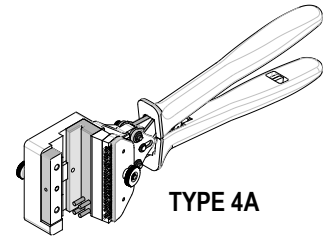


Modular Crimp Head
Order No. 63827-6370

molex®

Application Tooling Specification Sheet



Hand Crimp Tool
Order No. 63827-6300

FEATURES

- % A full cycle ratcheting hand tool ensures complete terminations
- % Ergonomically designed soft handles
- % Wire gripping comb holds wires in place before termination
- % Easy handling due to outstanding force ratio
- % Modular Crimp Head is removable and can be used in the Air Powered Tool Order No.63816-0100, accompanied by Air Powered Crimp Adapter (Order No. 63816-0700)
- % Modular Crimp Head can also be used in the Battery Powered Tool Order No.63816-0200 (110 V) or 63816-0250 (220 V), accompanied by Battery Powered Crimp Adapter (Order No. 63816-0600)

SCOPE

Products: Appli-Mate RAST5 connectors, 1 – 12 circuits, 0.38mm² – 1.5mm² wires.

Connector Series	Connector Order No.	Wire Size	Insulation Diameter	
		mm ²	mm	In.
91954	See table below	0.38	1.3 – 1.5	0.051 – 0.059
90833, 91338, 91777, 91778, 91886, 93052, 93057, 93213	See table below	0.5 – 0.75	2.0 – 2.5	0.078 – 0.098
90835, 91247, 91779, 92000, 93210, 93396	See table below	1.0 – 1.5	2.65 – 3.10	0.104 – 0.122
*Customer to cut off connector from molded chain				
Contact Molex about approved AWG wires for these products				

