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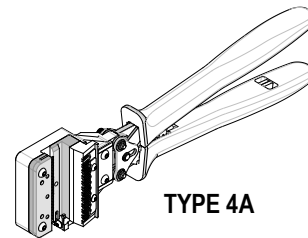
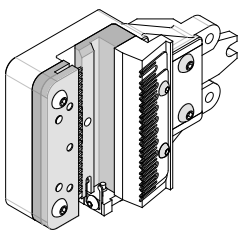
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**Modular Crimp Head
Order No. 63827-2970**

Application Tooling Specification Sheet

**Hand Crimp Tool
Order No. 63827-2900**

FEATURES

- % A full cycle ratcheting hand tool ensures complete crimps
- % 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 RAST2.5, RAST Signal, and R-Power connectors.

Connector Series	Connector Order No.	Wire Size	Insulation Diameter	
		mm ²	mm	In.
RAST2.5	See table below	0.22 – 0.38	1.60 max	0.063 max
RAST Signal	See table below	0.22 – 0.38	1.60 max	0.063 max
R-Power	See table below	0.38 – 0.50	2.20 max	0.087 max
*Customer to cut off connector from molded chain				
Contact Molex about approved AWG wires for these products				

Connector Series	Assembly Order Number								
RAST2.5 90871	90871-0001	90871-0002	90871-0013	90871-0014	90871-0015	90871-0016	90871-0017	90871-0018	
	90871-0019	90871-0020	90871-0021	90871-0022	90871-0024	90871-0034	90871-0041	90871-0042	
	90871-0044	90871-0251	90871-0252	90871-0253	90871-0501	90871-0502	90871-0503	90871-0504	
	90871-0505	90871-0506	90871-0507	90871-0508	90871-0509	90871-0530	90871-0538	90871-0539	
	90871-0540	90871-0541	90871-0542	90871-0751	90871-0752	90871-0677	90871-0678	90871-0679	
	90871-0755	90871-1001	90871-1002	90871-1003	90871-1004	90871-1005	90871-1006	90871-1007	
	90871-1008	90871-1009	90871-1251	90871-1501	90871-1502	90871-1503	90871-1504	90871-1505	
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	90871-1514	90871-1515	90871-1516	90871-1517	90871-1518	90871-1519	90871-1520	90871-1521	
	90871-1522	90871-1523	90871-1524	90871-1525	90871-1526	90871-1527	90871-1528	90871-1529	
	90871-1751	90871-1752	90871-1753	90871-2001	90871-2002	90871-2004	90871-2005	90871-2006	
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	90871-2504	90871-2505	90871-2506	90871-2507	90871-2508	90871-2509	90871-2751	90871-2752	
	90871-2753	90871-3001	90871-3002	90871-3003	90871-3004	90871-3251	90871-3256	90871-3501	
	90871-3502	90871-3503	90871-3751	90871-3752	90871-3753	90871-4001	90871-4002	90871-4251	
	90871-4501	90871-4751	90871-5001	90871-5002	90871-5003	90871-5004	90871-5005	90871-5501	
	90871-5751	90871-6001	90871-6002	90871-6251	90871-6501	90871-7001	90871-7501	90871-8001	
	90871-8501	90871-8751							
	RAST2.5 90872	90872-0002	90872-0003	90872-0004	90872-0005	90872-0006	90872-0007	90872-0008	90872-0009
		90872-0010	90872-0011	90872-0012	90872-0013	90872-0014	90872-0015	90872-0016	90872-0017

