

**Hand Crimp Tool  
VibraKrimp™**

**Application Tooling  
Specification Sheet**

**Order No. 64001-6700  
Engineering No. RHT 4050**

**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
- Insulation crimp adjustment allows a precise insulation crimp. To meet or exceed the requirements of UL, CSA and Military Class II
- Single color-coded crimp pocket eliminates the possibility of using the wrong pocket

**SCOPE**

Products: VibraKrimp™ Ring Tongue Terminals with brass sleeve, 18-22 AWG. (Standard and Military)

**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 and Government specifications (MIL-T-7928) for various wire sizes. The tensile strength is shown in pounds. It indicates the minimum acceptable force to break or separate the terminal from the conductor.

Wire Size (AWG)	*UL - 486 A	**Military Class 2
22	8	15
20	13	19
18	20	38

\*UL - 486 A - Terminals (Copper conductors only)

\*\*Military Class 2- Military Approved Terminals only as listed

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](http://www.molex.com).

<b>MILITARY CLASS 2</b>					
<b>Wire Size: 18 – 22 AWG 0.80 – 0.35mm<sup>2</sup></b>					
Terminal No.	Terminal Eng No. (REF)	Wire Strip Length		Insulation Diameter Maximum	
		In.	mm	In	mm
19072-0008	AA-420-04	.250	6.35	.140	3.56
19072-0010	AA-420-06	.250	6.35	.140	3.56
19072-0016	AA-421-10	.250	6.35	.140	3.56
19072-0028	AA-426-38	.250	6.35	.140	3.56
19072-0030	AA-426-56	.250	6.35	.140	3.56

Wire Size: 18 – 22 AWG 0.80 – 0.35mm <sup>2</sup>					
Terminal No.	Terminal Eng No. (REF)	Wire Strip Length		Insulation Diameter Maximum	
		In.	mm	In.	mm
19072-0021	AA-422-14	.250	6.35	.140	3.56
19072-0032	AA-432-04	.250	6.35	.140	3.56
19072-0034	AA-432-06	.250	6.35	.140	3.56

## OPERATION

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

### Crimping Terminals

1. Push up on the locator blade and position the terminal with the barrel facing up into the color-coded nest with front edge of the barrel against the locator. See Figure 1. Release the locator blade to hold the terminal in position.
2. Partially close the tool to hold the terminal in place. See Figure 2.
3. Insert the properly stripped wire into the terminal barrel. See Figure 2 and 3. The wires end should butt against the wire stop position of the locator. Cycle the tool.

