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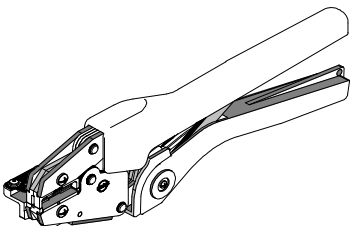
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Molex Connector Corporation
0640011000

For any questions, you can email us directly:
sales@integrated-circuit.com

RHT 5758-CC Hand Crimp Tool

Hand Crimp Tool InsulKrimp™	molex® Application Tooling Specification Sheet	Order No. 64001-1000 Engineering No. RHT 5758-CC

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
- Single color-coded crimp pocket eliminates the possibility of using the wrong pocket

SCOPE

Products: InsulKrimp™ Fully Insulated Quick Disconnect and, Perma-Seal™ Fully Insulated Quick Disconnect Conductor Crimp only 14–16 AWG.

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 specifications for various wire sizes. The tensile strength is shown in pounds and indicates the minimum acceptable force to break or separate the terminal from the conductor.

Wire Size (AWG)	*UL - 310
16	30
14	50

*UL – 310 – Quick Disconnects

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.

Wire Size: 14-16 AWG 2.00-1.30mm²							
Terminal No.	Terminal Eng No. (REF)	Terminal No. Mylar Tape	Terminal No. Molded Strip	Wire Strip Length		Insulation Diameter Maximum	
				In	mm	In	mm
19003-0040	BB-2206	19003-0042	19003-0041	0.25	6.35	0.16	4.06
19003-0044	BB-2206VB	19003-0080	19003-0045	0.25	6.35	0.16	4.06
19003-0047	BB-2206X	19003-0049	19003-0048	0.25	6.35	0.26	6.60
19003-0050	BB-2207	19003-0052	19003-0051	0.25	6.35	0.26	6.60
19003-0053	BB-2207X	19003-0055	19003-0054	0.25	6.35	0.26	6.60
19003-0056	BB-2208	19003-0058	19003-0057	0.25	6.35	0.16	4.06
19003-0059	BB-2208X	19003-0061	19003-0060	0.25	6.35	0.26	6.60
19003-0062	BB-2215	19003-0077	19003-0085	0.25	6.35	0.16	4.06
19003-0063	BB-2216	19003-0078	19003-0086	0.25	6.35	0.16	4.06
19003-0132	BB-2207V	19003-0133	19003-0134	0.25	6.35	0.16	4.06
19003-0135	BB-2208V	19003-0136	19003-0137	0.25	6.35	0.16	4.06

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Terminal No.	Terminal Eng No. (REF)	Terminal No. Mylar Tape	Terminal No. Molded Strip	Wire Strip Length		Insulation Diameter Maximum	
				In	mm	In	mm
19023-0056	19023-0056	19023-0054	19023-0055	0.25	6.35	0.16	4.06
19164-0047	SBB-2141	N/A	N/A	0.20	5.16	0.24	6.10
19276-0005	BB-2206-LIF	N/A	N/A	0.25	6.35	0.16	4.06

OPERATION

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

Crimping Terminals

1. There are 3 tab locator blades supplied with the tool. One is for .187 and .250 tabs; another is for .205 tabs and .110 tabs and another is for LIF terminals. Make sure the proper blade is installed on the top of the locator and the other is stored on the bottom of the locator.
2. Push the terminal onto the tab locator all the way to the stop in the color-coded nest. The barrel of the terminal should be up. See Figure 1.
3. Partially close the tool to hold the terminal in place. See Figure 2.
4. Insert the properly stripped wire into the terminal barrel. See Figure 2 and 3. Cycle the tool.
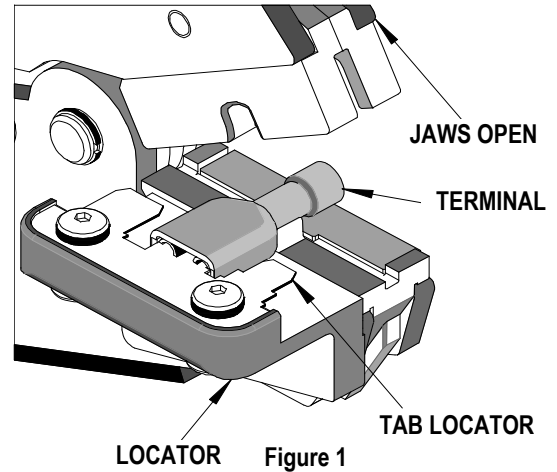
Figure 1

