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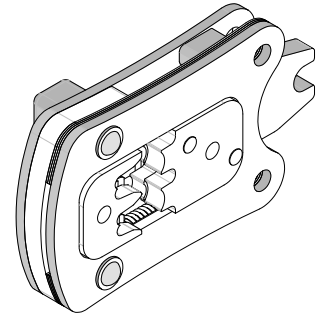
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Modular Crimp Head Specification Sheet Order No. 63811-1170



FEATURES

- Quick change Modular Crimp Head is easily installed into Power Crimp Adapter
- Crimp head is interchangeable with the Air or Battery Power Actuators
- Also installed into Hand Crimp Frames without the adapters
- A precision user-friendly terminal locator wire stop holds terminals in the proper crimping position
- Air or battery powered crimp tools help reduce fatigue and discomfort from repetitive manual crimping

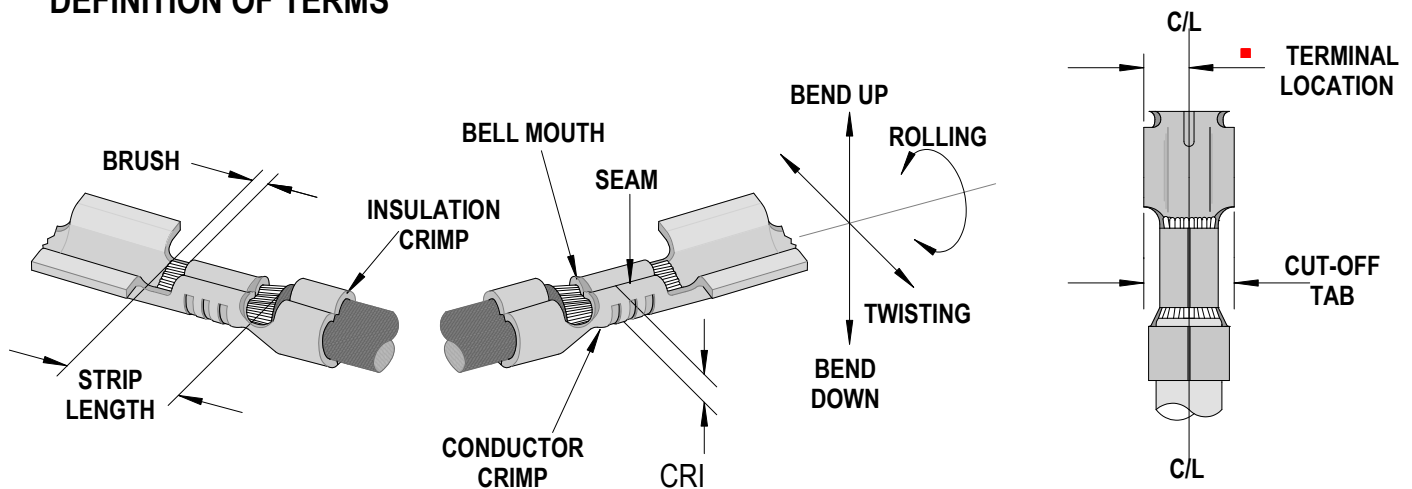
SCOPE

Products: 3.18mm (.125") Diameter HCS-125 Pin and Socket Crimp Terminals, 10-14 AWG.

Terminal Series No.	Terminal Order No.		Wire Size		Insulation Diameter		Strip Length	
	Loose Piece	• Reel	AWG	mm ²	mm	In.	mm	In.
1900	18-12-2602	18-12-2601	10-14	5.25-2.00	3.56-4.57	.140-.180	4.06-5.59	.160-.220
1901	18-12-1602	18-12-1601	10-14	5.25-2.00	3.56-4.57	.140-.180	4.06-5.59	.160-.220
42546		18-12-1607	10-14	5.25-2.00	3.56-4.57	.140-.180	4.06-5.59	.160-.220
42547	18-12-1604	18-12-1603	10-14	5.25-2.00	3.56-4.57	.140-.180	4.06-5.59	.160-.220

• Follow the Cut-Off Tab specifications on Applicator specification sheets.
 These Terminals cannot be removed from the reel by manual cutting.
 An applicator must be used or the terminals will not function properly.