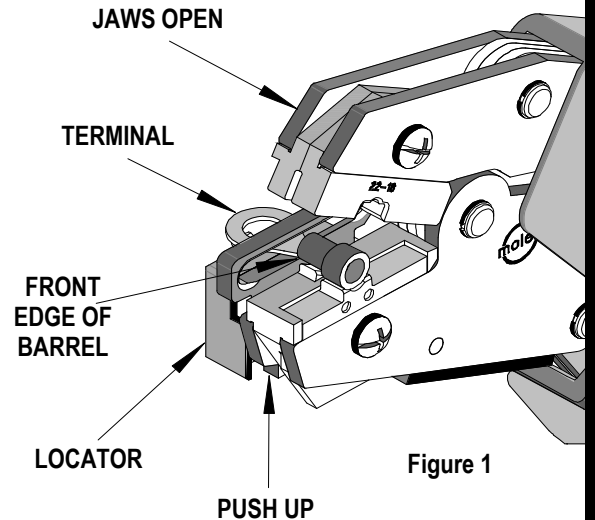


Figure 1

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

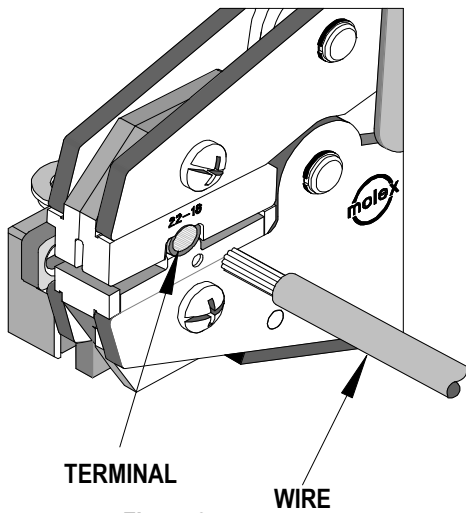


Figure 2

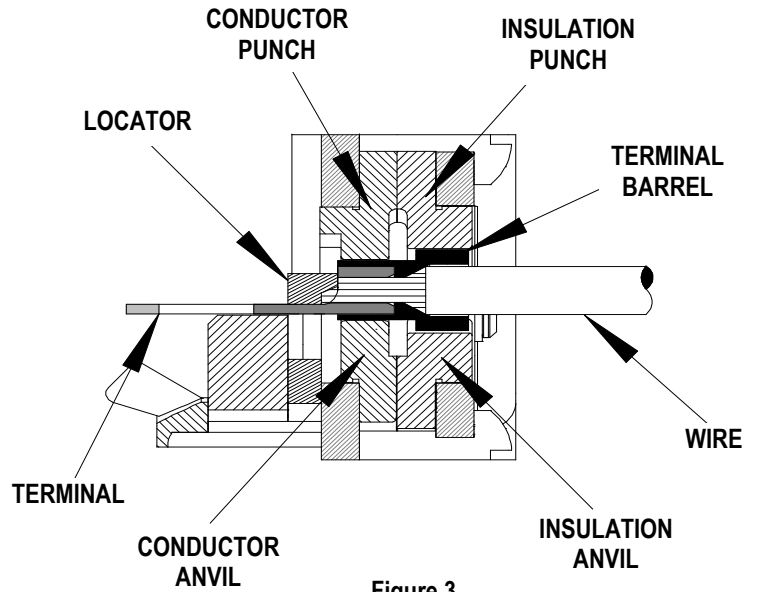


Figure 3

4. Lift the locator blade or wire stop and remove the crimped terminal. Inspect for proper crimp location, and check for insulation closure. Locator is adjustable up and down to keep terminals straight after crimping.
5. If the insulation part of the crimp needs to be adjusted, first loosen the M4 screw on the bottom tool jaw, then insert a 3/32 hex wrench (supplied) into the bottom of the lower die. See Figure 4. A clockwise (CW) rotation decreases insulation crimp while a counter-clockwise (CCW) rotation increases insulation crimp. After adjusting retighten the M4 screw.

**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.

## 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. This tool was engineered for durability, but like any fine piece of equipment it needs cleaning and lubrication for a maximum service life of trouble-free crimping. A light oil, such as 30 weight automotive oil used at the oil points shown in Figure 4, every 5,000 crimps or 3 months will significantly enhance the tool life and ensure a stable calibration.
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.

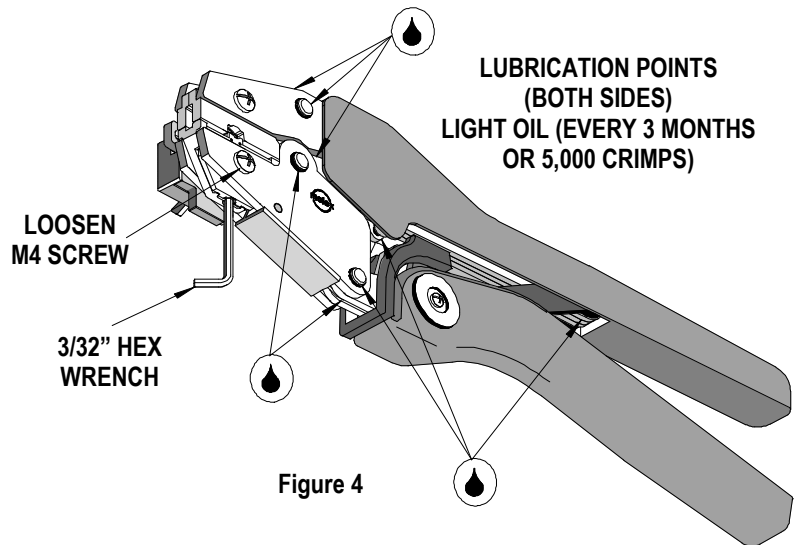


Figure 4

## 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 5.

## How to Adjust Tool Preload (See Figure 5)

Over the life of the tool, it may be necessary 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:

1. 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.

