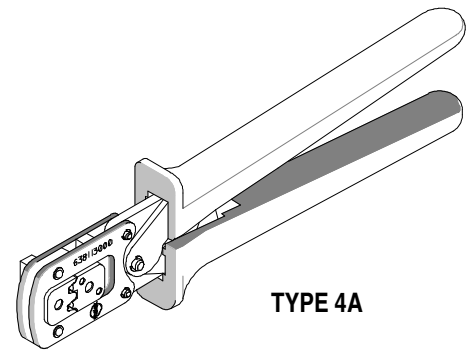




Hand Crimp Tool Specification Sheet Order No. 63811-4900



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

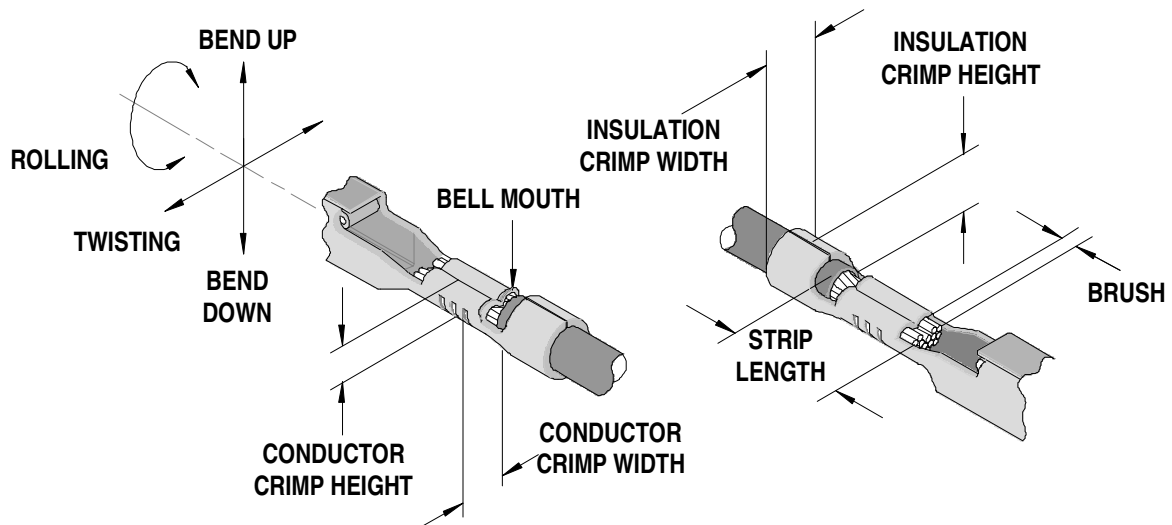
SCOPE

Products: 2.54mm (.100") Pitch MX64™ GET Female Terminals, 18-20 AWG.

Terminal Series No.	Terminal Order No. ● Reel	Wire Size	Actual mm ²	Wire Specification		Insulation Diameter		Strip Length	
				Low Temp	High Temp	mm	In.	mm	In.
34230	34230-0003 34230-0004	20 AWG	0.562	WSB-M1L134-A1	WSS-M1L135-A1	1.70-1.85	.067-.073.	4.00-4.80	.157-.189
				ESB-M1L120-A	ESB-M1L123-A/A2				
		18AWG	0.806	WSB-M1L134-A1	WSS-M1L135-A1	1.91-2.06	.075-.081.	4.00-4.80	.157-.189
				ESB-M1L120-A	ESB-M1L123-A/A2				

● Customer to cut off terminal from reel: 0.50mm (.020") maximum Cut-off Tab.

DEFINITION OF TERMS



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

CRIMP SPECIFICATION

Terminal Series No.	Bell mouth (Front Only)		Conductor Brush	
	mm	In.	mm	In.
34230	0.20-0.50	.008-.020	0.10-1.00	.004-.039

Terminal Part No.	Wire Size	Actual mm ²	Bend up	Bend down	Twist	Roll
			Degree		Degree	
34230	18 AWG	0.806	2.5	2.5	1.5	N/A
	20 AWG	0.562	3	3	2.5	N/A

After crimping, the conductor profile should measure the following.

