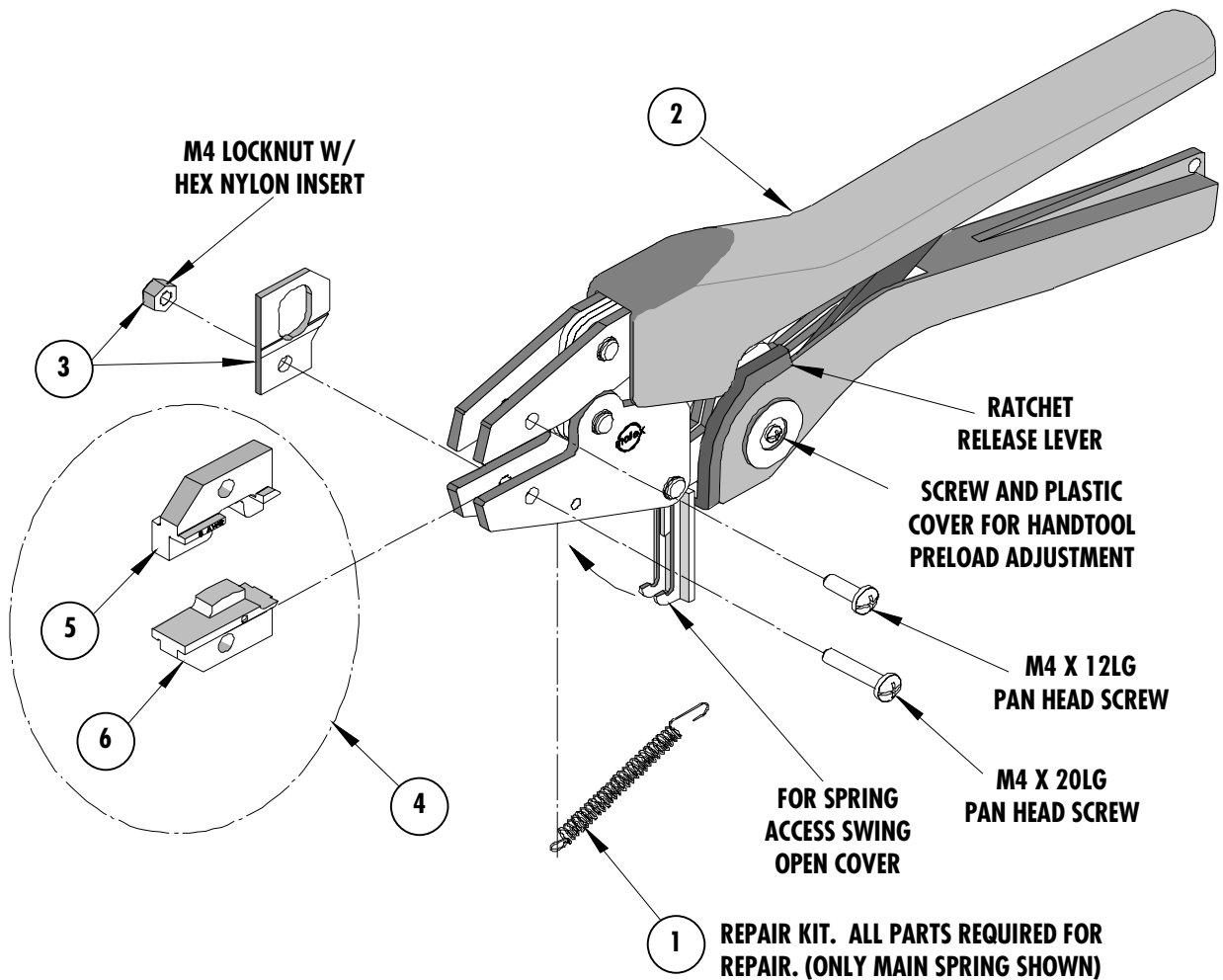
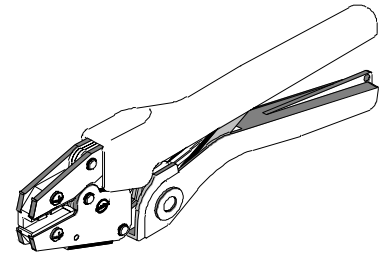


Figure 6



### Certificate of Calibration

Tool Order Number \_\_\_\_\_

Tool Eng. Number \_\_\_\_\_

Tool Revision \_\_\_\_\_

Serial Number \_\_\_\_\_

Date of Manufacture \_\_\_\_\_

Handle Load Range at 1 inch from the Tips = \_\_\_\_\_

Actual = \_\_\_\_\_

Pin Gauge of Conductor Nest/Nests or Slug height if the nest is the "F" Crimp style.

Range Conductor Nest # 1 = \_\_\_\_\_ Actual = \_\_\_\_\_

Range Conductor Nest # 2 = \_\_\_\_\_ Actual = \_\_\_\_\_

Range Conductor Nest # 3 = \_\_\_\_\_ Actual = \_\_\_\_\_

Technician \_\_\_\_\_

Date of Calibration \_\_\_\_\_

Calibration should be done every 5,000 cycles or 3 months.  
Tools should be lubricated during this operation.

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