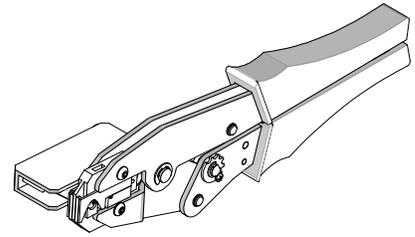


**Micro-D
HAND CRIMP
TOOL**



**Application Tooling
Specification Sheet**



Order No. 62100-0900

FEATURES

- Ratchet with safety release that ensures consistent performance
- Small handle spread which make this style tool ideally suited for end users

SCOPE

Products: 1.27mm Pitch Commercial Micro-D, Cable Receptacle Kit, 9 Circuits.

The following is a partial list of the product order numbers and their specifications that this tool is designed to run. Updates to this list are available on www.molex.com.

Back Shell	Cable Outer Diameter		Micro-D Subassembly Order No.
	mm	In	
83015-0004	5.72	.225	83421-9014

Description

This tool is designed to perform the final crimp operation on a Micro-D cable assembly. It crimps the Micro -D Subassembly onto the contact and terminal assembly.

Note: The contacts must first be crimped to the cable conductors using the crimp hand tool order no. 63811-4800 or the FineAdjust applicator order no. 63862-2000.

This hand tool measures 244mm (9.60 in.) by 173mm (6.81 in.) open by 20mm (.79 in.) and weighs 0.55kg (1.22 lbs.)

Cable Preparation

Before the Micro-D Backshell can be crimped onto the cable and insulator assembly the cable must be prepared as follows:

Step 1

1. Slide the rubber boot over the cable jacket.
2. Slide a crimp ring over the cable jacket.
3. Braided shield folds back over crimp ring.

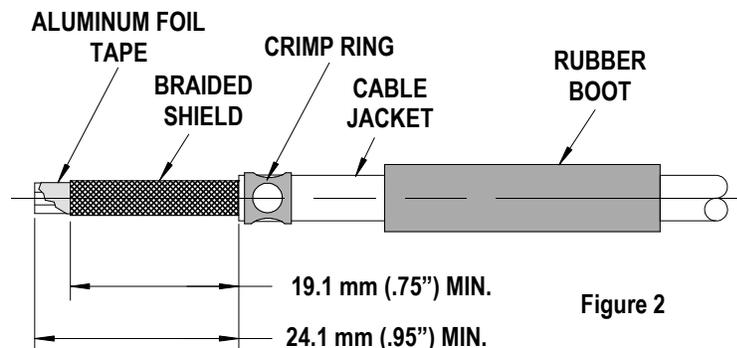


Figure 2

- Trim the cable jacket and braided shield to the dimensions shown in Figure 2.

Step 2

- Slide the crimp ring up to the end of the cable jacket.
- Fold the braid back over the crimp ring, distribute evenly, and place adhesive tape 360° around it.
- Trim the aluminum foil and the fillers back to the braided shield.
- Strip the inner and outer insulation of the conductors to dimensions shown in Figure 3.
- Crimp the contacts as shown and load into insulator.
- Load the insulator into the Backshell Sub-Assembly and crimp.

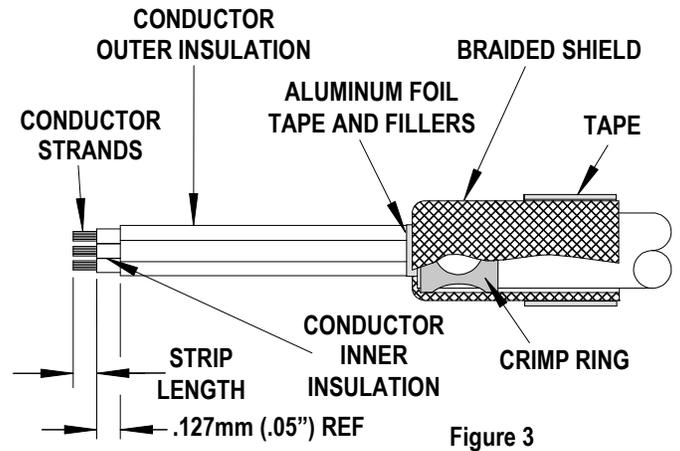


Figure 3

OPERATION

Loading the Back Shell

- Open the Backshell Sub-Assembly by pivoting one half as shown in Figure 4.
- Install the completed insulator and cable assembly into the Backshell. Make sure the holes in the crimp ring will be aligned with the dimples in the Backshell when the Backshell is closed.
- Fold the Backshell halves closed making sure the holes and dimples align.