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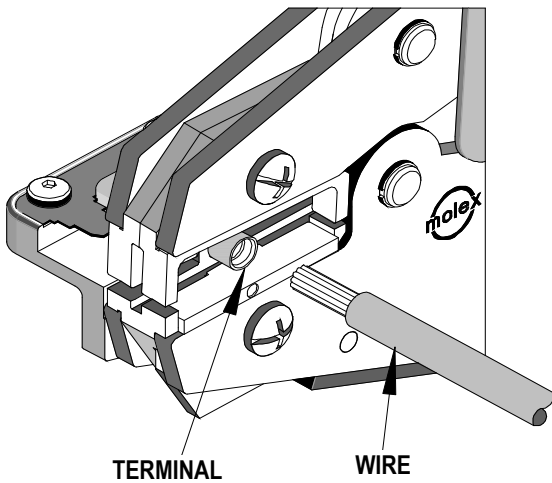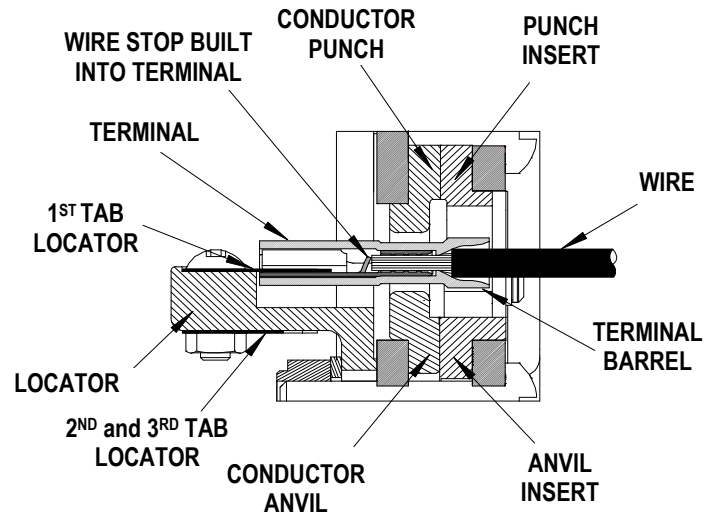

Figure 2

Figure 3

5. Remove the crimp and inspect for proper crimp location. Molex offers a Crimp Inspection Handbook for closed barrel industrial product. See our website or contact your sales engineer.

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.

Distributor of Molex Connector Corporation: Excellent Integrated System Limited
Datasheet of 0640011000 - TOOL CRIMP 14-16AWG .187 & .250
Contact us: sales@integrated-circuit.com Website: www.integrated-circuit.com

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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 pin, 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, can be 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.
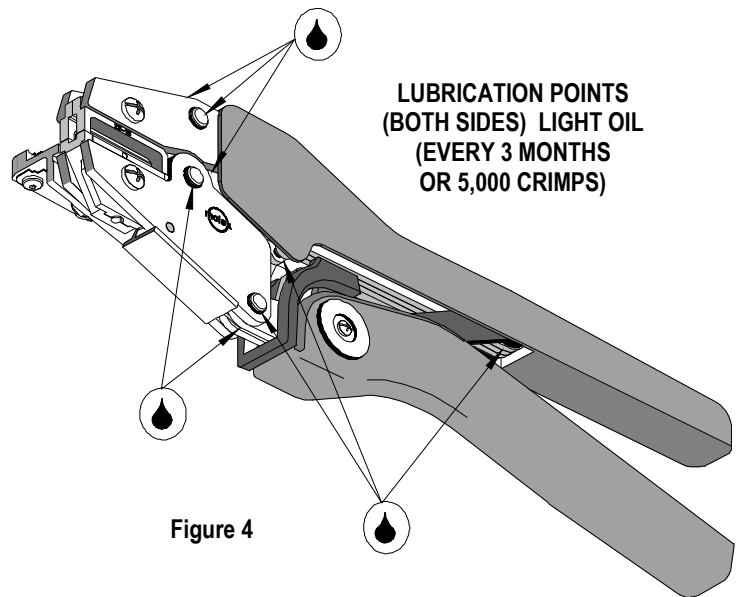
**LUBRICATION POINTS
(BOTH SIDES) LIGHT OIL
(EVERY 3 MONTHS
OR 5,000 CRIMPS)**