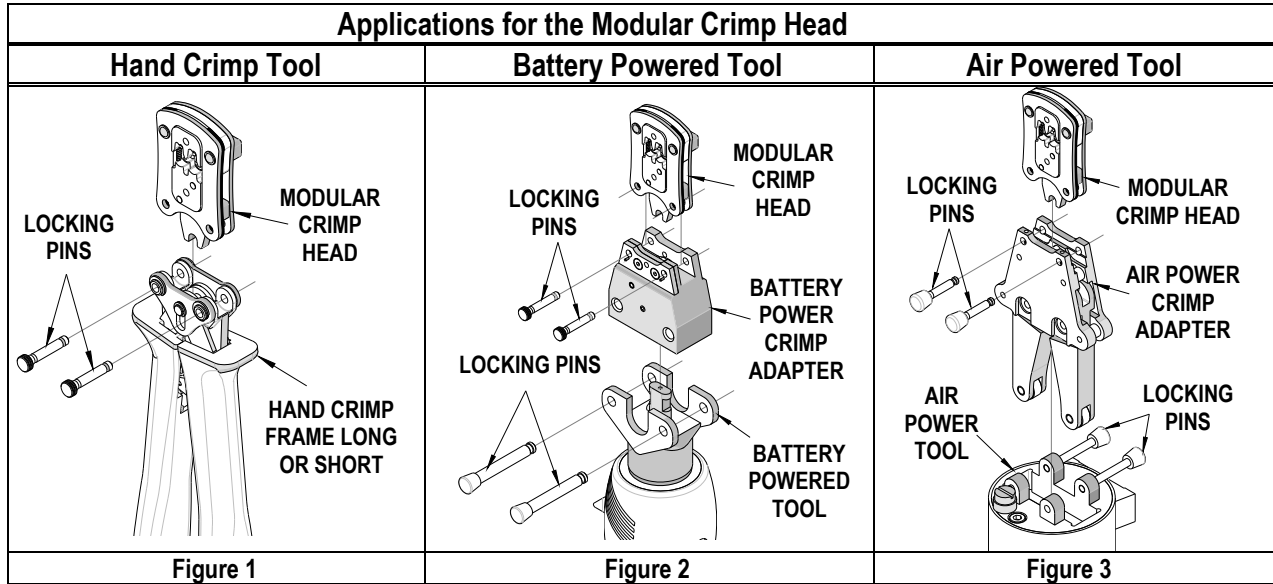
DEFINITION OF TERMS



- Terminal is to be centrally located between the two (2) cut-off tab edges by one half of the total cut-off tab tolerance.
- This illustration is a generic terminal representation and not an exact image of any terminal listed in the scope.

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.
63811-1170	63816-0000	Hand Crimp Frame (Short)	N/A	N/A	1
	63816-0050	Hand Crimp Frame (Long)	N/A	N/A	1
	63816-0200	Battery Power Tool	63816-0600	Battery Power Crimp Adapter	2
	63816-0100	Air Power Tool	63816-0700	Air Power Crimp Adapter	3



CONDITIONS:

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

Terminal Series No.	Wire Size		Conductor Crimp				Pull Force Minimum		Profile	
			Height (Ref)		Width (Ref)					
	AWG	mm ²	mm	In.	mm	In.	N	Lb.	A	B
1900	14	2.00	1.90-2.00	.075-.079	3.91	.154	222.4	50.00	X	
	12	3.30	2.08-2.18	.082-.086	3.91	.154	311.4	70.00	X	
	10	5.25	2.24-2.34	.088-.092	4.01	.158	355.9	80.00		X
1901	14	2.00	1.90-2.00	.075-.079	3.91	.154	222.4	50.00	X	
	12	3.30	2.08-2.18	.082-.086	3.91	.154	311.4	70.00	X	
	10	5.25	2.24-2.34	.088-.092	4.01	.158	355.9	80.00		X
42546	14	2.00	1.90-2.00	.075-.079	3.91	.154	222.4	50.00	X	
	12	3.30	2.08-2.18	.082-.086	3.91	.154	311.4	70.00	X	
	10	5.25	2.24-2.34	.088-.092	4.01	.158	355.9	80.00		X
42547	14	2.00	1.90-2.00	.075-.079	3.91	.154	222.4	50.00	X	
	12	3.30	2.08-2.18	.082-.086	3.91	.154	311.4	70.00	X	
	10	5.25	2.24-2.34	.088-.092	4.01	.158	355.9	80.00		X

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 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.

OPERATION

The Modular Crimp Head can be installed into various applications. Refer to the chart on the previous page and see Figures 1 through 3.