Terminal Series No.	Wire Size	Actual mm ²	Wire Specification		Crimp Conductor				Pull Force Minimum	
					Height		Width			
			Low Temp	High Temp	mm	In.	mm	In.	N	Lb.
34230	18 AWG	0.806	WSB-M1L134-A1	WSS-M1L135-A1	1.16-1.24	.046-.049	1.83-1.91	.072-.075	115.0	25.88
	18 AWG	0.806	ESB-M1L120-A	ESB-M1L123-A/A2	1.16-1.24	.046-.049	1.83-1.91	.072-.075	115.0	25.88
	20 AWG	0.562	WSB-M1L134-A1	WSS-M1L135-A1	1.04-1.12	.041-.044	1.82-1.90	.072-.075	75.0	16.88
	20 AWG	0.562	ESB-M1L120-A	ESB-M1L123-A/A2	1.04-1.12	.041-.044	1.82-1.90	.072-.075	75.0	16.88

Terminal Series No.	Wire Size	Actual mm ²	Wire Specification		Crimp Insulation			
					Height		Width	
			Low Temp.	High Temp	mm	In.	mm	In.
34230	18 AWG	0.806	WSB-M1L134-A1	WSS-M1L135-A1	1.90-2.10	.075-.083	1.85-2.05	.073-.081
	18 AWG	0.806	ESB-M1L120-A	ESB-M1L123-A/A2	1.90-2.10	.075-.083	1.85-2.05	.073-.081
	20 AWG	0.562	WSB-M1L134-A1	WSS-M1L135-A1	1.80-2.00	.071-.079	1.85-2.05	.073-.081
	20 AWG	0.562	ESB-M1L120-A	ESB-M1L123-A/A2	1.90-2.10	.075-.083	1.85-2.05	.073-.081

Pull Force should be measured with no influence from the insulation crimp.

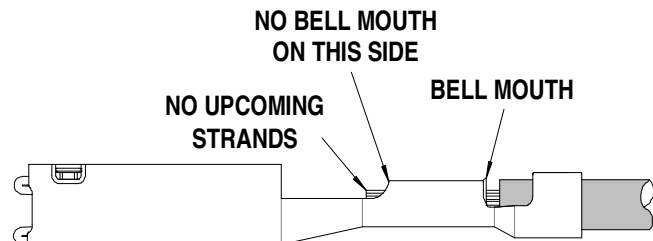
The above specifications are guidelines to an optimum crimp.

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.

Crimping Terminals

1. Lift the wire stop blade up.
2. Insert the terminal fully into the correct die profile and the locator slot until the terminal is fully seated and stops.
3. Bring down the wire stop blade. Make sure the wire stop blade is fully seated on the terminal behind the conductor grip section.



4. Slide the pre-stripped wire into the terminal; make sure to aim the wire brush towards the tip point on the wire stop blade (See Figure 1). 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 2.
5. Close the tool until the ratchet releases.
6. Lift the wire stop blade up.
7. Carefully remove the crimped terminal.

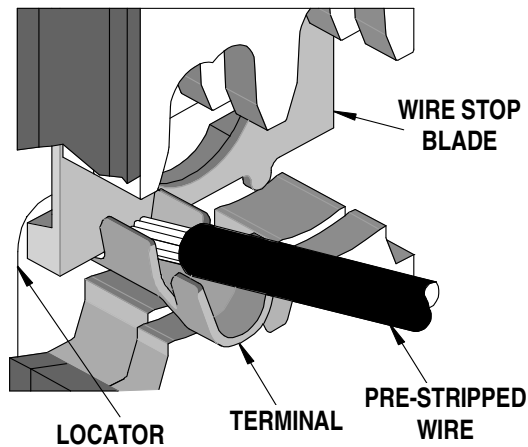


Figure 1

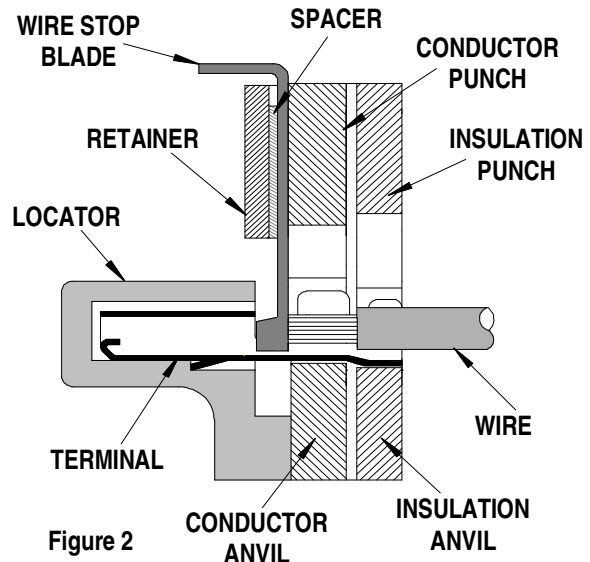


Figure 2

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

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 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 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.