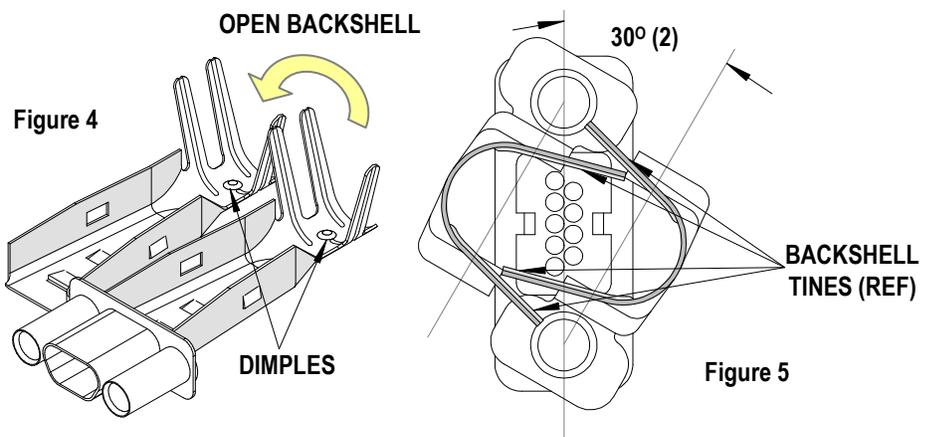


Figure 4

Figure 5

CAUTION: In order to prevent the crimp tines from tangling and becoming bent or damaged, it is necessary to rotate the both halves of the Backshell Sub-Assembly approximately 30° to allow simultaneous closing without tine interference. After closing it is recommended that the tines be closed by hand to parallel for easier crimping. See Figure 5.

Note:

There is a wall in the front of the crimp tool. See Figure 6. This secures the tines in place while crimping. If the back shell and cable assembly is put in the hand tool backwards this wall will damage the Backshell.

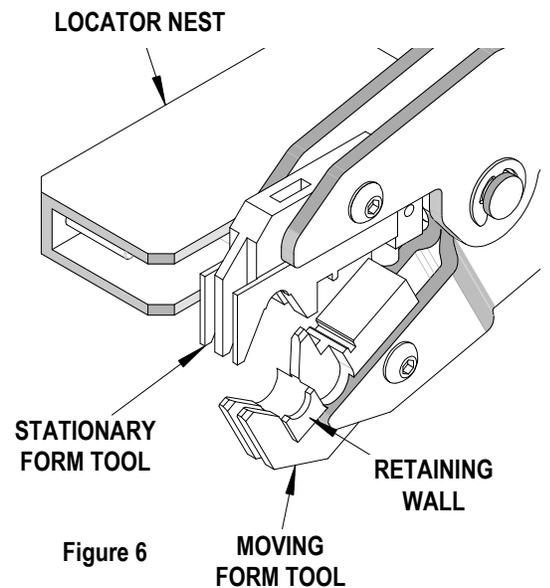


Figure 6

Crimping the Backshell

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. Push the backshell with the cable assembly through the hand tool until the holes on the flat end of the backshell is over the 2 pins of the locating nest. The tines should be over the tooling nest. See Figure 7.

CAUTION: Make sure the cable assembly is pushed all the way forward into the front shell so that it is retained by the backshell after crimping.