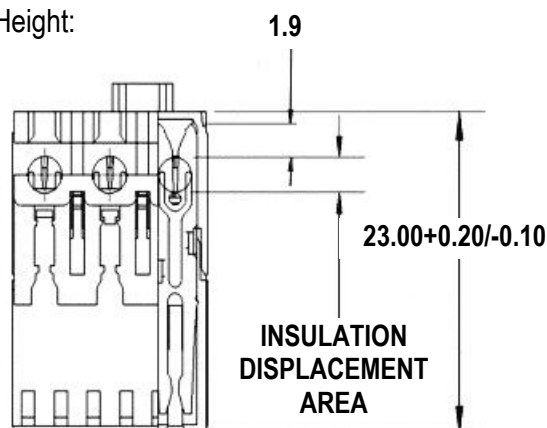
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	90833-0021	90833-0022	90833-0025	90833-0026	90833-0027	90833-0028	90833-0032	90833-0047	90833-0048	90833-0050
	90833-0051	90833-0052	90833-0053	90833-0054	90833-0056	90833-0057	90833-0058	90833-0059	90833-0060	90833-0061
	90833-0062	90833-0063	90833-0064	90833-0065	90833-0066	90833-0068	90833-0069	90833-0500	90833-0501	90833-0502
	90833-0503	90833-0504	90833-0505	90833-0506	90833-0507	90833-0508	90833-0509	90833-0510	90833-0511	90833-0513
	90833-0524	90833-0525	90833-0526	90833-0528	90833-0529	90833-0530	90833-0531	90833-0532	90833-0533	90833-0534
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	90833-1261	90833-1262	90833-1264	90833-1267	90833-1271	90833-1272	90833-1273	90833-1276	90833-1277	90833-1279
	90833-1282	90833-1283	90833-1284	90833-2001	90833-2002	90833-2006	90833-2007	90833-2008	90833-2010	90833-2011
	90833-2012	90833-2019	90833-2023	90833-2024	90833-2025	90833-2026	90833-2027	90833-2028	90833-2029	90833-2750
	90833-2751	90833-2752	90833-2764	90833-2765	90833-2773	90833-2776	90833-2777	90833-2778	90833-2779	90833-2780
	90833-2781	90833-3500	90833-3501	90833-3502	90833-3503	90833-3513	90833-3514	90833-3518	90833-3520	90833-3521
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	90833-9305	90833-9306	90833-9401	90833-9402	90833-9403	90833-9404	90833-9405	90833-9501	90833-9502	90833-9503
	90833-9504	90833-9601	90833-9602	90833-9603	90833-9701	90833-9702	90833-9703	90833-9704	90833-9705	90833-9801
	90833-9901									
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Connector Series	Assembly Order Number									
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	91886-9001	91886-9023	91886-9024	91886-9031	91886-9032	91886-9033	91886-9036	91886-9037	91886-9041	91886-9042
	91886-9043	91886-9051	91886-9052	91886-9053	91886-9054	91886-9055	91886-9061	91886-9062	91886-9063	91886-9064
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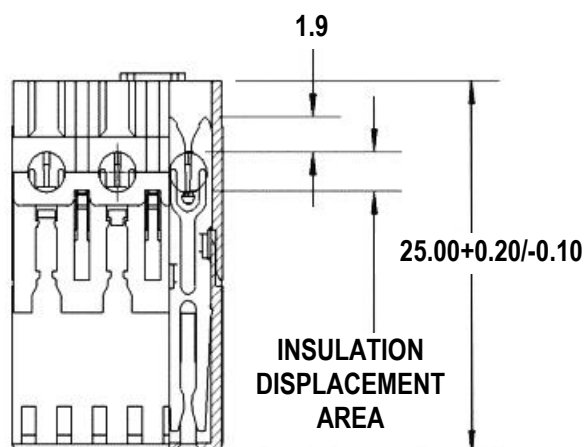
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	91954-0050	91954-0051	91954-0052	91954-0053	91954-0054	91954-0055	91954-0056	91954-0057	91954-0058	91954-0059	
	91954-0060	91954-0061	91954-0062	91954-0063	91954-0064	91954-0065	91954-0066	91954-0067	91954-0068	91954-0069	
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	91954-0110	91954-0111	91954-0112	91954-0113	91954-0114	91954-0115	91954-0116	91954-0117	91954-0118	91954-0119	
