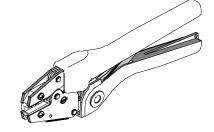


Hand Crimp Tool Operating Instruction And Specifications Sheet Order No. 64001-0900 Eng. No. RHT 7050 (Replaces 19285-0053)



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

SCOPE

Nylon closed end connectors 12–22 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 terminal from the conductor.

Wire Size (AWG)	UL – 486 C
22	8
20	10
18	10
16	15
14	25
12	35

* UL — 486 C — Closed end connectors and Wire Nuts.

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

Terminal No.	Terminal	Wire Size		Wire Combinations
lei iiiiidi 140.	Eng No. (REF)	AWG	mm²	Wife Combinations
19160-0009	NC-2212	12 - 22	(3.30-0.35)	See Chart 1
19160-0010	NC-2212-L	12 - 22	(3.30-0.35)	See Chart 1
19160-0011	NC-2212-BA	12 - 22	(3.30-0.35)	See Chart 1

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OPERATION

Wire Preparation

Pre-twisted wire not required for OEM applications. For Solid Wire strip leads to 3/8 of an inch. Insert into connector and crimp (OEM only).

For stranded wire strip leads to approximately 3/4 of an inch. Twist the wire combination even and tight. Trim stripped pre-twisted area to 3/8 of an inch and insert into connector and crimp. For more information follow the Quality Crimping Handbook.

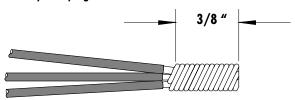


CHART 1

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Wire Combinations for Nylon- Insulated Closed End Connectors Part No. 191600009 (NC-2212)						
				(AWG		
Wire Type	14	16	18	20	22	Rating
Stranded or Solid	1	1				UL & CSA
Stranded or Solid	1		1			UL & CSA
Stranded or Solid	1		2			UL & CSA
Stranded or Solid	1		1	1		UL & CSA
Stranded or Solid	1		1	2		UL & CSA
Stranded or Solid	1		1		1	UL & CSA
Stranded or Solid	1		1		2	UL & CSA
Stranded or Solid	1		1		3	UL & CSA
Stranded or Solid	1			1		UL & CSA
Stranded or Solid	1			2		UL & CSA
Stranded or Solid	1			3		UL & CSA
Stranded or Solid	1				1	UL & CSA
Stranded or Solid	1				2	CSA
Stranded or Solid	1				3	CSA
Stranded or Solid	1				4	CSA
Stranded or Solid	1		1	1	1	CSA
Stranded or Solid	Ì	3				UL & CSA
Stranded or Solid		2				UL & CSA
Stranded or Solid		2	1			UL & CSA
Stranded only		2	2			UL & CSA
Stranded or Solid		2		1		UL & CSA
Stranded or Solid		2		2		UL & CSA
Stranded or Solid		2			1	UL & CSA
Stranded or Solid		2			2	UL & CSA
Stranded or Solid		2			3	UL & CSA
Stranded or Solid		2	1	1		UL & CSA
Stranded or Solid		2	1		1	UL & CSA
Stranded or Solid		2		1	1	UL & CSA
Stranded or Solid		1		1	2	UL & CSA
Stranded or Solid		1	1			UL & CSA
Stranded or Solid		1	1			UL & CSA
Stranded or Solid		1	2			UL & CSA
Stranded or Solid		1	3			UL & CSA