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 3.

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: Repetitive use of this tool should be avoided.

CAUTIONS:

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.

Insulated rubber handles are not protection against electrical shock.

Wear eye protection at all times.

Use only the Molex terminals specified for crimping with this tool.

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, however crimp force is adjustable (See instructions above). 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 is damaged or worn, a new tool must be purchased.
5. Pull force should be used as the final criteria for an acceptable crimp. Pull force is measured with no influence from the insulation crimp. The insulation should be stripped long (1/2 in.) 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 crimp hand tools.

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

PARTS LIST

Item	Order Number	Description	Quantity
1	63600-0520	Crimping Spring	2
2	63811-4975	Locator	1
3	63600-0525	Handle Spring	1

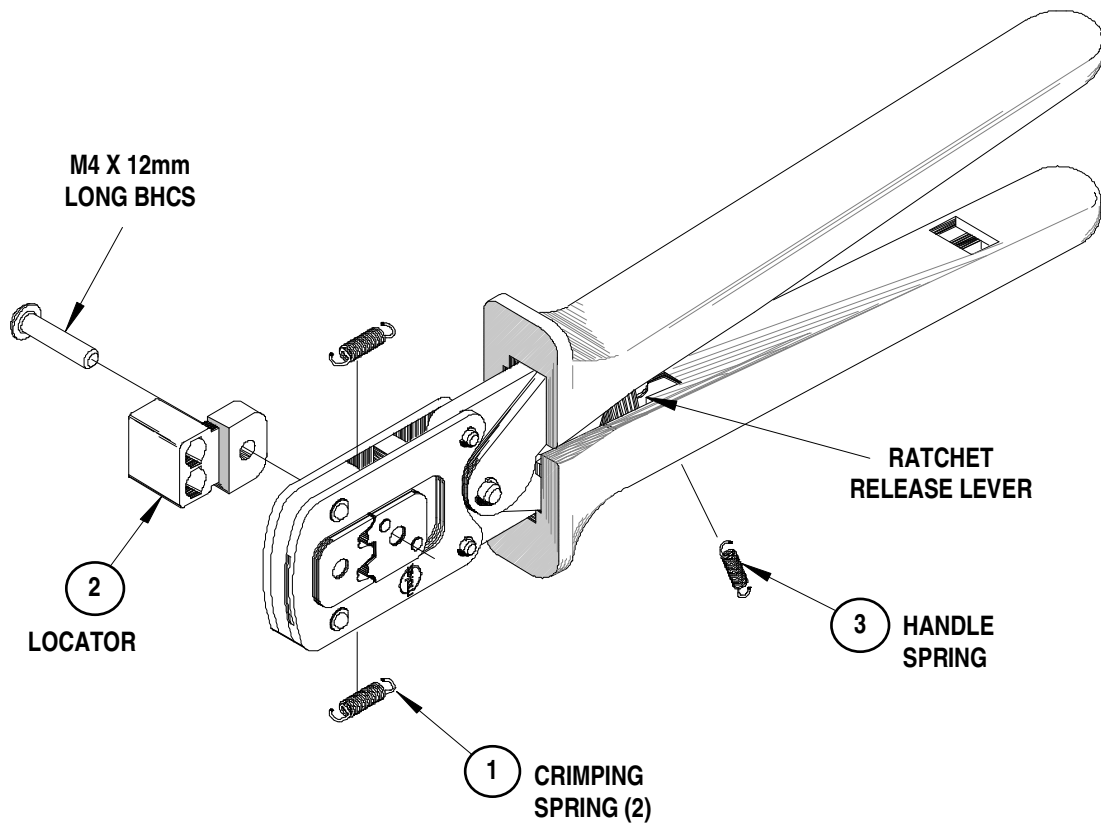


Figure 3

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