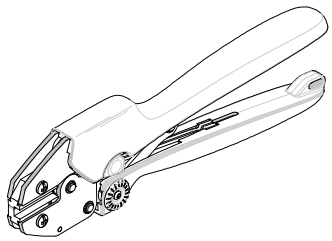
Hand Crimp Tool Krimptite™ Quick Disconnects	molex **Application Tooling Specification Sheet**	 **Order No. 64003-1600**

FEATURES

- A full cycle ratcheting hand tool ensures complete crimps
- Long handles for comfortable crimping with reduced crimping force

SCOPE

Products: Krimptite ™ Un-insulated Female Flag Quick Disconnect Terminals, 10-12 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 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 310
12	70
10	80

*UL – 310 – Flag Quick Disconnects.

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.

Wire Size: 10 – 12 AWG 5.00 – 3.30mm²					
Terminal No.	Terminal Eng. No. (REF)	Wire Strip Length		Insulation Diameter Maximum	
		In.	mm	In.	mm
19008-0063	C-1012	.313	7.94	N/A	N/A

OPERATION

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

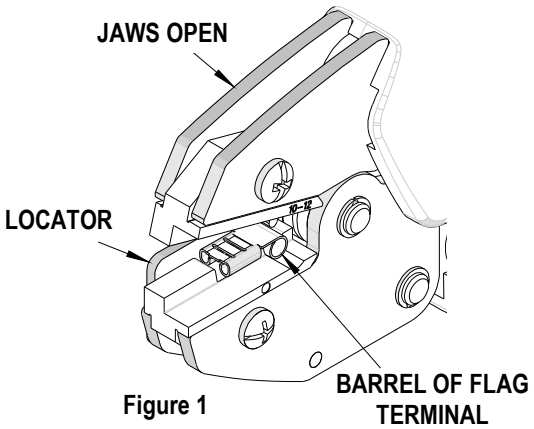


Figure 1

Crimping Terminals

1. Insert the flag terminal into the nest with the barrel down and centered in the nest. The flag terminal should be against the locator.
2. Partially close the tool to hold the terminal in place.