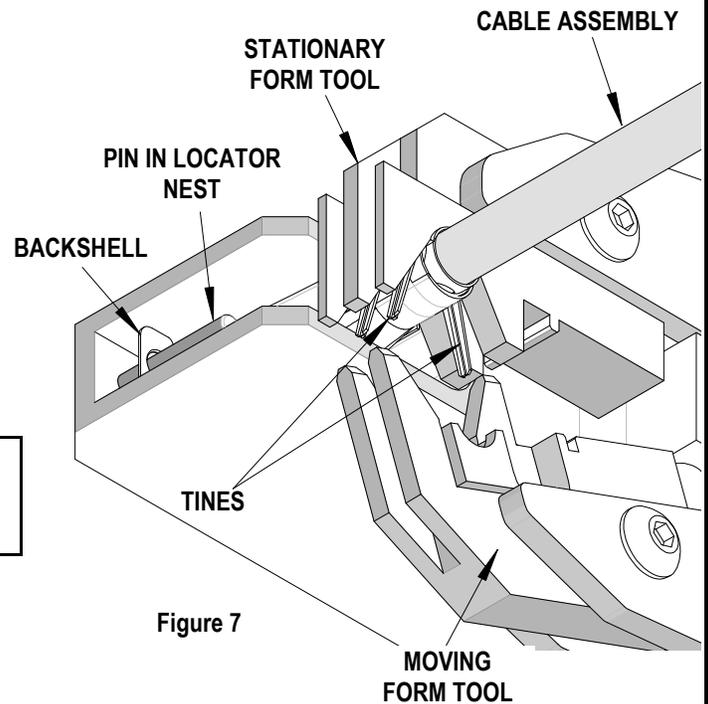


Figure 7

3. While holding the backshell into position, begin squeezing the handles of the hand tool
4. Keep the backshell square with the tooling and make sure the tines stay in the tool. If they come out release the pressure in the hand tool and reposition the backshell.
5. Continue squeezing the handles until the ratchet releases.

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

6. Release the handles and remove the crimped backshell assembly.

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.

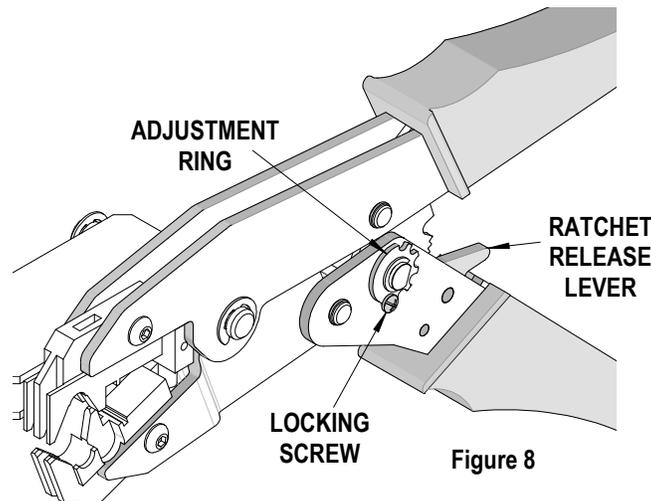
Miscrimps or Jams

Should this tool ever become stuck or jammed in a partially closed position, **Do Not force the handles open or closed.** The tool will open easily by lifting the ratchet release lever. See Figure 8.

How to Adjust Tool Crimp Force (See Figure 8)

It may be necessary over the life of the tool to adjust tool-crimping force. The pre load is the handle force required to release the anti-backup ratchet when the tool is closed without performing a crimp. The pre load should be 35-40lbs (16-18kg). Listed below are the steps required to adjust the crimping force of the hand tool to obtain proper crimp conditions:

1. Remove the locking screw. Located over the adjustment ring.
2. Lift the adjusting ring slightly, off the locating pin.
3. Turn the adjusting ring in the desired direction (+ = less force, - = more force) to increase or decrease crimp pressure.
4. Press the adjusting wheel flat against the tool and engage the locking pin.
5. Replace the locking screw. Check the crimp specifications after tool crimp force is adjusted.



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 free of manufacturing defects for a period of **30 days**. Should such a defect occur, we would exchange the tool free of charge. This 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: Molex crimp specifications are valid only when used with Molex tooling.

