

**Modular Crimp Tooling Kit**

**Application Tooling Specification Sheet**

**Order No. 63827-4070**

**SCOPE**

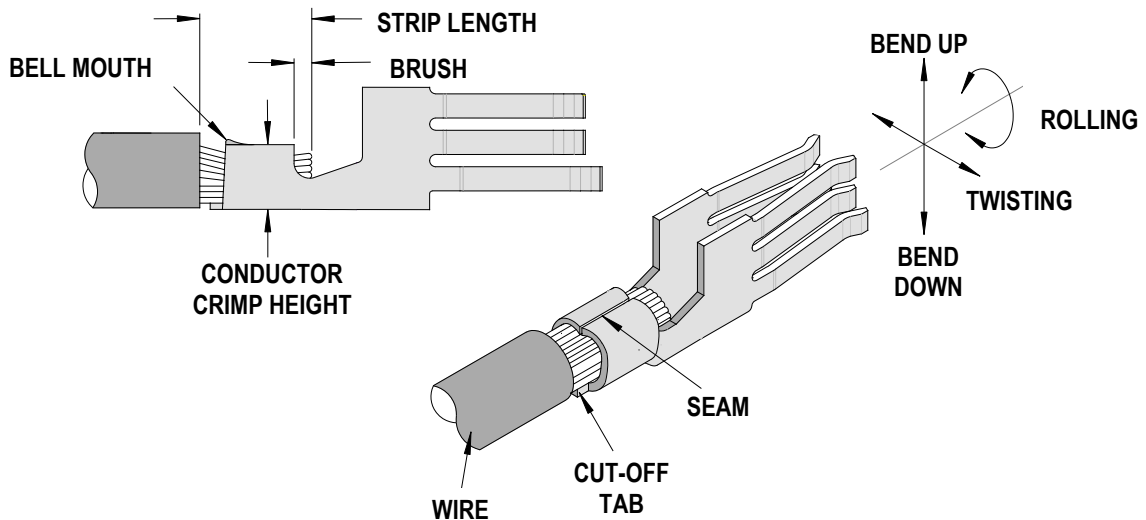
Tooling: The Square "DIN" style die sets are used with two machines and each machine requires an adapter for the square "DIN" dies. The Molex Pneumatic Universal Crimp Machine UP 60 Order Number 63801-8900 will process the square "DIN" style die sets with the 63801-8901 Crimp Adapter. The Molex 12 Ton Battery Powered Crimping Tool, Order Number 63816-1000 will process the square "DIN" style die sets with the 63816-1100 Power Crimp Head. Refer to the appropriate Operation manual for installation and operation information, TM-638018900 or TM-638161000.

Products: Guardian Power Receptacle Terminals, 6 AWG UL1028 or UL1283.

Terminal Series No.	Terminal Order No. (1) Reel Form Only	Wire Size		Insulation Diameter Maximum (2)		Strip Length	
		AWG	mm <sup>2</sup>	mm	In.	mm	In.
46819	46819-0013	6	13.30	8.70	.343	8.00-9.00	.315-.354

(1) Customer to cut off terminal from reel: 0.35mm (.014") maximum cut-off tab.  
 (2) Overall insulation OD specification for terminal.

**DEFINITION OF TERMS**



### CRIMP SPECIFICATION

Terminal Series No.	Bell mouth		Conductor Brush	
	mm	In.	mm	In.
46819	0.25-1.25	.010-.049	1.00-2.50	.039-.098

Terminal Series No.	Bend up	Bend down	Twist	Roll	Seam Seam shall not be open and no wire allowed out of the crimping area
	Degree		Degree		
46819	3	3	3	3	

### CONDITIONS:

After crimping, the crimp profiles should measure the following (See Notes).