3. Insert the properly stripped wire into the terminal barrel. See Figure 2.

4. Now close the handle completely and release. The jaws will open when the tool has fully closed.

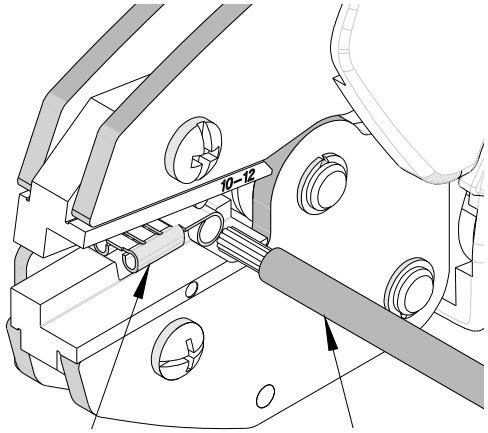


Figure 2

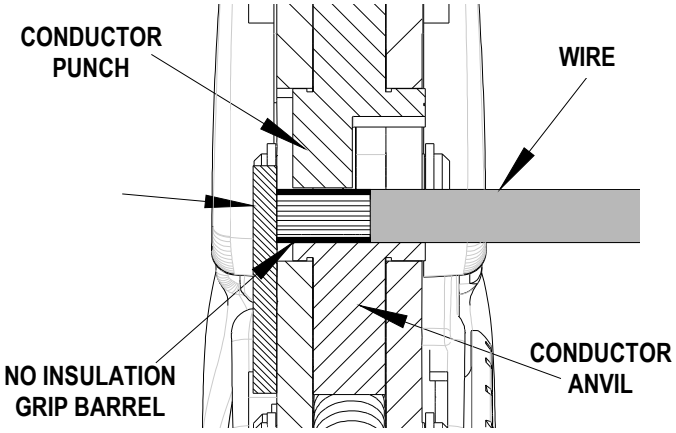


Figure 3

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

Maintenance

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

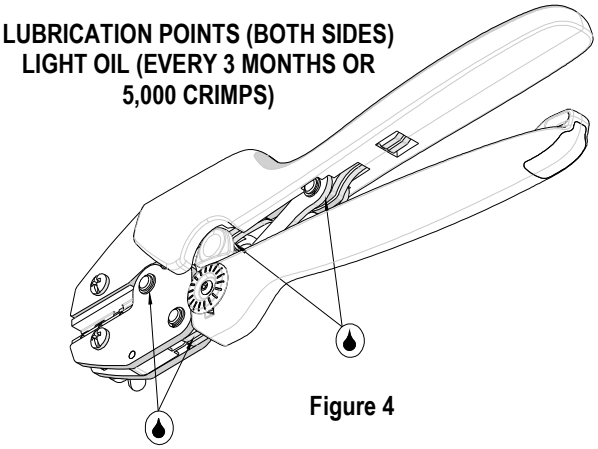


Figure 4

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. This hand 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. 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.

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 5).

How to Adjust Tool Preload (See Figure 5)

Over the life of the tool, it may be necessary 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.

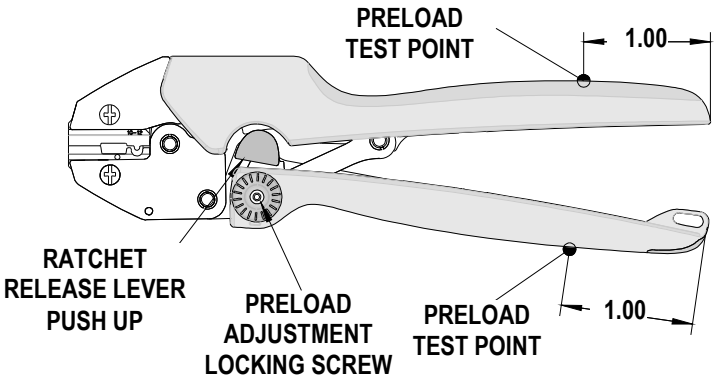
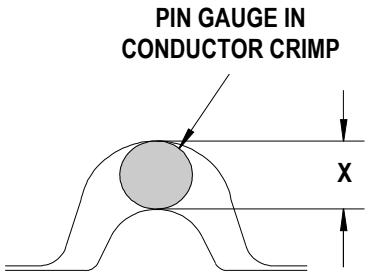


Figure 5

Tool Calibration

A Certificate of Calibration (see last page) was supplied with the tool. To recalibrate this Tool, measurements should be taken from each conductor nest and compared to this chart. The tool should be lubricated before 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.



"Indenter Crimp"

Nest Color Code	Wire Range		"X" Dimension Conductor Crimp		
	AWG	mm²	Mean	Go	No Go
Yellow	10 - 12	5.00 – 3.30	.086	.083	.088

Warranty

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

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 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
	64003-1600	**Hand Crimp Tool**	**Figure 6**
1	**64000-0076**	**Repair Kit (Springs, Pins and E-Rings)**	**1**
2	**63810-0000**	**Handle**	**1**
3	**64003-1670**	**Tooling Kit**	**1**
4	**64003-1675**	**Locator Assembly**	**1**
Tooling Kit Only			
5	**64003-1601**	**Conductor Punch (indenter)**	**1**
6	**64003-1602**	**Conductor Anvil**	**1**