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	93052-5012	93052-6000	93052-6001	93052-6005	93052-6006	93052-6007	93052-6008	93052-6023	93052-6024	93052-6025	
	93052-7000	93052-7001	93052-8000	93052-8001							
93057	93057-0001	93057-0002	93057-0003	93057-0004	93057-0005	93057-0006	93057-0007	93057-0008	93057-0009	93057-0010	
	93057-0011	93057-0012	93057-0013	93057-0014	93057-0015	93057-0016	93057-0017	93057-0018	93057-0019	93057-0020	
	93057-0021	93057-0022	93057-0023	93057-0024	93057-0025	93057-0026	93057-0101	93057-0102	93057-0103	93057-0104	
	93057-0105	93057-0106	93057-0107	93057-0108	93057-0109	93057-0110	93057-0111	93057-0112	93057-0113	93057-0114	
	93057-0115	93057-0116	93057-0117	93057-0118	93057-0119	93057-0120	93057-0121	93057-0122	93057-0123	93057-0124	
	93057-0125	93057-0126	93057-0127	93057-0128	93057-0129	93057-0201	93057-0202	93057-0203	93057-0204	93057-0205	
	93057-0206	93057-0207	93057-0208	93057-0209	93057-0210	93057-0211	93057-0212	93057-0301	93057-0302	93057-0303	
	93057-0304	93057-0305	93057-0306	93057-0307	93057-0308	93057-0309	93057-0310	93057-0311	93057-0312	93057-0313	
	93057-0314	93057-0315	93057-0316	93057-0401	93057-0402	93057-0403	93057-0404	93057-0405	93057-0406	93057-0407	
	93057-0408	93057-0409	93057-0410	93057-0501	93057-0502	93057-0503	93057-0504	93057-0505	93057-0506	93057-0507	
	93057-0508	93057-0509	93057-0510	93057-0511	93057-0512	93057-0601	93057-0602	93057-0603	93057-0604	93057-0605	
	93057-0606	93057-0607	93057-0608	93057-0609	93057-0701	93057-0702	93057-0703	93057-0704	93057-0705	93057-0706	
	93057-0707	93057-0708	93057-0709	93057-0801	93057-0802	93057-0803	93057-0804	93057-0805	93057-0806	93057-0807	
	93057-0808	93057-0809	93057-0901	93057-0902	93057-1001	93057-1002					
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	93210-0101	93210-0102	93210-0103	93210-0104	93210-0105	93210-0106	93210-0107	93210-0108	93210-0201	93210-0202	
	93210-0203	93210-0204	93210-9001	93210-9002	93210-9003	93210-9101	93210-9102	93210-9201	93210-9202		
93213	93213-0001	93213-0002	93213-0003	93213-0004	93213-0005	93213-0006	93213-0007	93213-0008	93213-0009	93213-0010	
	93213-0011	93213-0012	93213-0013	93213-0014	93213-0015	93213-0016	93213-0102	93213-0103	93213-0104	93213-0105	
	93213-0106	93213-0107	93213-3102	93213-3103	93213-3104	93213-3105	93213-3106	93213-3107			
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	93396-0101	93396-0102	93396-0103	93396-0104	93396-0105	93396-0106	93396-0107	93396-0108	93396-0201	93396-0202	
	93396-0203	93396-0204									