Connector Series	Assembly Order Number							
RAST2.5 90872	90872-0018	90872-0019	90872-0020	90872-0021	90872-0022	90872-0023	90872-0024	90872-0351
	90872-0352	90872-0353	90872-0354	90872-0501	90872-1001	90872-1002	90872-1003	90872-1004
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	90872-2002	90872-2003	90872-2004	90872-2005	90872-2006	90872-2007	90872-2008	90872-2009
	90872-2010	90872-2011	90872-3001	90872-4001	90872-5001	90872-5002	90872-6001	
RAST2.5 91491	91491-0002	91491-0003	91491-0004	91491-0005	91491-0006	91491-0007	914910008	914910009
	91491-0010	91491-0011	91491-0012	91491-0013	91491-0014	91491-0015	91491-0016	91491-0017
	91491-0018	91491-0022	91491-0023	91491-0042	91491-0043	91491-0044	91491-0045	91491-0046
	91491-0047	91491-0048	91491-0049	91491-0050	91491-0051	91491-0052	91491-0053	91491-0054
	91491-0055	91491-0056	91491-0057	91491-0058	91491-0062	91491-0063	91491-0104	91491-0143
	91491-0144	91491-0203	91491-0208	91491-0210	91491-0215	91491-0243	91491-0248	91491-0250
	91491-0255	91491-0263	91491-0304	91491-0305	91491-0310	91491-0344	91491-0345	91491-0350
	91491-0405	91491-0412	91491-0445	91491-0452	91491-0506	91491-0509	91491-0511	91491-0546
	91491-0549	91491-0551	91491-0607	91491-0611	91491-0612	91491-0647	91491-0651	91491-0652
	91491-0708	91491-0748	91491-0809	91491-0849	91491-0852	91491-0910	91491-0950	91491-1011
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	91716-0042	91716-0043	91716-0044	91716-0045	91716-0046	91716-0501	91716-0502	91716-0503
	91716-0504	91716-0505	91716-0506	91716-0507	91716-0530	91716-0538	91716-0539	91716-0540
	91716-0541	91716-0542	91716-0543	91716-0544	91716-0545	91716-0546	91716-0677	91716-0678
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	91716-5501	91716-6001	91716-6002	91716-6501	91716-7001	91716-7501	91716-8001	91716-8501
RAST2.5 91717	91717-0002	91717-0003	91717-0004	91717-0005	91717-0006	91717-0007	91717-0008	91717-0009
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Connector Series	Assembly Order Number							
RAST2.5 91780	91780-6501	91780-7001	91780-7002	91780-7501	91780-8001	91780-8501	91780-9001	91780-9002
	91780-9003	91780-9004	91780-9005	91780-9006	91780-9007	91780-9008	91780-9009	91780-9010
	91780-9011	91780-9012	91780-9013	91780-9014	91780-9015			
RAST2.5 92332	92332-0043	92332-0045	92332-2048	92332-2148				
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	92336-0019	92336-0020	92336-0021	92336-0022	92336-0023	92336-0024	92336-0041	92336-0042
	92336-0043	92336-0044	92336-0045	92336-0046	92336-0501	92336-0502	92336-0503	92336-0504
	92336-0505	92336-0506	92336-0507	92336-0530	92336-0538	92336-0539	92336-0540	92336-0541
	92336-0542	92336-0543	92336-0544	92336-0545	92336-0546	92336-0677	92336-0678	92336-0679
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	92336-1009	92336-1010	92336-1011	92336-1012	92336-1013	92336-1014	92336-1015	92336-1501
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	92336-3006	92336-3007	92336-3008	92336-3009	92336-3501	92336-3502	92336-3503	92336-3504
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	92336-5003	92336-5501	92336-6001	92336-6002	92336-6501	92336-7001	92336-7501	92336-8001
92336-8501								
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	92338-0043	92338-0044	92338-0351	92338-1001	92338-1002	92338-1003	92338-1004	92338-1005
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	92338-7001							
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	92339-0009	92339-0010	92339-0011	92339-0013	92339-0014	92339-0501	92339-0502	92339-0503
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	92339-3006	92339-3007	92339-3008	92339-3009	92339-3010	92339-3426	92339-3501	92339-3502
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	92339-4505	92339-4506	92339-5001	92339-5501	92339-6001	92339-6426	92339-6501	92339-7001
	92339-7002	92339-7501	92339-8001	92339-8501	92339-9001	92339-9002	92339-9003	92339-9004
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	92339-9014							
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93037-0261		93037-0262	93037-0301	93037-0302	93037-0303	93037-0501	93037-0502	93037-0503
93037-0751		93037-0752	93037-0753	93037-0754	93037-0755	93037-0756	93037-0757	93037-0758
93037-0759		93037-1001	93037-1002	93037-1003	93037-1251	93037-1252	93037-1253	93037-1501
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RAST2.5	93037-2751	93037-2752	93037-3001	93037-3002	93037-3003	93037-3501	93037-3502	93037-4001