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Wire Combinations for Nylon- Insulated Closed End Connectors Part No. 191600009 (NC-2212)						
Wire Type				(AWG)		Rating
wile Type	14	16	18	20	22	Kuiliig
Stranded or Solid	14	1	10	1	22	UL & CSA
Stranded or Solid		1		2		UL & CSA
Stranded or Solid		1		3		UL & CSA
Stranded or Solid		1		4		UL & CSA
Stranded or Solid		1			1	UL & CSA
Stranded or Solid		1			2	UL & CSA
Stranded or Solid		1			3	UL & CSA
Stranded or Solid		1			4	UL & CSA
Stranded or Solid		1			5	UL & CSA
Stranded or Solid		1	2	1		UL & CSA
Stranded or Solid		1	2		1	UL & CSA
Stranded or Solid		1	2		2	UL & CSA
Stranded or Solid			1	1	1	UL & CSA
Stranded or Solid			1	2	1	UL & CSA
Stranded or Solid			1	1	2	UL & CSA
Stranded Only			5			UL only
Stranded or Solid			4			UL & CSA
Stranded or Solid			4	1		UL & CSA
Stranded or Solid			4		1	UL & CSA
Stranded or Solid			3			UL & CSA
Stranded or Solid			3	1		UL & CSA
Stranded or Solid			3	2		UL & CSA
Stranded or Solid			3		1	UL & CSA
Stranded or Solid			3		2	UL & CSA
Stranded or Solid			3		3	UL & CSA
Stranded or Solid			3	1	1	UL & CSA
Stranded or Solid			2			UL & CSA
Stranded or Solid			2	1		UL & CSA
Stranded or Solid			2	2		UL & CSA
Stranded or Solid			2	3		UL & CSA
Stranded or Solid			2		1	UL & CSA
Stranded or Solid			2		2	UL & CSA
Stranded or Solid			2		3	UL & CSA
Stranded or Solid			2	1	1	UL & CSA
Stranded or Solid			2	2	1	UL & CSA
Stranded or Solid			2	3	1	UL & CSA
Stranded or Solid			2	1	2	UL & CSA
Stranded or Solid			2	1	3	UL & CSA
Stranded or Solid			1	1		UL & CSA
Stranded or Solid			1	2		UL & CSA
Stranded or Solid			1	3		UL & CSA
Stranded or Solid			1	4		UL & CSA
Stranded or Solid			1	5		UL & CSA
Stranded or Solid			1		1	UL & CSA
Stranded or Solid			1		2	UL & CSA
Stranded or Solid			1		3	UL & CSA
Stranded or Solid			1		4	UL & CSA
Stranded or Solid			1		5	UL & CSA
Stranded or Solid			1	1	1	UL & CSA
Stranded or Solid			1	2	1	UL & CSA
Stranded or Solid			1	3	1	UL & CSA
Stranded or Solid			1	4	1	UL & CSA
Stranded or Solid			1	1	2	UL & CSA
Stranded or Solid			1	1	3	UL & CSA
Stranded or Solid			1	1	4	UL & CSA
Stranded or Solid			1	2	2	UL & CSA
Stranded or Solid			1	2	3	UL & CSA
Stranded or Solid			1	3	2	UL & CSA
Stranded or Solid			<u> </u>	6		UL & CSA
Stranded or Solid	<u> </u>		<u> </u>	5		UL & CSA

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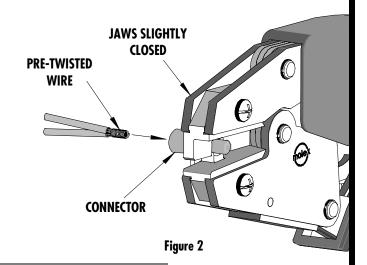
Wire Combinations for Nylon- Insulated Closed End Connectors Part No. 191600009 (NC-2212)						
Wire Type		Wire 6	auge	(AWG)	Rating
wile Type	14	16	18	20	22	Kuiliig
Stranded or Solid				5	1	UL & CSA
Stranded or Solid				4		UL & CSA
Stranded or Solid				4	1	UL & CSA
Stranded or Solid				4	2	UL & CSA
Stranded or Solid				3		UL & CSA
Stranded or Solid				3	1	UL & CSA
Stranded or Solid				3	2	UL & CSA
Stranded or Solid				3	3	UL & CSA
Stranded or Solid				2		UL & CSA
Stranded or Solid				2	1	UL & CSA
Stranded or Solid				2	2	UL & CSA
Stranded or Solid				2	3	UL & CSA

Wire Combinations for Nylon- Insulated Closed End Connectors Part No. 191600009 (NC-2212)						
Wire Type		Wire G	auge	(AWG))	Rating
	14	16	18	20	22	
Stranded or Solid				2	4	UL & CSA
Stranded or Solid				1	1	UL & CSA
Stranded or Solid				1	2	UL & CSA
Stranded or Solid				1	3	UL & CSA
Stranded or Solid				1	4	UL & CSA
Stranded or Solid				1	5	UL & CSA
Stranded or Solid					6	UL & CSA
Stranded or Solid					5	UL & CSA
Stranded or Solid					4	UL & CSA
Stranded or Solid					3	UL & CSA
Stranded or Solid					2	UL & CSA

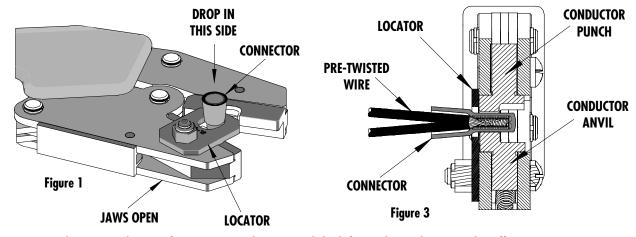
Crimping Terminals

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

- Hold hand tool with the locator facing up. Insert the closed end connector in the correct slot (12-22). Make sure that the shoulder of the connector is resting on the locator plate (See Figure 1).
- Close the hand tool jaws until the connector is held snug in place.
 Load the connector with the desired wire combination (See Figure 2 and 3). Complete the crimp by closing the hand tool handles until they release.



