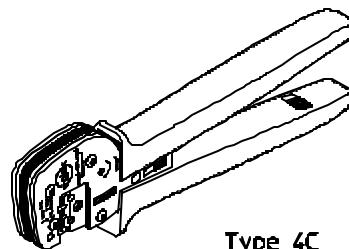




**TOOLING  
SPECIFICATION SHEET  
HAND CRIMP TOOL  
Part No. 63811-2100**



## SCOPE

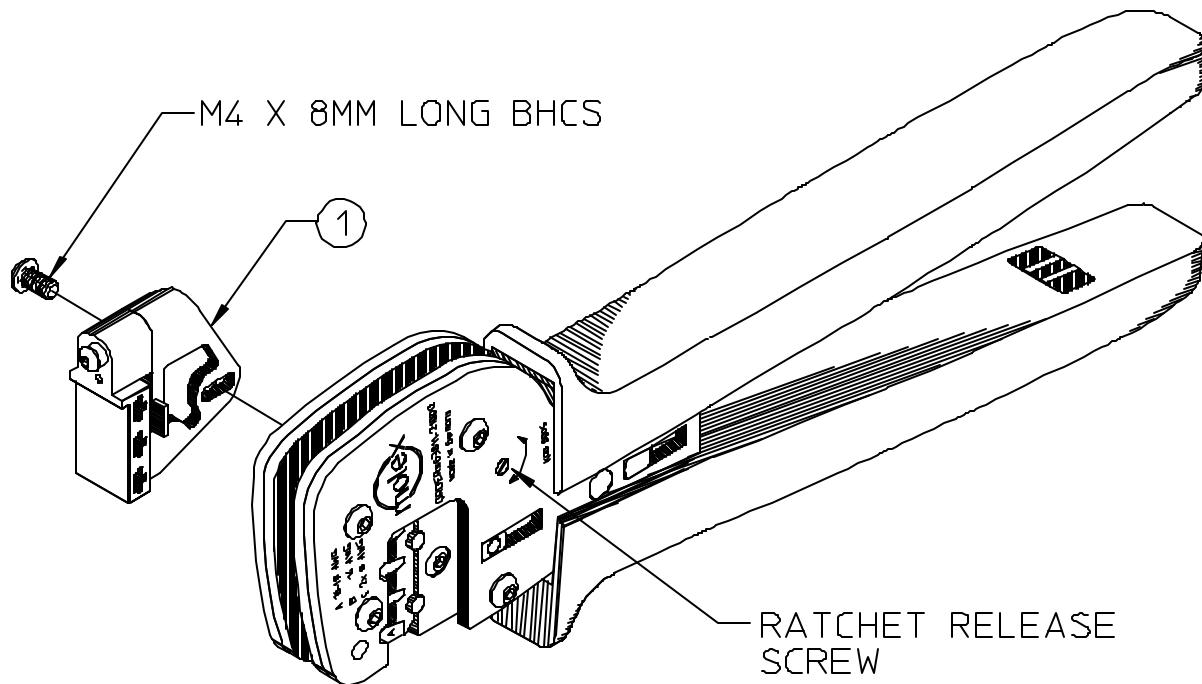
Terminal Series No	Wire Size		Insulation Diameter		Strip Length	
	Awg	mm <sup>2</sup>	mm	in	mm	in
43178-2002	14-18	2.00-0.80	2.70-4.57	.106-.180	3.96-5.54	.156-.218
43178-2002	2x18 Vert.	2x 0.80	2.70-4.57	.106-.180	3.96-5.54	.156-.218