Terminal Series No.	Wire Size		Conductor				Pull Force Minimum	
			Crimp Height		Crimp Width (Ref.)			
	AWG	mm <sup>2</sup>	mm	In.	mm	In.	N	Lb.
46819	6	13.30	3.95-4.05	.155-.159	7.20	.283	951.9	214.00

The chart below shows all applications for this Modular Crimp Tooling Kit.

Modular Crimp Tooling Kit Order No.	Tool Order no.	Tool Description	Adapter Order No.	Adapter Description	Figure No.
63827-4070	63816-1000	Battery Power Crimping Tool	63816-1100	Power Crimp Head For DIN Style Dies	1
	63801-8900	Pneumatic Universal Crimp Machine UP60	63801-8901	Crimp Die Adapter For DIN Style Dies	2

### Note:

The individual Modular Crimp Tooling Kit is ordered separately from the Battery Powered Crimping Tool and Pneumatic Universal Crimp Machine UP 60.

**WARNING:** NEVER operate, service, install, or adjust this Modular Crimp Tooling Kit without proper instruction and without first reading and understanding the instructions in the proper Manual or Specification Sheet. See Chart above 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 crimping area when operating this tool. It may cause severe injury.

**CAUTION:** Wear safety glasses when operating or serving this tool.

Applications for the Modular Crimp Tooling Kit	
Battery Powered Tool	Pneumatic Universal Crimp Machine UP 60
<p>UPPER DIE HOLDER</p> <p>LOWER DIE HOLDER</p> <p>LOCKING PINS</p> <p>BATTERY POWERED TOOL</p>	<p>CRIMP ADAPTER</p> <p>PNEUMATIC UNIVERSAL CRIMP MACHINE UP 60</p>
<p>UPPER DIE</p> <p>LOWER DIE</p>	<p>CRIMP ADAPTER</p> <p>MODULAR CRIMP TOOLING KIT</p>
Figure 1	Figure 2

## Parts List

Item Number	Order Number	Description	Quantity
1	63827-4070	Modular Crimp Tooling Kit	1
2	63827-4075	Locator with Wire Stop	REF

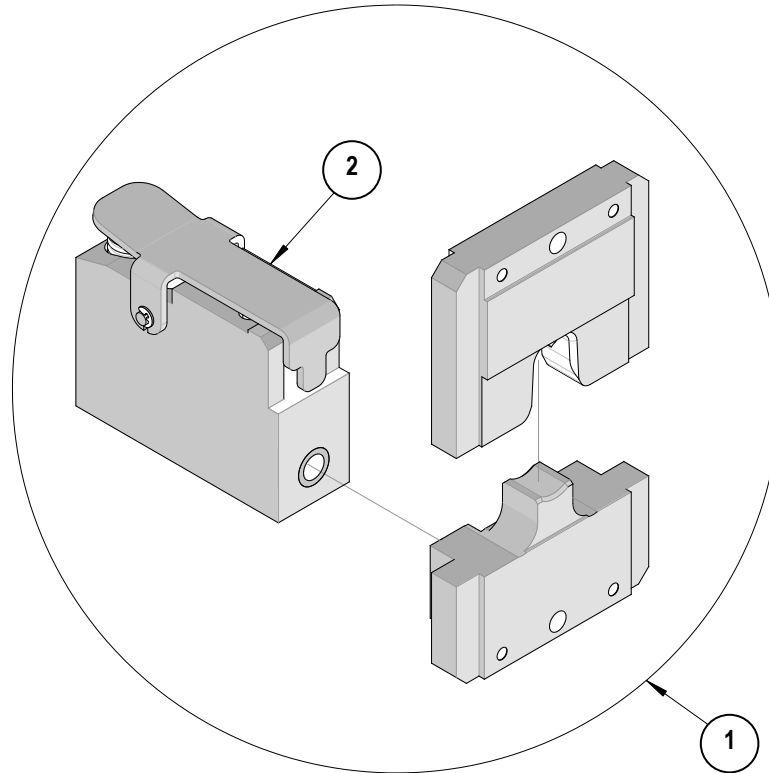


Figure 1

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