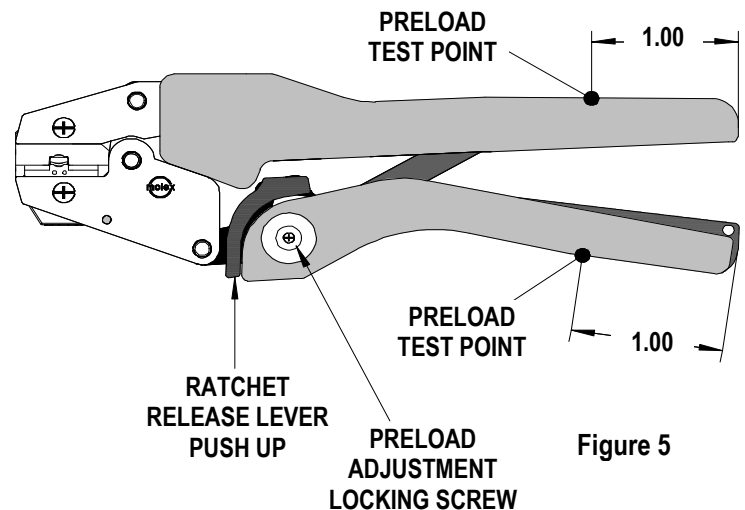
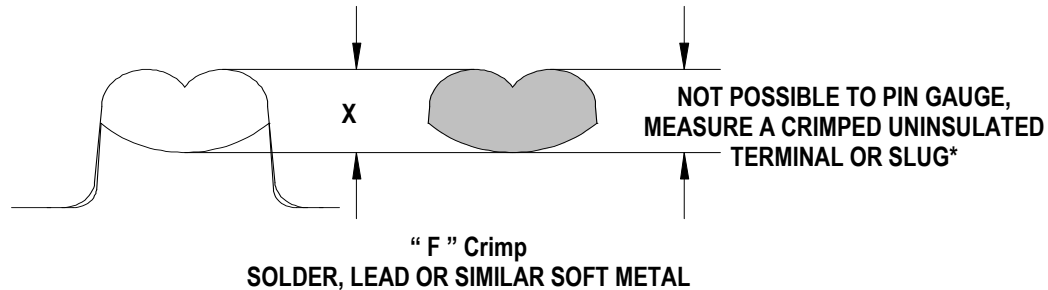


Figure 5

### Tool Calibration

A Certificate of Calibration (See Last Page) was supplied with the tool. To recalibrate this Tool, a soft metal slug or solder should be crimped in the conductor nest and the “X” Dimension measured and compared to this chart. The tool should be lubricated before recalibration to ensure consistent measurements. Handle preload is factory set to 25-45 LBS. See **How to Adjust Tool Preload** and Figure 5 to recalibrate.



Nest Color Code	Wire Range		“X” Dimension Conductor Crimp			Crimp Inspection Marking
	AWG	mm <sup>2</sup>	Mean	Go	No Go	
Red	18 - 22	0.35 - 0.80	.084	.081	.092	N/A

### Warranty

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

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.

**PARTS LIST**

Item	Order No	Description	Quantity
	<b>64001-6700</b>	<b>Hand Crimp Tool</b>	<b>Figure 6</b>
1	64000-0076	Repair Kit (Springs, Pins and E-Rings)	1
2	63810-0000	Handle	1
3	64007-0375	Locator Assembly	1
4	64001-6770	Tooling Kit	1
<b>Tooling Kit Only</b>			
5	64001-6702	Conductor Punch	1
6	64001-6701	Conductor Anvil	1
7	64001-6704	Insulation Punch	1
8	64001-6703	Insulation Anvil	1
9	N/A	4 mm Diameter by 5.0mm Long Roll Pins	2**
10	N/A	#10-32 by 5/16" Long Cup Pt. Set Screw	1**
** Available from an Industrial supply company such as MSC (1-800-645-7270).			