Connector Series	Assembly Order Number							
93037	93037-4251	93037-4501	93037-5001	93037-5002	93037-5003	93037-5004	93037-5251	
RAST2.5 93039	93039-0001	93039-0002	93039-0003	93039-0004	93039-0251	93039-0252	93039-0253	93039-0254
	93039-0255	93039-0256	93039-1001	93039-2001	93039-2002	93039-3001	93039-4001	93039-5001
RAST2.5 93050	93050-0001	93050-0003	93050-0005	93050-0006	93050-0007	93050-0008	93050-0009	93050-0011
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Connector Series	Assembly Order Number							
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	93270-1005	93270-1006	93270-1007	93270-1008	93270-1009	93270-1010	93270-1011	93270-1012
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	93280-7501	93280-7502	93280-8001	93280-8501				
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Connector Series	Assembly Order Number							
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93366-0506		93366-0507	93366-0508	93366-0751	93366-0752	93366-0753	93366-0754	93366-0755
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DEFINITION OF TERMS

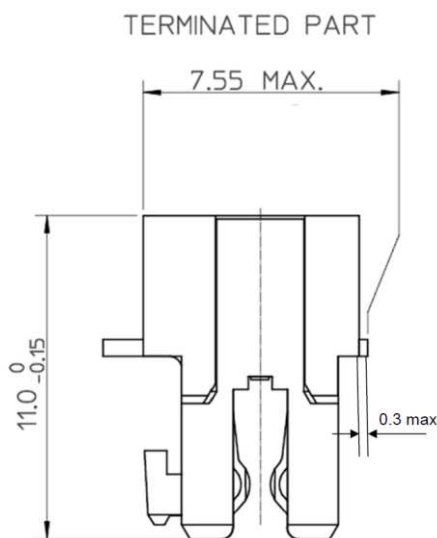


Figure 1

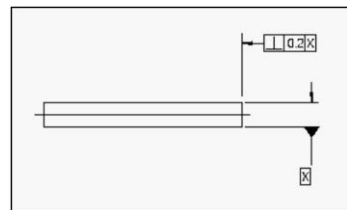


Fig. 1: The cables to be cut off without burr or deformity

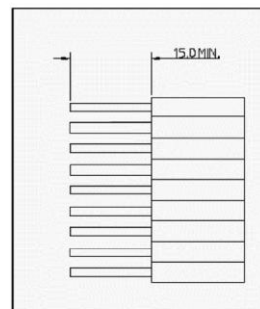


Fig. 2: Ribbon cable to be prepared as per above diagram.

Reference:
Application Specification AS-99033-0008.

TERMINATION SPECIFICATION

Connector Series	Terminated Height		Cut-off Tab Maximum*		Pull Force Minimum*	
	mm	In.	mm	In.	N	Lbf
RAST2.5	10.85 – 11.00	0.427 – 0.433	0.3	0.012	30	6.7
RAST Signal					30	6.7
R-Power					50	11.2
*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 gauges specified on this sheet.
2. This tool is not adjustable for termination height. 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.

OPERATION

Trim one connector off the molded chain using a razor blade, as shown below. See Figure 2. The cut-off tab must be less than 0.3mm as shown in Figure 1.