DEFINITION OF TERMS

Terminated Height:



FOR SERIES: 90833, 91247, 91338, 91777, 91778, 91886, 91954, 93052, 93057, and 93213



FOR SERIES: 90835, 91779, 92000, 93210, and 93396

Reference:

Application Specification AS-99033-0004

TERMINATION SPECIFICATION

Wire Size	Terminated Height		Pull Force Minimum*	
	mm	In.	N	Lbf
0.38mm ²	22.90 – 23.20	0.901 – 0.913	50	11.2
0.50mm ²			70	15.7
0.75mm ²			100	22.5
1.0mm ²	24.90 – 25.20	0.980 – 0.992	110	24.7
1.5mm ²			150	33.7
Customer to cut off connector from molded chain			*Parallel or 90° to the wire axis	

Notes:

1. This tool should only be used for the connectors and wire sizes specified on this sheet.
2. Variations in tools, connectors, wire stranding, and insulation types may affect termination height.
3. 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.
4. Terminated height should be used as the final criteria for an acceptable crimp. Pull force is a reference only.
5. Molex does not certify crimp hand tools.

SETUP

Connector Preparation

Trim one connector off the molded chain using a razor blade, as shown below. See Figure 2.

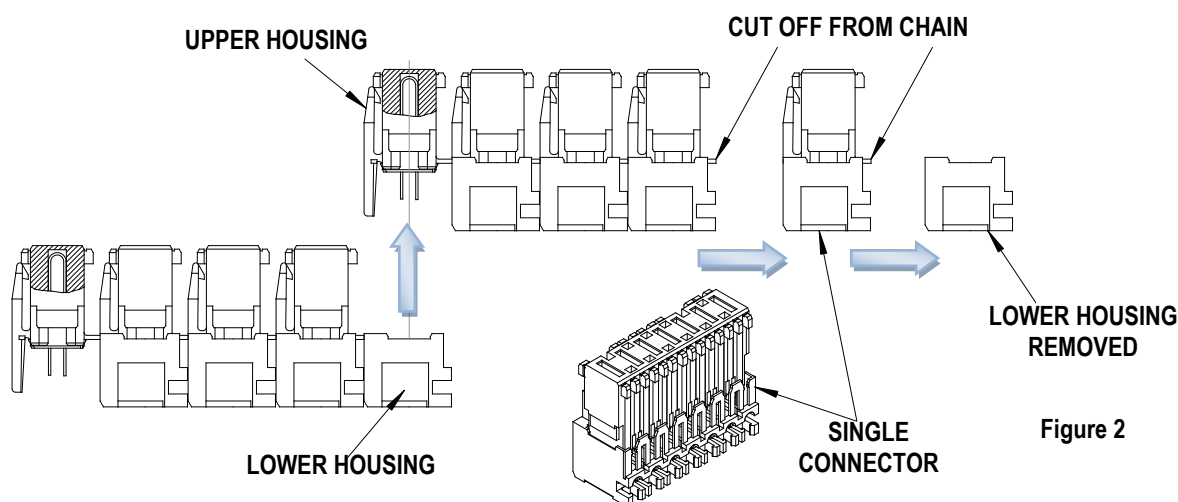


Figure 2

When trimming the connector off the molded chain, be careful to not accidentally close the connector pathway. If the connector is closed too far, wires will be unable to fit into it.

Terminated Height Adjustment

Depending on the connector to be terminated, there is a reversible block in the tool that is used to adjust the terminated height of the connector. Loosen the knob on the back of the tool head and rotate the block to the correct position. Tighten the knob to keep the block in place. See Figure 3.

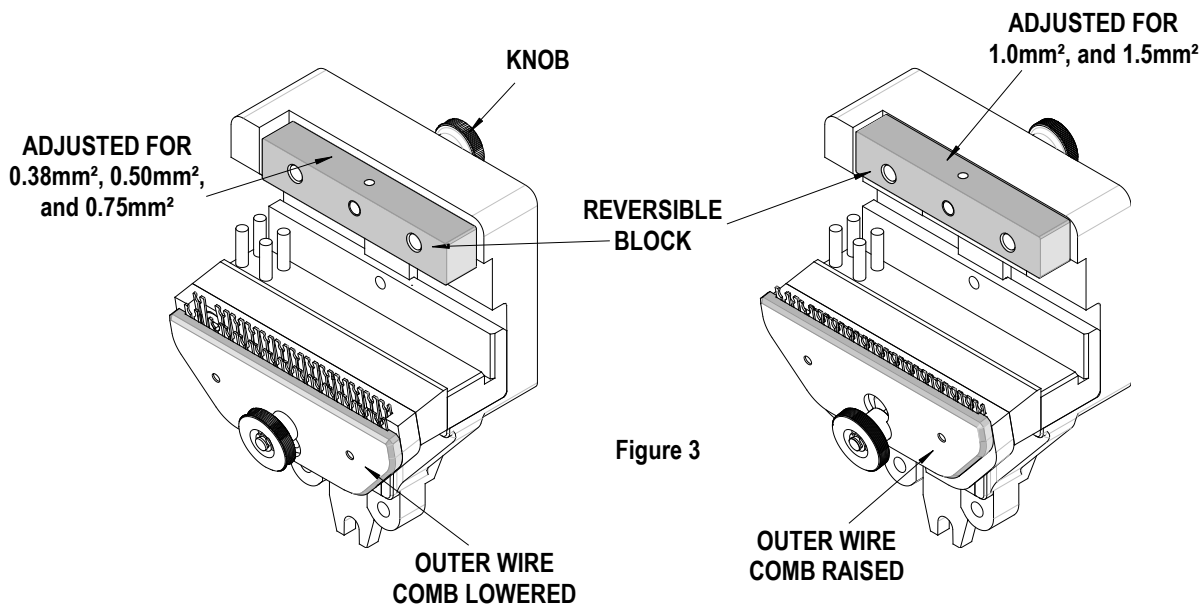


Figure 3

Wire Retaining Comb Adjustment

There are two wire combs in the tool which hold the inserted wires in place prior to termination. The inner comb is used for smaller diameter wires and is lower. The outer comb (for larger wires) can be raised by loosening the knob and raising the comb.