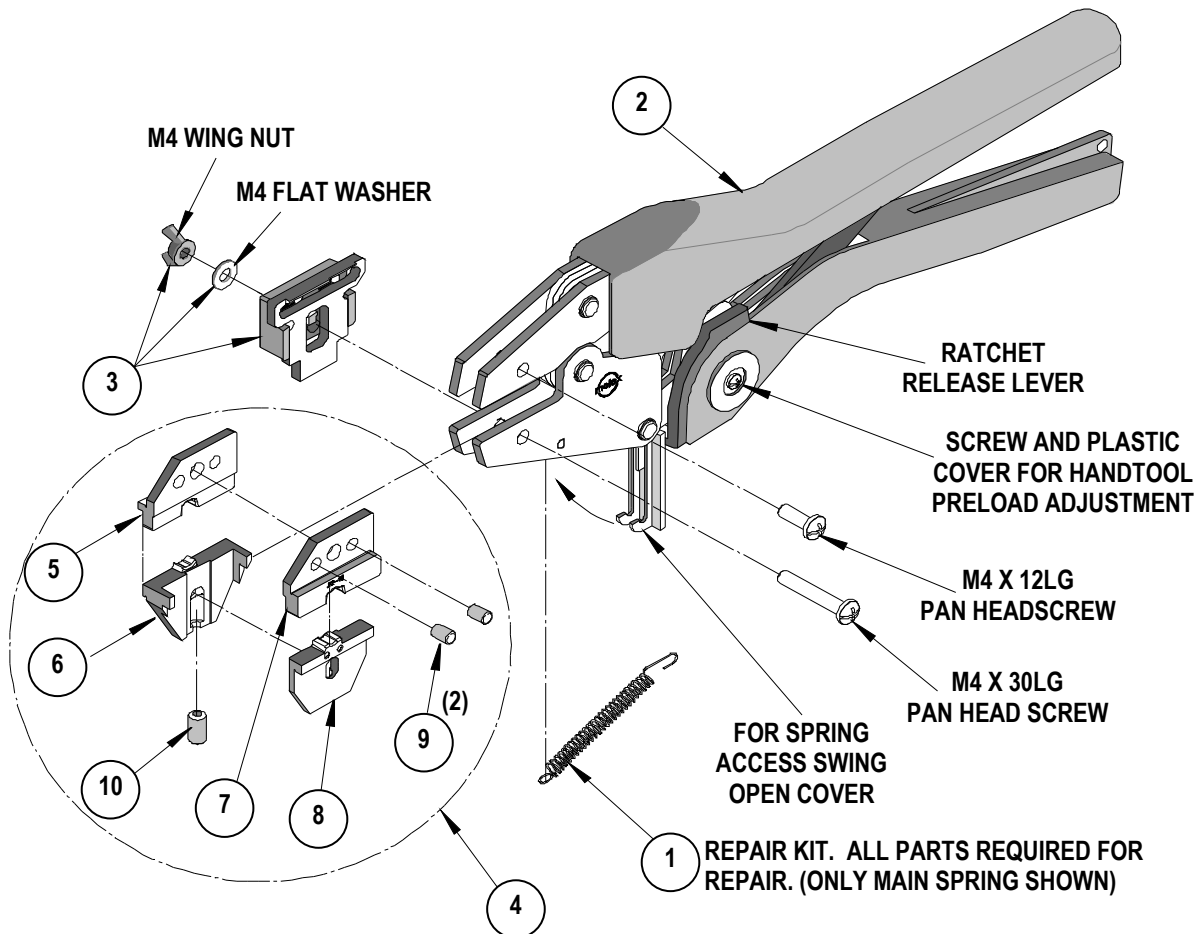
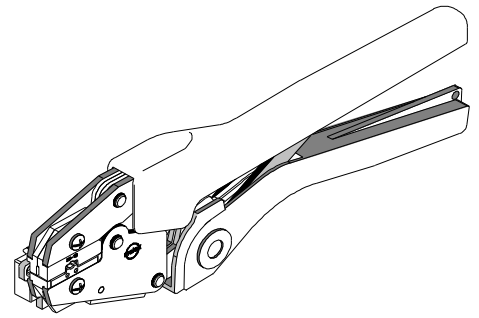


Figure 6



**Certificate of Calibration**

Tool Order Number \_\_\_\_\_

Tool Eng. Number \_\_\_\_\_

Tool Revision \_\_\_\_\_

Serial Number \_\_\_\_\_

Date of Manufacture \_\_\_\_\_

Handle Load Range at 1 inch from the Tips = \_\_\_\_\_

Actual = \_\_\_\_\_

Pin Gauge of Conductor Nest/Nests or Slug height if the nest is the "F" Crimp style.

Range Conductor Nest # 1 = \_\_\_\_\_ -- Actual = \_\_\_\_\_

Technician \_\_\_\_\_

Date of Calibration \_\_\_\_\_

Calibration should be done every 5,000 cycles or 3 months.  
Tools should be lubricated during this operation.

<http://www.molex.com>