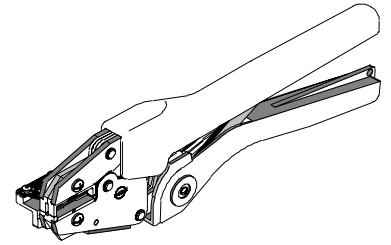




**Hand Crimp Tool Operating Instruction  
And Specifications Sheet  
Order No. 64001-6300  
Engineering No. 19813-1000**



## 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 for each of the three nests
- 3-nested tool eliminates the need for additional tools

## SCOPE

Products: InsulKrimp™ Piggyback Quick Disconnect Terminals, 10 - 22 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 - 310
22	8
20	13
18	20
16	30
14	50
12	70
10	80

\*UL - 310 - 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](http://www.molex.com).

Wire Size: 14 - 16 AWG 2.00 - 1.30mm <sup>2</sup>						
Terminal No.	Terminal Eng No. (REF)	Terminal No. Mylar Tape	Wire Strip Length		Insulation Diameter Maximum	
			In.	mm	In.	mm
19013-0005	BB-2318	19013-0006	.313	7.94	.165	4.19
19013-0007	BB-2318X	19013-0008	.313	7.94	.165	4.19
19013-0029	19013-0029	19013-0030	.313	7.94	.165	4.19
19013-0031	19013-0031	19013-0032	.313	7.94	.165	4.19

Wire Size: 18 – 22 AWG 0.80 – 0.35mm <sup>2</sup>						
Terminal No.	Terminal Eng No. (REF)	Terminal No. Mylar Tape	Wire Strip Length		Insulation Diameter Maximum	
			In.	mm	In.	mm
19013-0001	AA-2317	19013-0002	.313	7.94	.140	3.56
19013-0003	AA-2317X	19013-0004	.313	7.94	.140	3.56
19013-0025	19013-0025	19013-0026	.313	7.94	.140	3.56
19013-0027	19013-0027	19013-0028	.313	7.94	.140	3.56

## OPERATION

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

### Crimping Terminals

1. Push the terminal onto the tab locator all the way to the stop in the proper color-coded nest. The male tab of the terminal should be up. See Figure 1.
2. The height of the locator may need to be adjusted when changing from one terminal size to another. To do this, loosen the locator lock nut, (See Figure 3), and adjust height so the tab aligns with the female locator tab. Tighten the lock nut.
3. Partially close the tool to hold the terminal in place. See Figure 2.
4. Insert the properly stripped wire into the terminal barrel. See Figure 2 and 3. The wires end should butt against the wire stop stamped into each terminal. Cycle the tool.