OPERATION

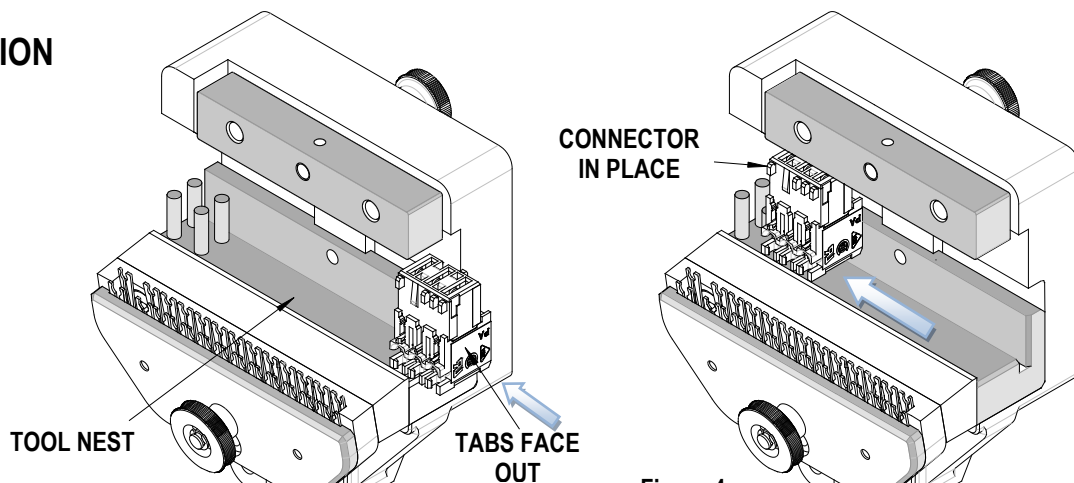


Figure 4

1. 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.
2. With the hand tool in the open position, load the connector in the tool. The tool nest is polarized to accept the connector in only one orientation (tabs facing outward) See Figure 4.
3. Push the connector all the way to the left until it stops.
4. Place the wire into the connector, pushing it in until it stops.
5. To keep the wire in place, press it into the retaining comb on the front of the tool. See Figure 5.
6. Repeat steps 3 and 4 until all wires are loaded into the connector.
7. Note: for the 1-circuit connector, position the connector between the pins on the left side of the tool. See Figure 6.

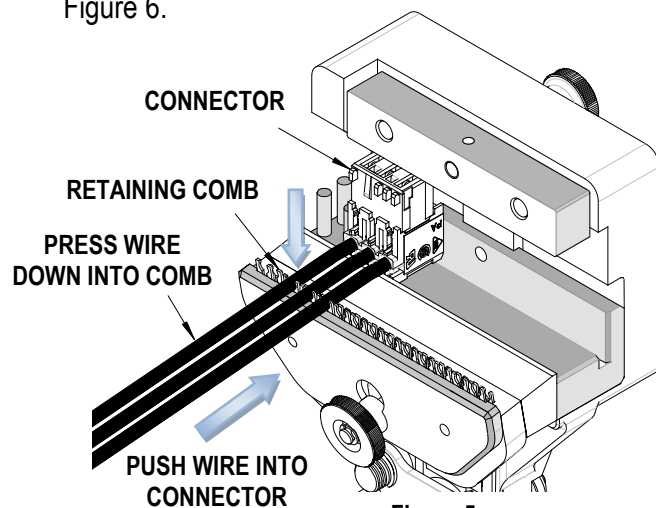


Figure 5

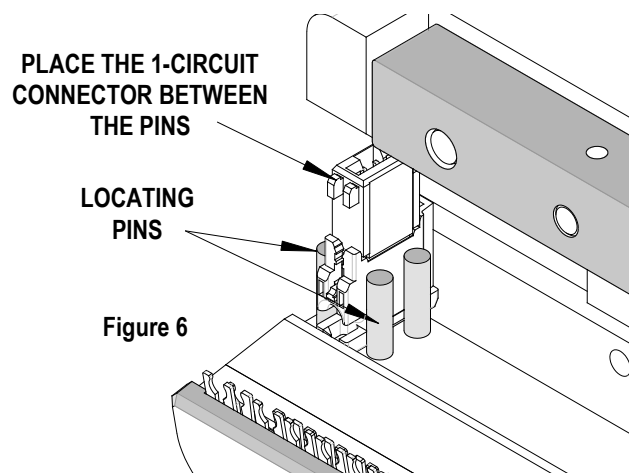


Figure 6

8. To terminate the connector, squeeze the tool handles together until the anti-backup ratchet releases. Release the handles and they will spring open.
9. Lift all wires out of the retaining comb and pull the finished connector out of the tool.