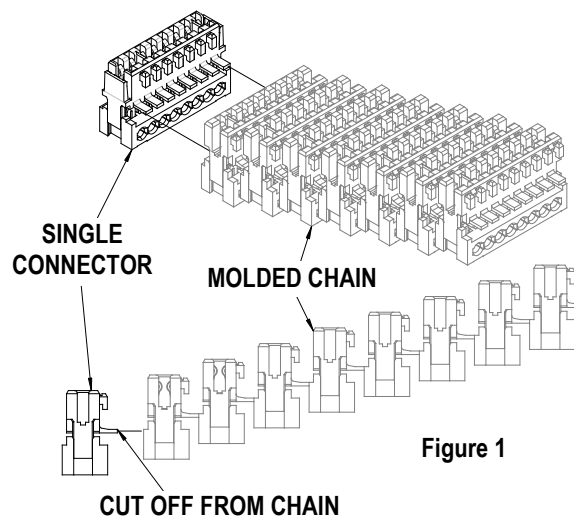
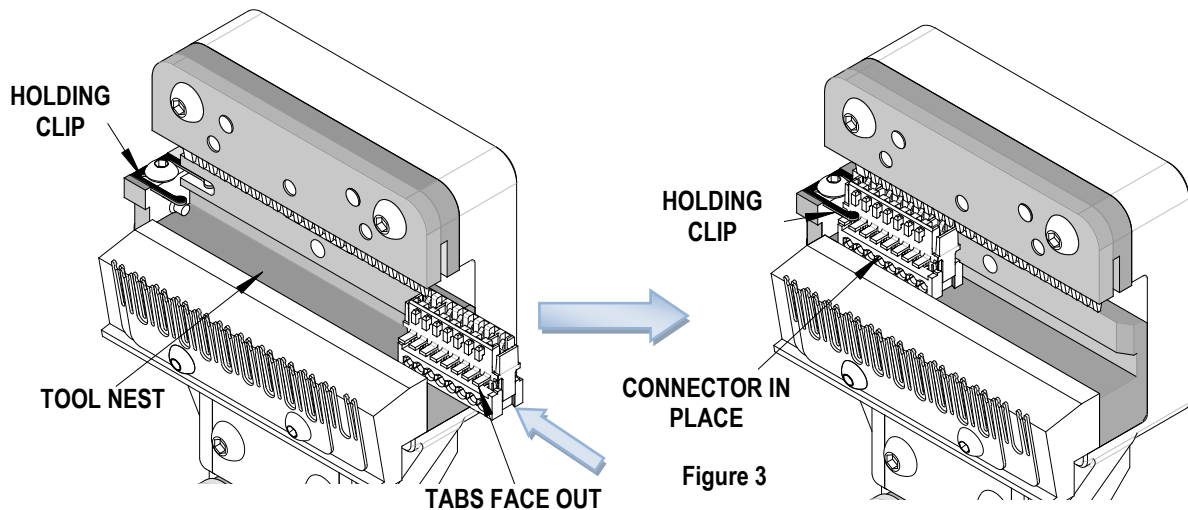