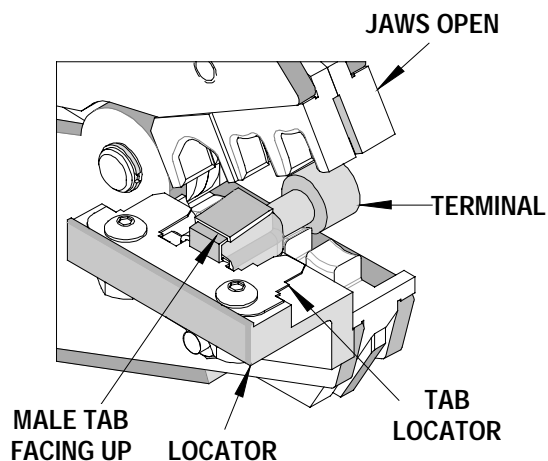


Figure 1

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

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

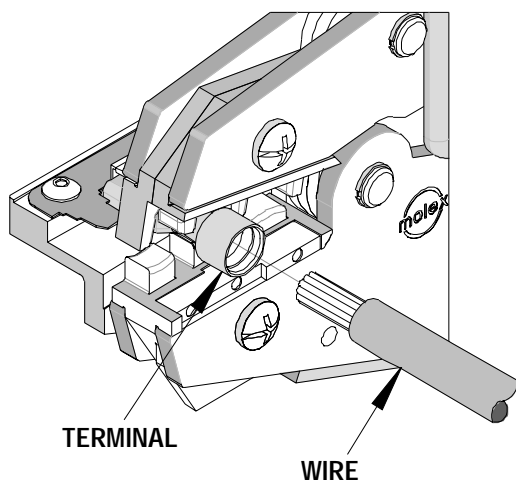


Figure 2

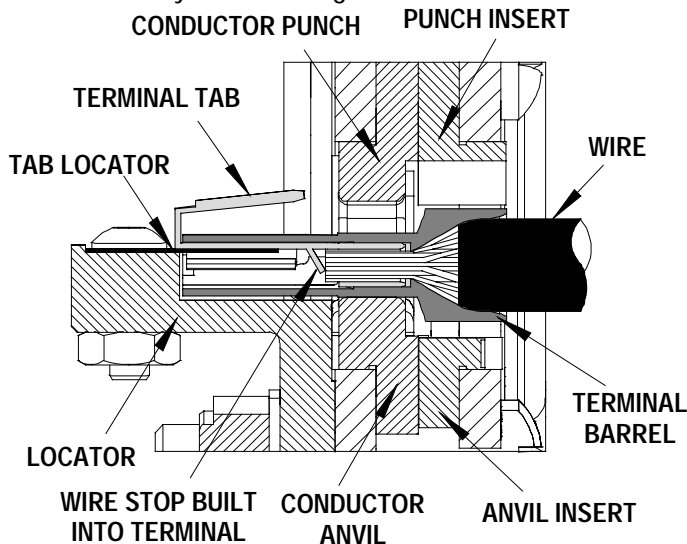


Figure 3

**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. 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.

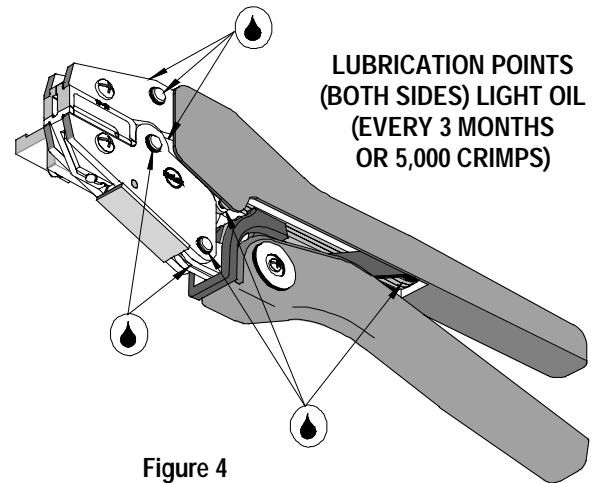


Figure 4

## 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)

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 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 crimp force is adjusted.

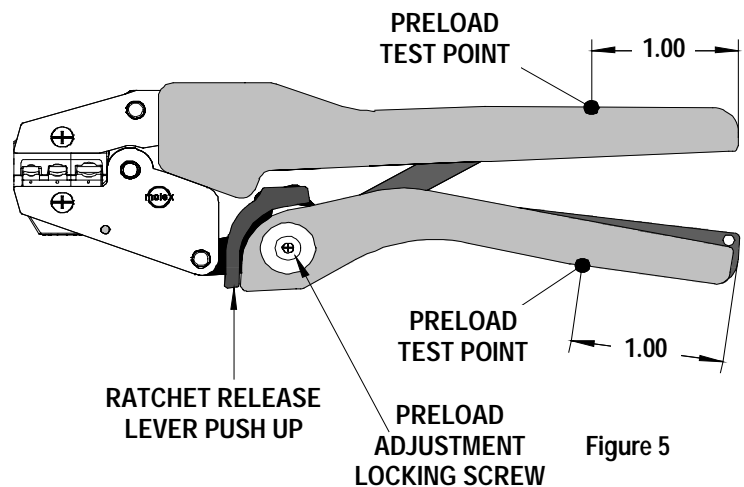
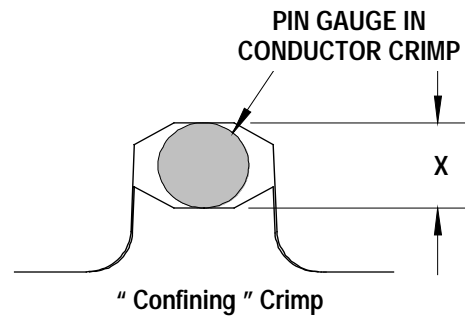


Figure 5

### 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.



Nest Color Code	Wire Range		"X" Dimension Conductor Crimp			Crimp Inspection Marking
	AWG	mm <sup>2</sup>	Mean	Go	No Go	
Red	18 - 22	0.35 - 0.80	.072	.068	.076	N/A
Blue	14 - 16	1.30 - 2.00	.090	.086	.094	N/A
Yellow	10 - 12	3.30 - 5.00	.134	.130	.138	N/A

### 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.**

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

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

**PARTS LIST**

Item	Order No	Description	Quantity
	<b>64001-6300</b>	<b>Hand Crimp Tool</b>	<b>Figure 6</b>
1	64000-0076	Repair Kit (Springs, Pins and E-Rings)	1
2	63810-0000	Handle	1
3	64001-6275	Locator Assembly	1
4	64001-6370	Tooling Kit	1
<b>Tooling Kit Only</b>			
5	64001-6301	Conductor Punch	1
6	64001-6302	Conductor Anvil	1
7	64001-0312	Insert, Punch	1
8	64001-0311	Insert, Anvil	1
9	N/A	4mm Diameter by 5.0mm LongRoll Pins	2**

\*\* The following purchased parts are available from an Industrial supply company such as MSC (1-800-645-7270).