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:

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 connectors or 3 months, will significantly enhance the tool life.
4. Wipe excess oil from hand tool, particularly from the connector nest area. Any oil transferred from the termination area onto the contacts may affect its electrical characteristics.
5. When tool is not in use, keep the handles closed to prevent objects from becoming lodged in the nest 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 8.

Warranty

This tool is for electrical connector termination 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:

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 connectors specified for this tool.

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

Applications for the Modular Crimp Head

WARNING: NEVER operate, service, install, or adjust this Modular Crimp Head without proper instruction and without first reading and understanding the instructions in the proper Manual or Specification Sheet. See Chart below for the correct Manual or Specification Sheet.

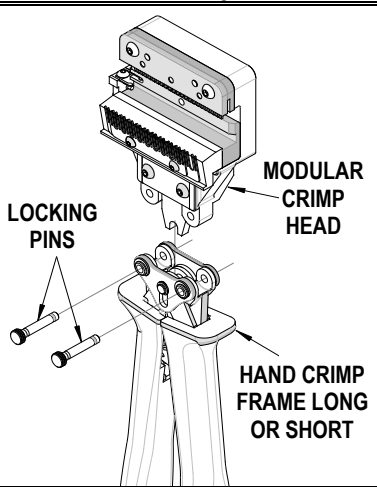
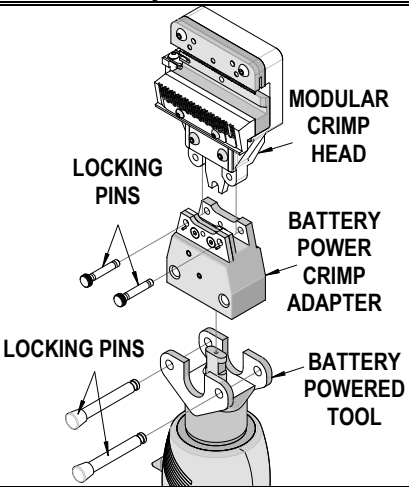
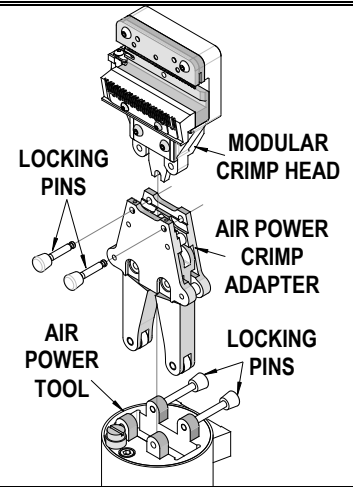
WARNING: NEVER install tooling or service this tool while it is into any power source. Disconnect the power by unplugging or turn off the Actuator from its power source.

CAUTION: Keep fingers away from the termination area when operating this tool. It may cause severe injury.

CAUTION: Wear safety glasses when operating or servicing this tool.

The chart below shows all applications for this Modular Crimp Head.

Modular Crimp Head Order No.	Tool Order no.	Tool Description	Adapter Order No.	Adapter Description	Figure No.
63827-6370	63816-0000	Hand Crimp Frame (Short)	N/A	N/A	5
	63816-0050	Hand Crimp Frame (Long)	N/A	N/A	5
	63816-0200	Battery Power Tool (110 V)	63816-0600	Battery Power Crimp Adapter	6
	63816-0250	Battery Power Tool (220 V)	63816-0600	Battery Power Crimp Adapter	6
	63816-0100	Air Power Tool	63816-0700	Air Power Crimp Adapter	7

Applications for the Modular Crimp Head		
Hand Crimp Tool	Battery Powered Tool	Air Powered Tool
 MODULAR CRIMP HEAD LOCKING PINS HAND CRIMP FRAME LONG OR SHORT Figure 5	 MODULAR CRIMP HEAD LOCKING PINS BATTERY POWER CRIMP ADAPTER BATTERY POWERED TOOL Figure 6	 MODULAR CRIMP HEAD LOCKING PINS AIR POWER CRIMP ADAPTER AIR POWER TOOL LOCKING PINS Figure 7