Crimping Terminals

1. Place the terminal into the correct die profile (A or B) until the terminal stopped by the locator.
2. Place a pre-stripped wire into the terminal and align the wire with the conductor and insulation grips visually. See Figure 4 and 5.
3. Cycle the tool.
4. Carefully remove the crimped terminal.

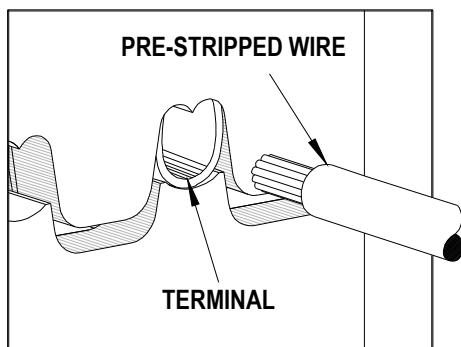


Figure 4

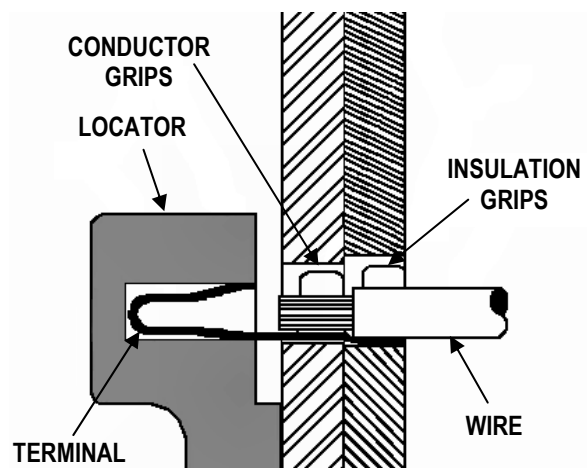


Figure 5

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 crimps or 3 months, will significantly enhance the tool life.
4. Wipe excess oil from the tool, particularly from crimping area. Oil transferred from the crimping area onto certain terminations may affect the electrical characteristics of an application.
5. Store the tool in a clean and dry location when not in use.

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.

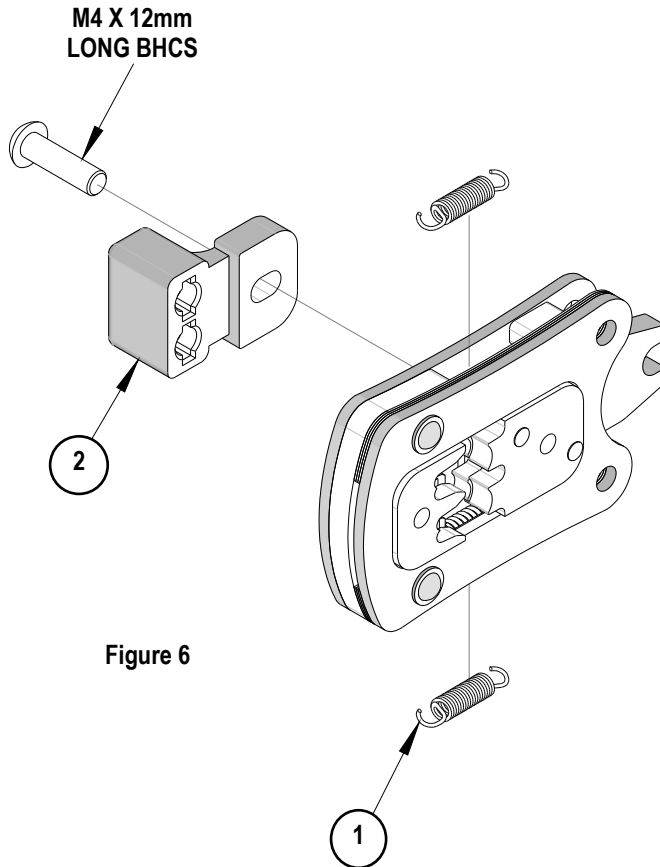
Notes:

1. This tool should only be used for the terminals and wire gauges specified on this sheet.
2. This tool is not adjustable for crimp height; however crimp force is adjustable (See instructions above). Variations in tools, terminals, wire stranding and insulation types may affect crimp height.
3. This tool is intended for standard conductor sizes. It may not give a good insulation crimp support for all insulation sizes.
4. Molex does not repair hand tools. (see warranty above) The replacement parts listed are the only parts available for repair. If the 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 tools.

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

PARTS LIST

Item	Order Number	Description	Quantity
1	63600-0520	Crimping Spring	2
2	63811-1175	Locator	1



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