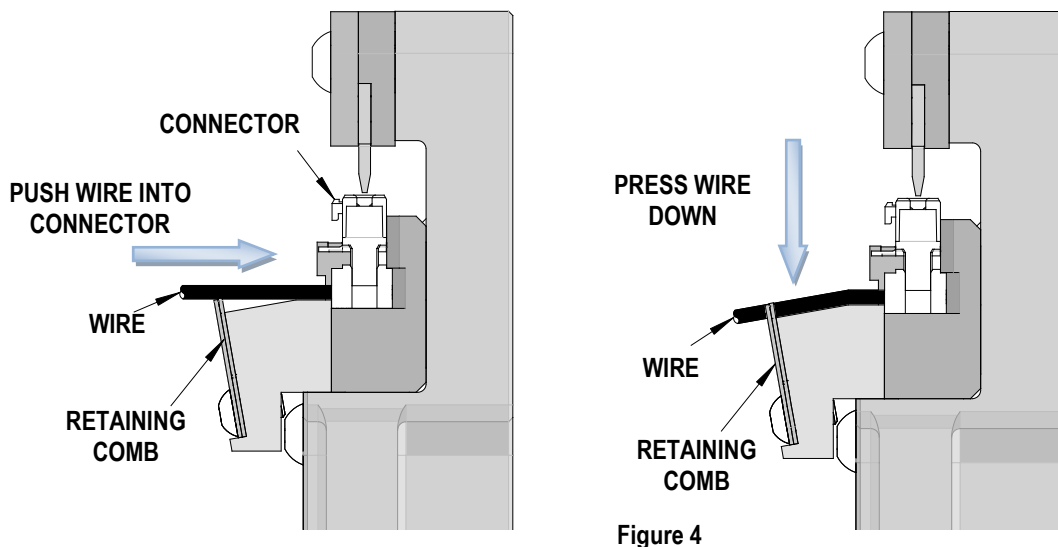
Figure 1

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

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 3.



3. Push the connector all the way to the left until it stops. There is a holding clip in the tool to prevent the connector from falling out.
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 4.



6. Repeat steps 3 and 4 until all wires are loaded into the connector.
7. To terminate the connector, squeeze the tool handles together until the anti-backup ratchet releases. Release the handles and they will spring open.
8. 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.

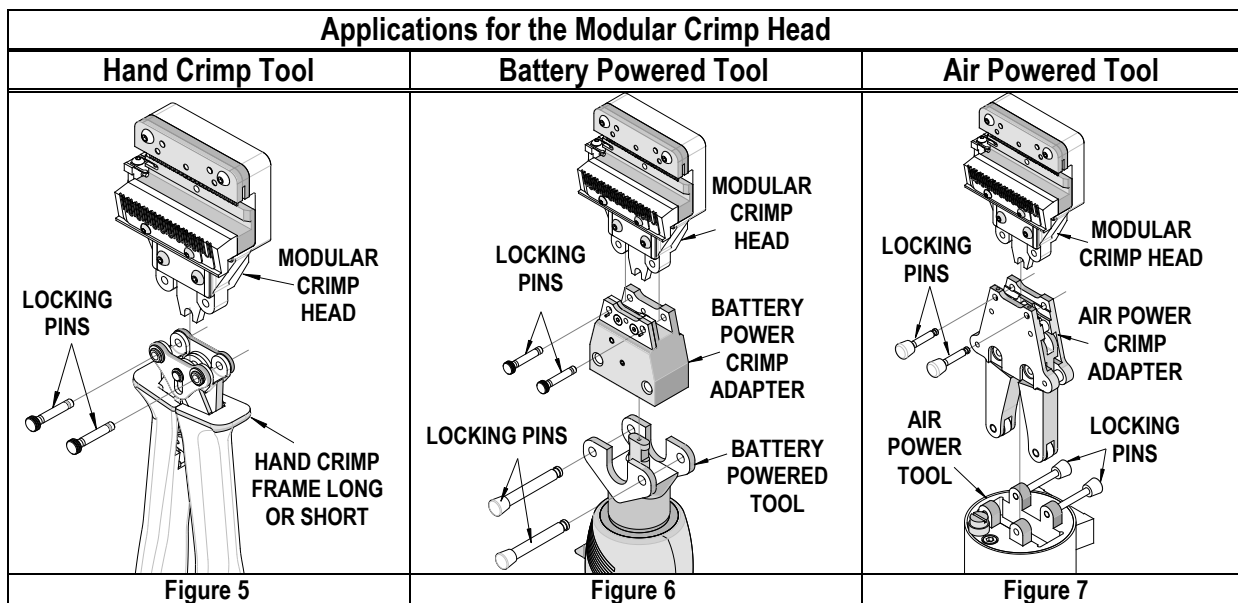
WARNING: NEVER install tooling or service this tool while it is into any power source. Disconnect the power by unplugging or turn off the Actuator from its power source.