PARTS LIST

Micro-D Crimp Hand Tool 62100-0900				
Item No.	Order No.	Engineering No.	Description	Quantity
Perishable Tooling				
1	62100-0901	62100-0901	Moving Form Tool	1
2	62100-0902	62100-0902	Stationary Form Tool	1
Other Components				
3	62100-0903	62100-0903	Connector Locating Nest	1
4	62100-0904	62100-0904	Locating Nest Pivot	1
5	63600-0572	63600-0572	Ideal Crimp Master Tool	1
6	63700-1320	63700-1320	External Retaining Ring	4
7	63700-1495	63700-1495	Compression Spring	1
Hardware				
8	N/A	N/A	M2.5 by 20 long Dowel Pin	2**
9	N/A	N/A	M4 by 12 Long BHCS	2**

** Available from an industrial supply company such as MSC (1-800-645-7270).

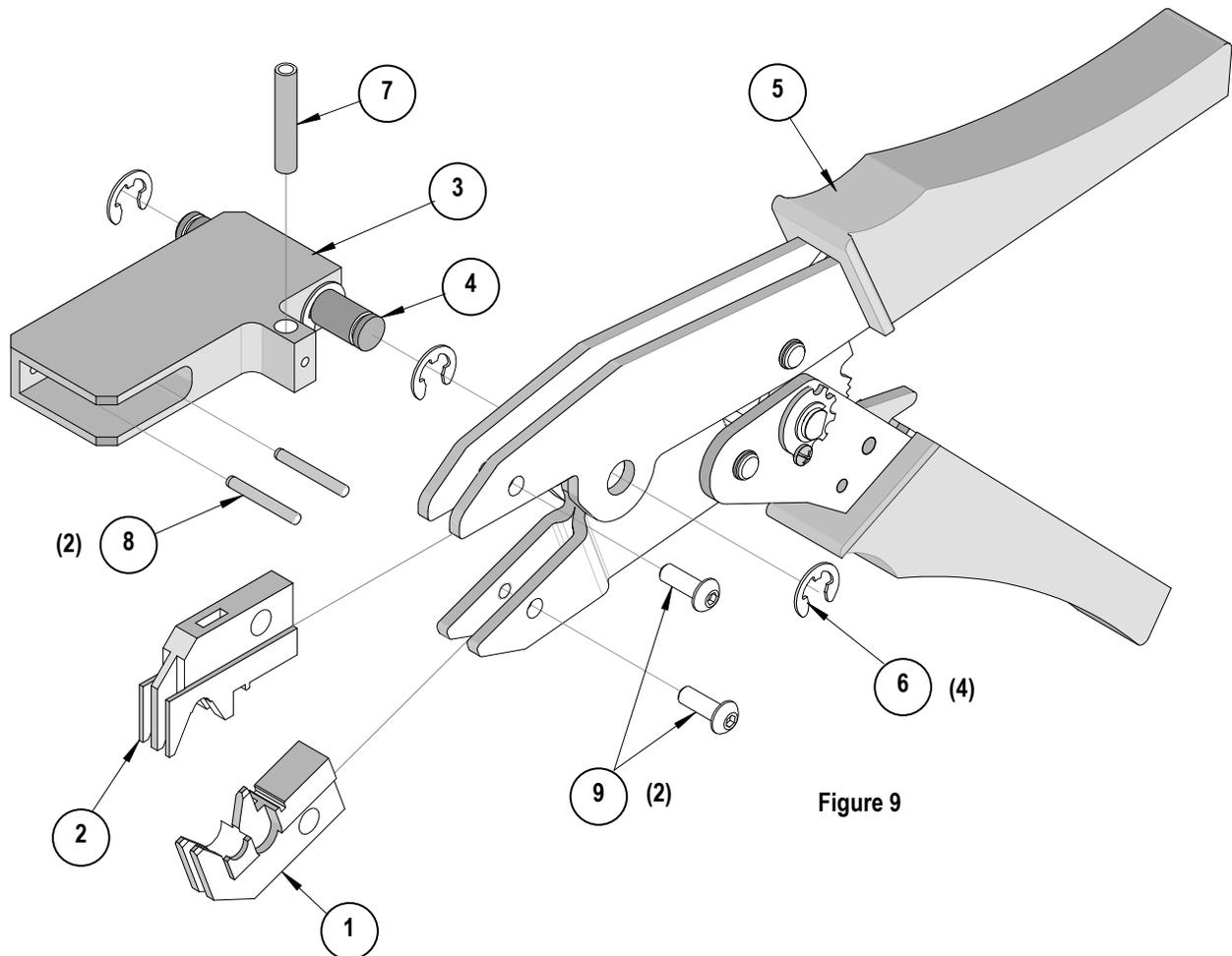


Figure 9

Visit our Web site at <http://www.molex.com>