PARTS LIST

Item	Order Number	Description	Quantity
1	63827-6370	Modular Crimp Head	1
2	63816-0050	Hand Crimp Frame (Long)	1
3	63816-0001	Locking Pin	2
4	63600-0520	Tool Head Spring	2
5	63600-0525	Handle Spring	1

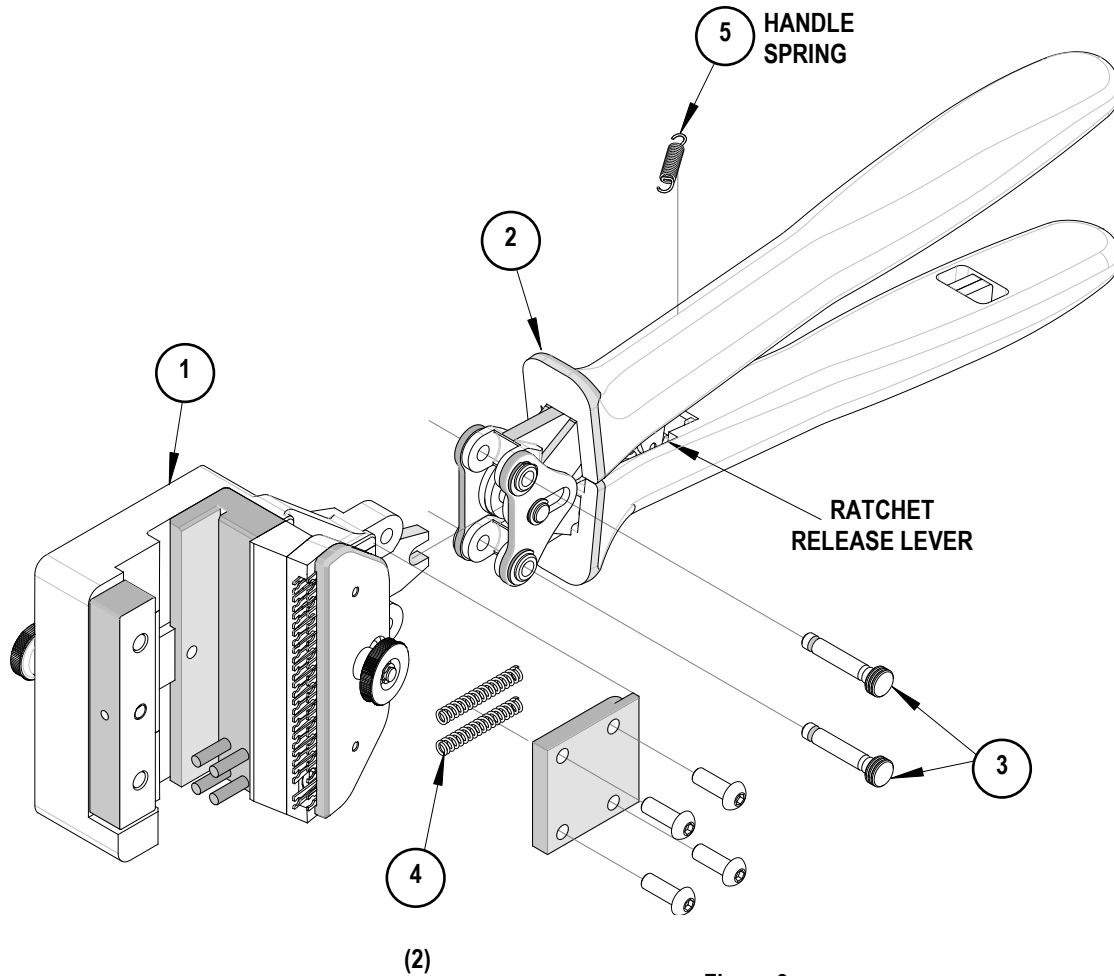


Figure 8

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