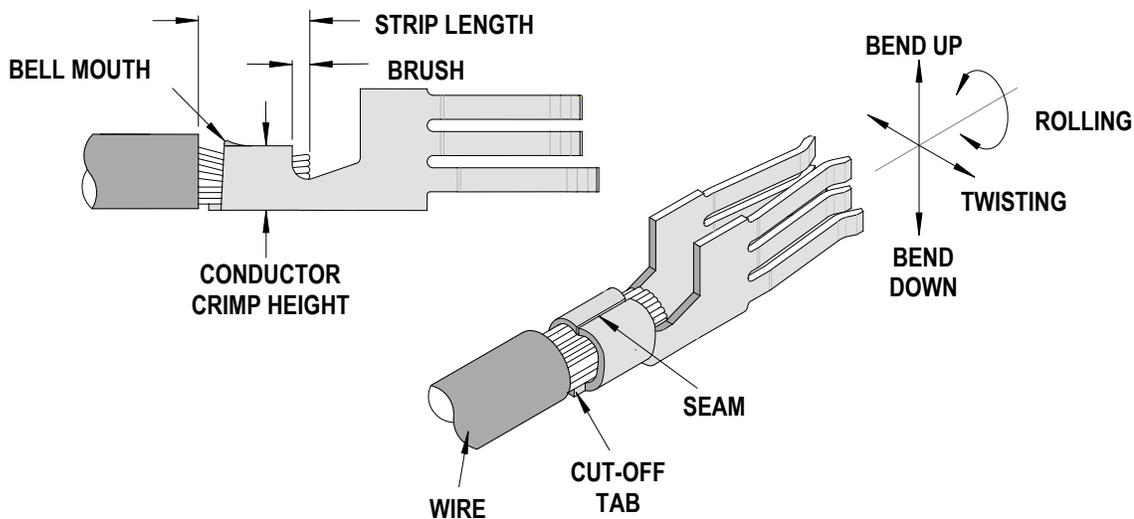| **Modular Crimp Tooling Kit**	**molex®**	
	Application Tooling Specification Sheet	
		Order No. 63827-4070

SCOPE

Tooling: The Square "DIN" style die sets are used with two machines and each machine requires an adapter for the square "DIN" dies. The Molex Pneumatic Universal Crimp Machine UP 60 Order Number 63801-8900 will process the square "DIN" style die sets with the 63801-8901 Crimp Adapter. The Molex 12 Ton Battery Powered Crimping Tool, Order Number 63816-1000 will process the square "DIN" style die sets with the 63816-1100 Power Crimp Head. Refer to the appropriate Operation manual for installation and operation information, TM-638018900 or TM-638161000.

Products: Guardian Power Receptacle Terminals, 6 AWG UL1028 or UL1283.

Terminal Series No.	Terminal Order No. (1) Reel Form Only	Wire Size		Insulation Diameter Maximum (2)		Strip Length	
		AWG	mm²	mm	In.	mm	In.
46819	46819-0013	6	13.30	8.70	.343	8.00-9.00	.315-.354
(1) Customer to cut off terminal from reel: 0.35mm (.014") maximum cut-off tab.							
(2) Overall insulation OD specification for terminal.							

DEFINITION OF TERMS

CRIMP SPECIFICATION

Terminal Series No.	Bell mouth		Conductor Brush	
	mm	In.	mm	In.
46819	0.25-1.25	.010-.049	1.00-2.50	.039-.098

Terminal Series No.	Bend up Bend down		Twist Roll		Seam
	Degree		Degree		Seam shall not be open and no wire allowed out of the crimping area
46819	3	3	3	3	

CONDITIONS:

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

Terminal Series No.	Wire Size		Conductor				Pull Force Minimum	
			Crimp Height		Crimp Width (Ref.)			
	AWG	mm²	mm	In.	mm	In.	N	Lb.
46819	6	13.30	3.95-4.05	.155-.159	7.20	.283	951.9	214.00

The chart below shows all applications for this Modular Crimp Tooling Kit.