## CONDITIONS:

**After crimping, the conductor profile should measure the following (see notes on page 2).**

## PARTS LIST

Item Number	Order Number	Description	Qty
1	63811-2175	Locator Assy.	1



**Fig. 1**

### Notes:

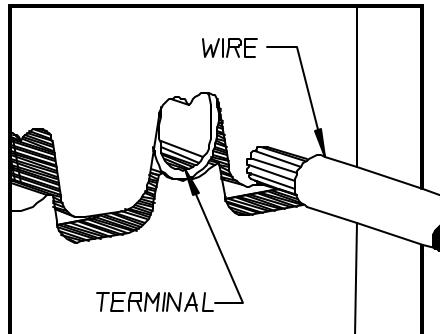
1. This tool should only be used for the terminals and wire gauges specified on this sheet.
2. This tool is not adjustable. Variations in tools, terminals, wire strandings and insulation types may effect crimp height.
3. This tool is intended for standard conductor sizes. It may not give a good insulation crimp support for all insulation sizes and types.
4. Molex does not repair handtools. (see warranty on next page) 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 handtools.
7. Hand held crimping tools are intended for low volume, prototyping, or repair requirements only.
8. This tool is very difficult to disassemble and reassemble. Customer repair is not recommended.

**Caution:** Repetitive use of this tool should be avoided.

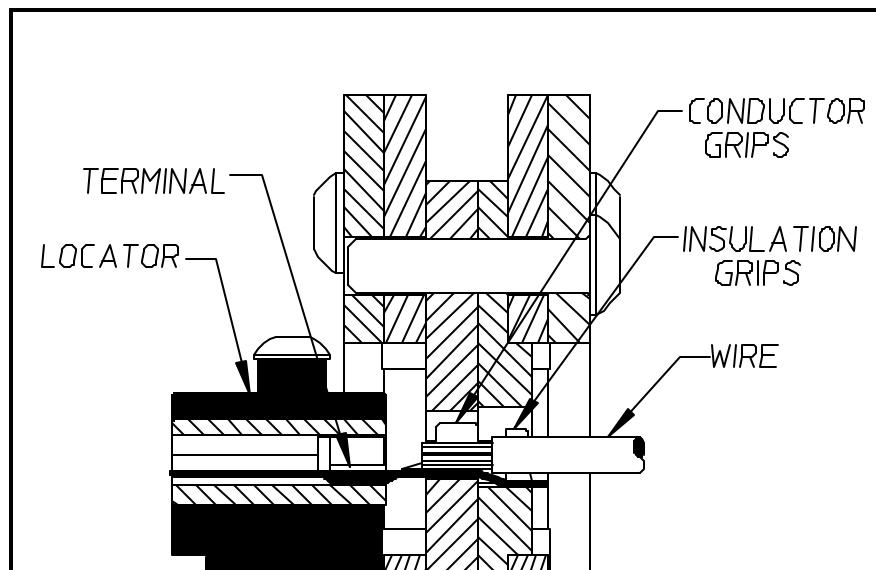
## **Crimping Instructions (see Fig. 1)**

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 tool will spring open.
2. Swing out the locator and insert a terminal into the proper position (A, B, or C). Swing the locator back against the tool. The terminal is now in proper position for crimping.
3. Partially close the tool until the terminal is held in place (see Fig. 2).
4. Place a wire into the terminal and align visually with crimp grips (see Fig. 3).
5. Close the tool until the ratchet releases (see Fig. 4).
6. Carefully remove the crimped terminal.

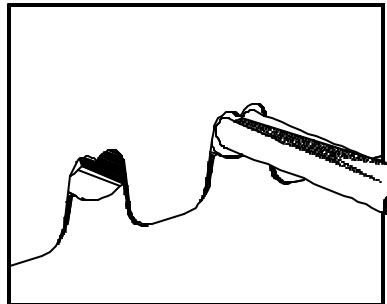
***Fig. 2***



***Fig. 3***



***Fig. 4***



## **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.
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, **Never** force the handles open or closed. The tool will open easily by rotating the small slotted screw marked with an arrow.

## **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 warrantied to be free of manufacturing defects for a period of **30 days**. Should such a defect occur, we will exchange the tool free of charge. This 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.

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