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



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

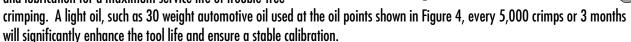
Note: Whenever crimping without the locator, make sure the seam of the terminal is oriented up or down in the tool if using unbrazed product, as this will provide higher pull force values.

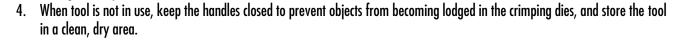
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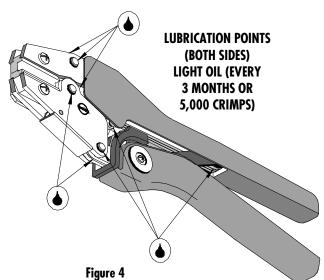
Maintenance

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.
- 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 64001-0900 (RHT-7050) was engineered for
 durability, but like any fine piece of equipment it needs cleaning
 and lubrication for a maximum service life of trouble-free







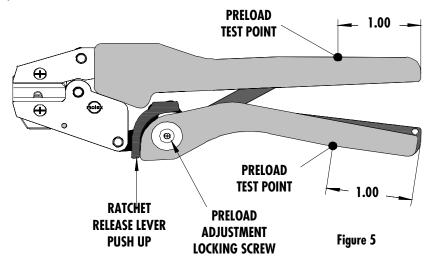
Miscrimps or Jams

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)

It may be necessary over the life of the tool 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:

- 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.

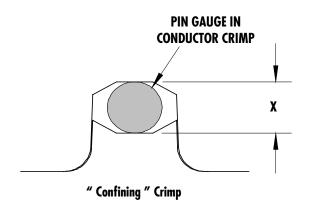


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Tool Calibration

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.



Wire Range			" Dimer ductor (
Awg	mm²	Mean	Go	No Go
12 - 22	0.35 - 3.30	.102	.099	.106

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.

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

Caution: Repetitive use of this tool should be avoided.

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PARTS LIST

Item	Order No	Description	Quantity
	64001-0900	Hand Crimp Tool	(Fig. 6)
1	64000-0076	Repair Kit (Springs, Pins and E-Rings)	1
2	63810-0000	Handle	1
3	64001-0975	Locator Assembly	1
4	64001-0970	Tooling Kit	1
		Tooling Kit Only	
5	64001-0901	Conductor Punch	1
6	64001-0902	Conductor Anvil	1

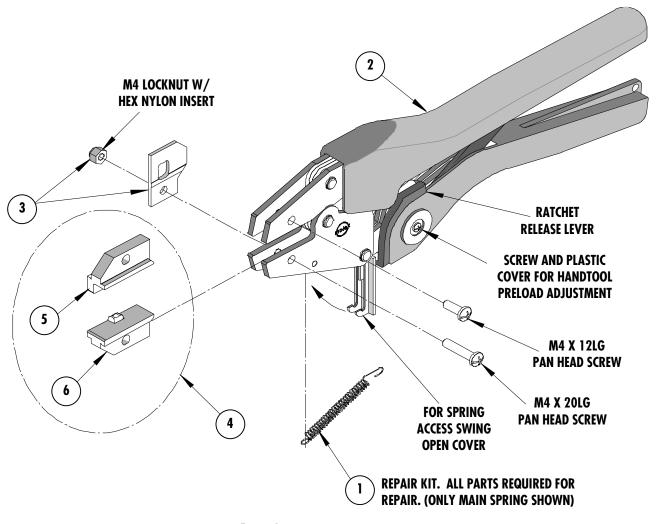
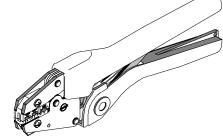


Figure 6

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Tool Order Number	<u>—</u>
Tool Eng. Number	
Tool Revision	
Serial Number	<u> </u>
Date of Manufacture	<u> </u>
	Handle Load Range at 1 inch from the Tips =
	Actual =
Pin Gage of Conductor Nest/Nests or Slug height i	f 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 Tools should be lubricated during this operation.	3 months.

Molex Application Tooling Group

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Fax: (630) 505-0049

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