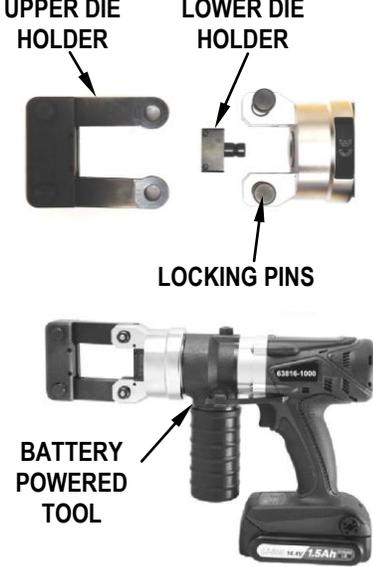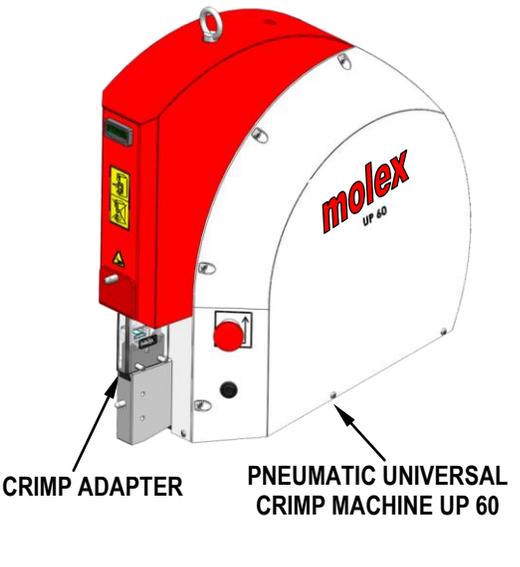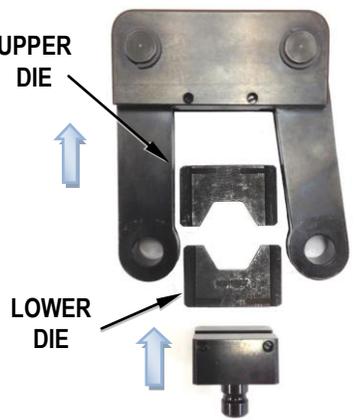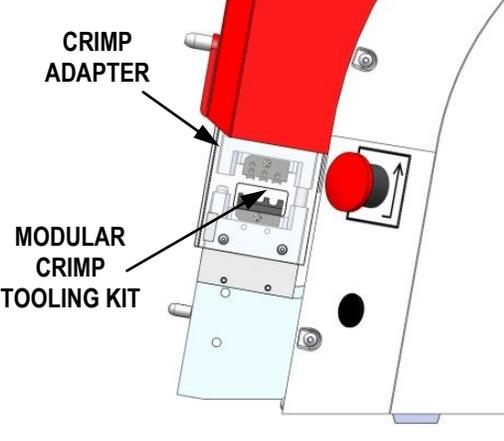| Modular Crimp Tooling Kit Order No.	Tool Order no.	Tool Description	Adapter Order No.	Adapter Description	Figure No.
63827-4070	63816-1000	Battery Power Crimping Tool	63816-1100	Power Crimp Head For DIN Style Dies	1
	63801-8900	Pneumatic Universal Crimp Machine UP60	63801-8901	Crimp Die Adapter For DIN Style Dies	2

Note:

The individual Modular Crimp Tooling Kit is ordered separately from the Battery Powered Crimping Tool and Pneumatic Universal Crimp Machine UP 60.

WARNING: *NEVER* operate, service, install, or adjust this Modular Crimp Tooling Kit 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.

Applications for the Modular Crimp Tooling Kit	
Battery Powered Tool	**Pneumatic Universal Crimp Machine UP 60**
UPPER DIE HOLDER LOWER DIE HOLDER LOCKING PINS BATTERY POWERED TOOL 63816-1000	molex UP 60 CRIMP ADAPTER PNEUMATIC UNIVERSAL CRIMP MACHINE UP 60
UPPER DIE LOWER DIE	CRIMP ADAPTER MODULAR CRIMP TOOLING KIT
Figure 1	**Figure 2**

Parts List

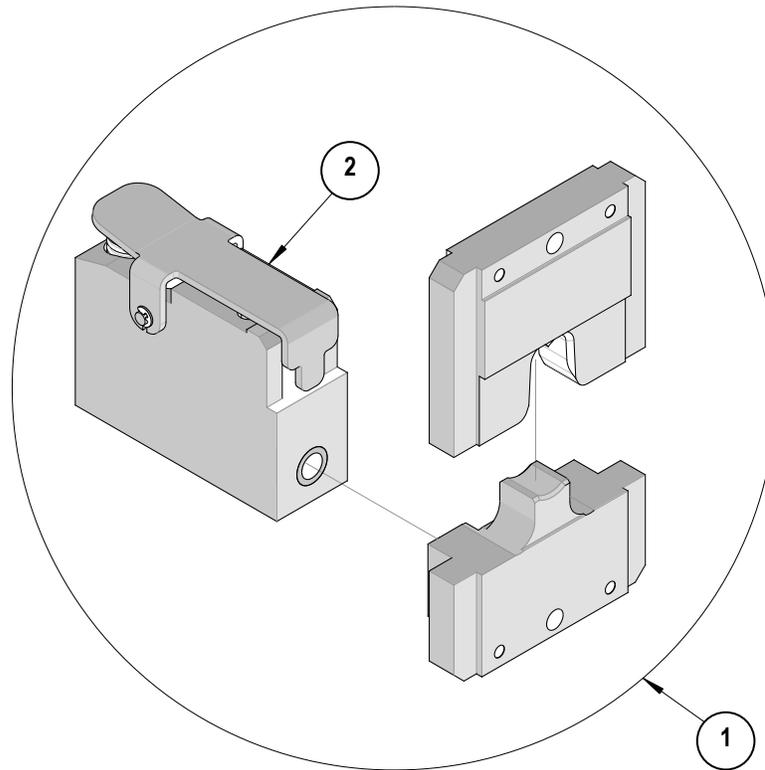| Item Number	Order Number	Description	Quantity
1	63827-4070	Modular Crimp Tooling Kit	1
2	63827-4075	Locator with Wire Stop	REF

Figure 1

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