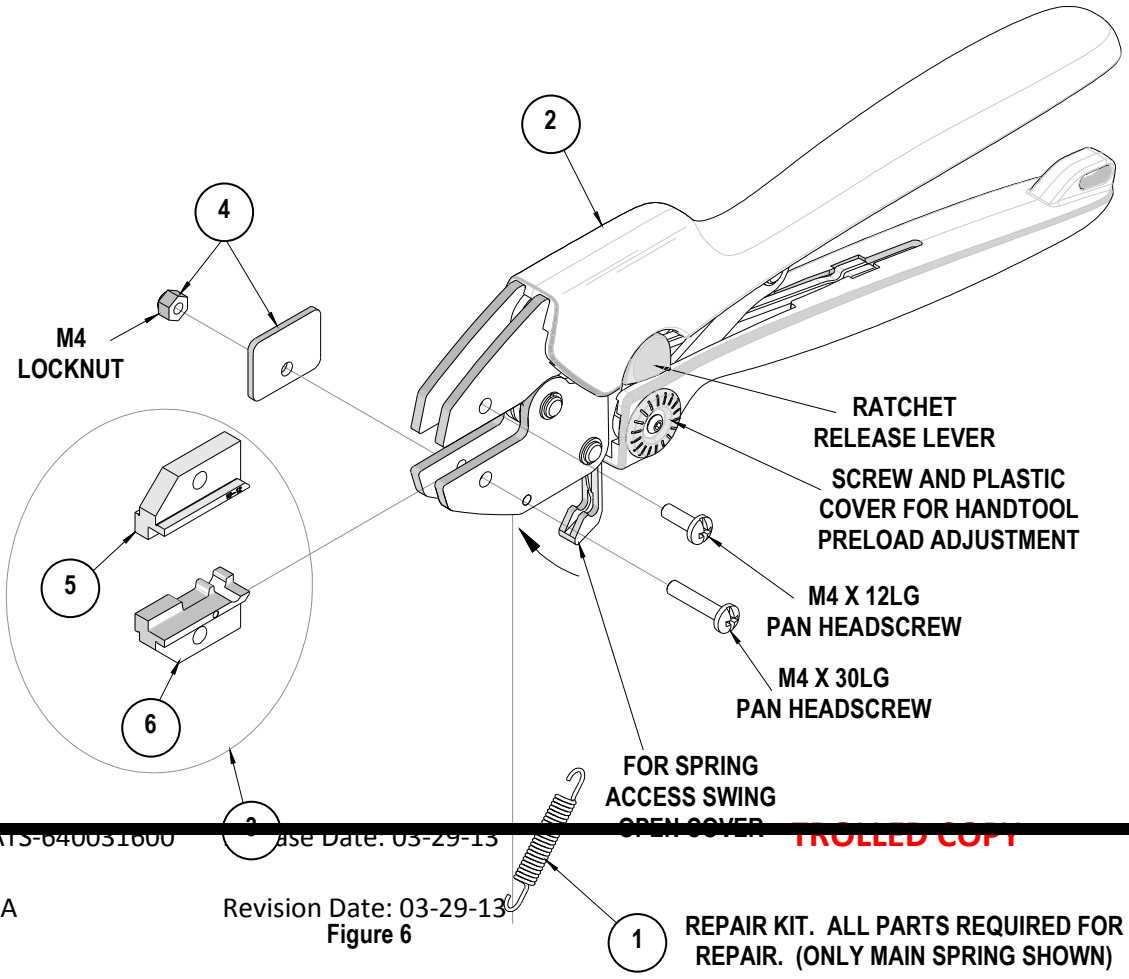
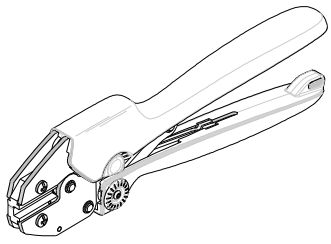


Figure 6

Hand Crimp Tool **Krimptite™** **Quick Disconnects**	molex	
	Application Tooling	

	Specification Sheet	Order No. 64003-1600

Certificate of Calibration

Tool Order Number _____

Tool Revision _____

Serial Number _____

Date of Manufacture_____

Handle Load Range:

At 1 inch from the Tips =_____Actual =_____

Pin Gauge of Conductor Nest:

Conductor Nest Range = _____-- Actual = _____

Technician _____

Date of Calibration _____

Calibration should be done every 5,000 cycles or 3 months.

Tools should be lubricated during this operation.

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