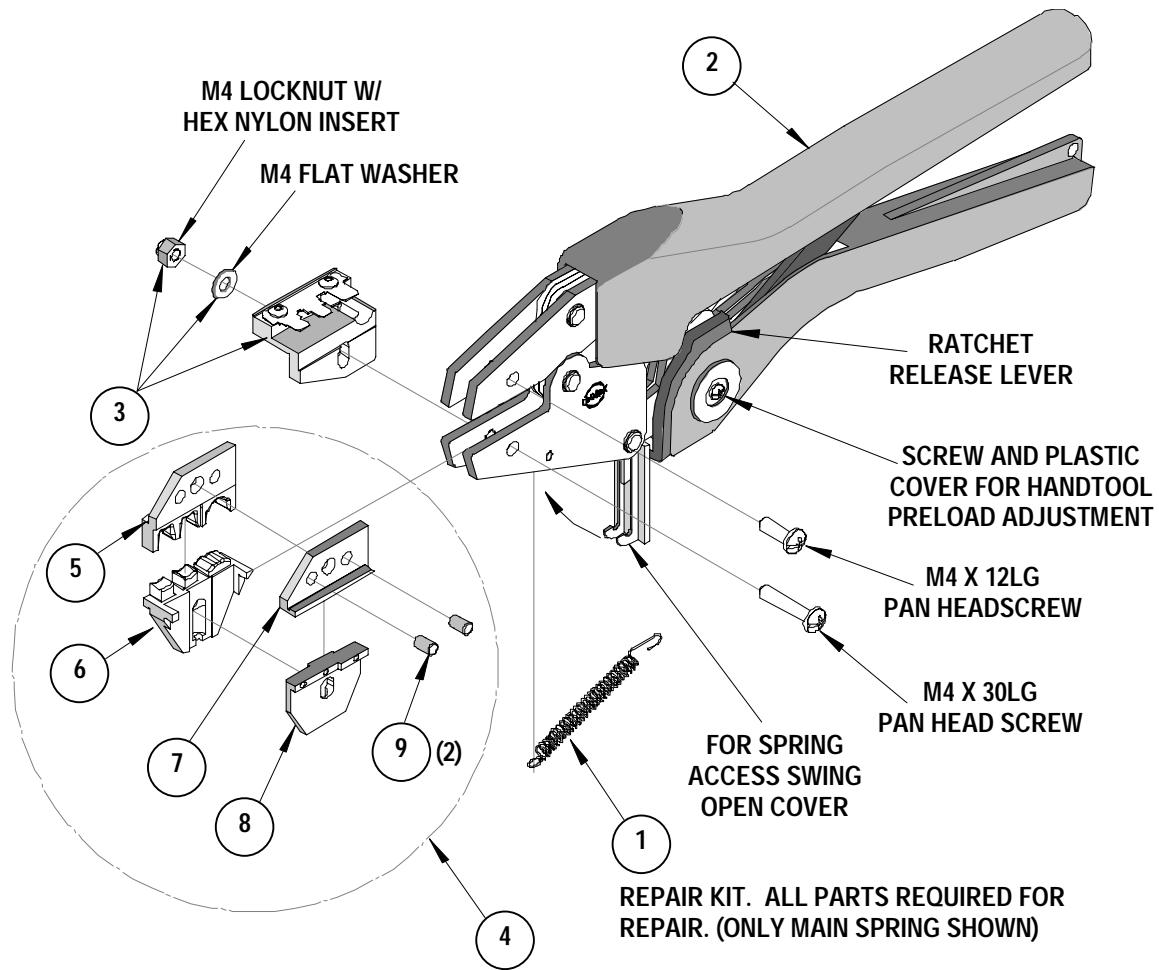
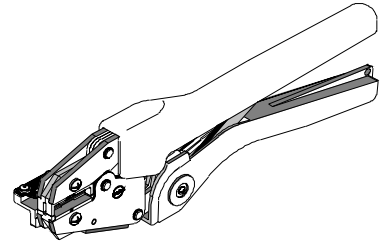


Figure 6



### 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.

**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>