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.
63827-2970	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



PARTS LIST

Item	Order Number	Description	Quantity
1	63827-2970	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

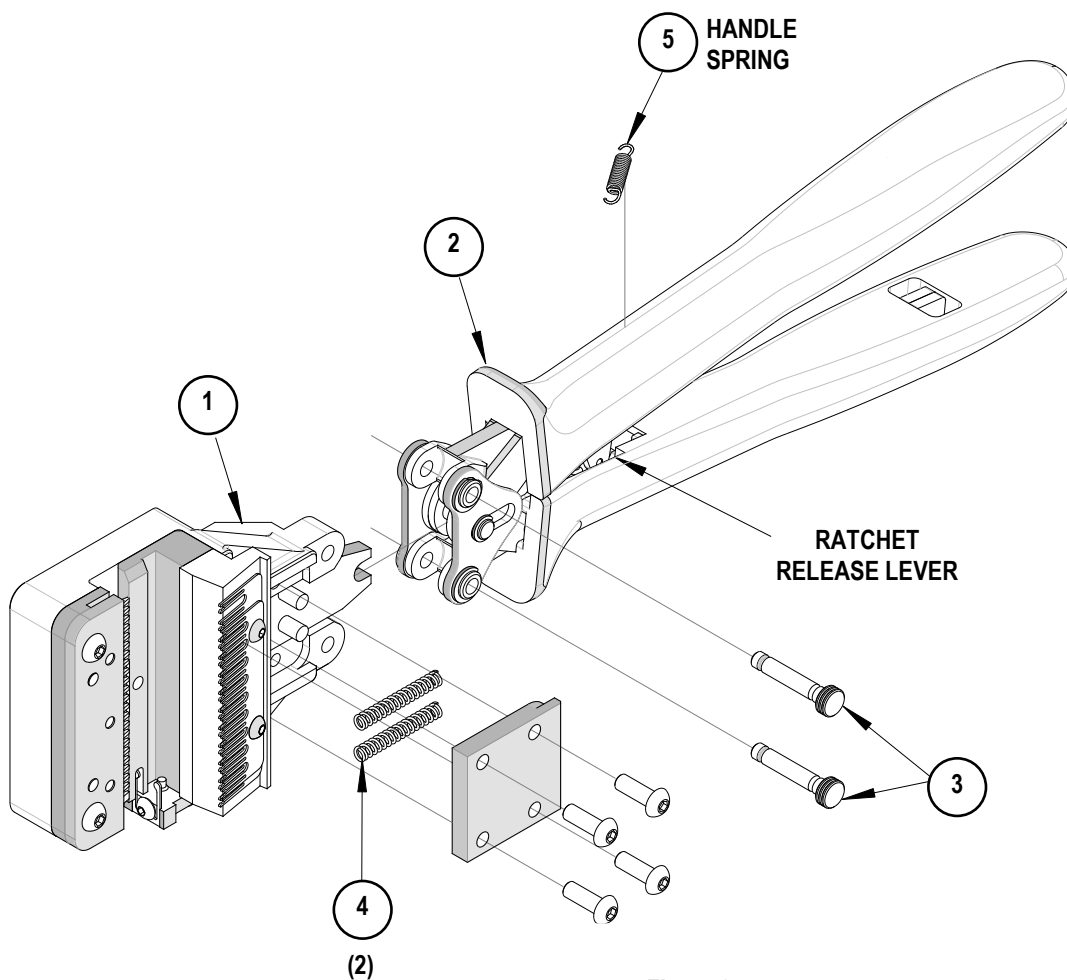


Figure 8

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