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 pressing 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 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.
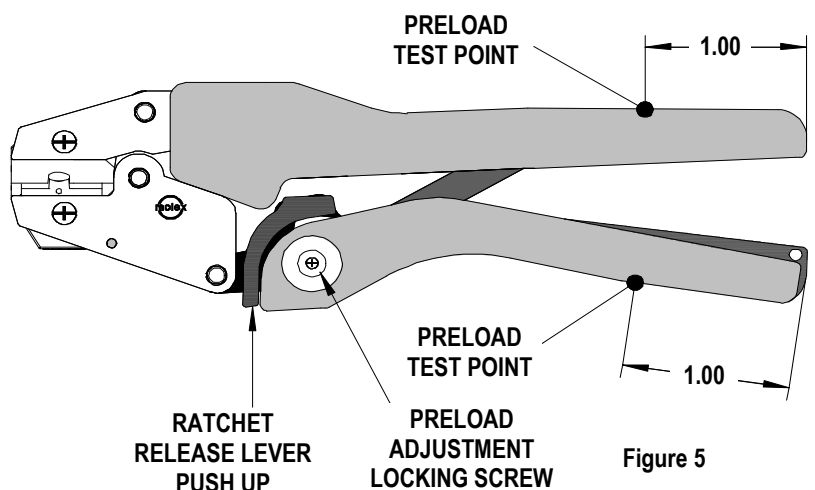6. Check the crimp specifications after tool crimp force is adjusted.

**PRELOAD
TEST POINT**

1.00

**PRELOAD
TEST POINT**

1.00

**RATCHET
RELEASE LEVER
PUSH UP**

**PRELOAD
ADJUSTMENT
LOCKING SCREW**

**PRELOAD
ADJUSTMENT
LOCKING SCREW**

Figure 5

RHT 5758-CC Hand Crimp Tool

Tool Calibration

A Certificate of Calibration (see last page) was supplied with the tool. To recalibrate this tool, pin gauge measurements should be taken in each conductor nest and compared to this chart. The tool should be lubricated prior to recalibration to ensure consistent measurements. Handle preload is factory set to 25-45 LBS. See How to Adjust Tool Preload (See Figure 5) to recalibrate.

PIN GAUGE IN CONDUCTOR CRIMP

X

" Confining " Crimp
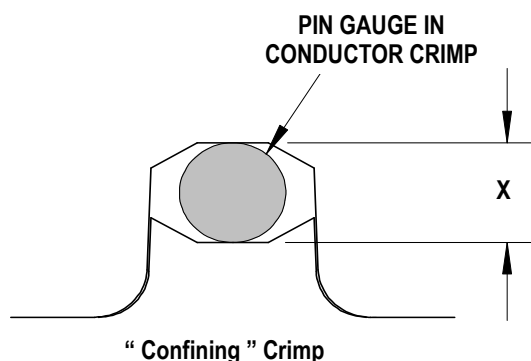
Nest Color Code	Wire Range		"X" Dimension Conductor Crimp			Crimp Inspection Marking
	AWG	mm²	Mean	Go	No Go	
Blue	14 - 16	1.30 - 2.00	.094	.091	.098	o

Warranty

> **Caution:** Repetitive use of this tool should be avoided.

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

RHT 5758-CC Hand Crimp Tool

PARTS LIST

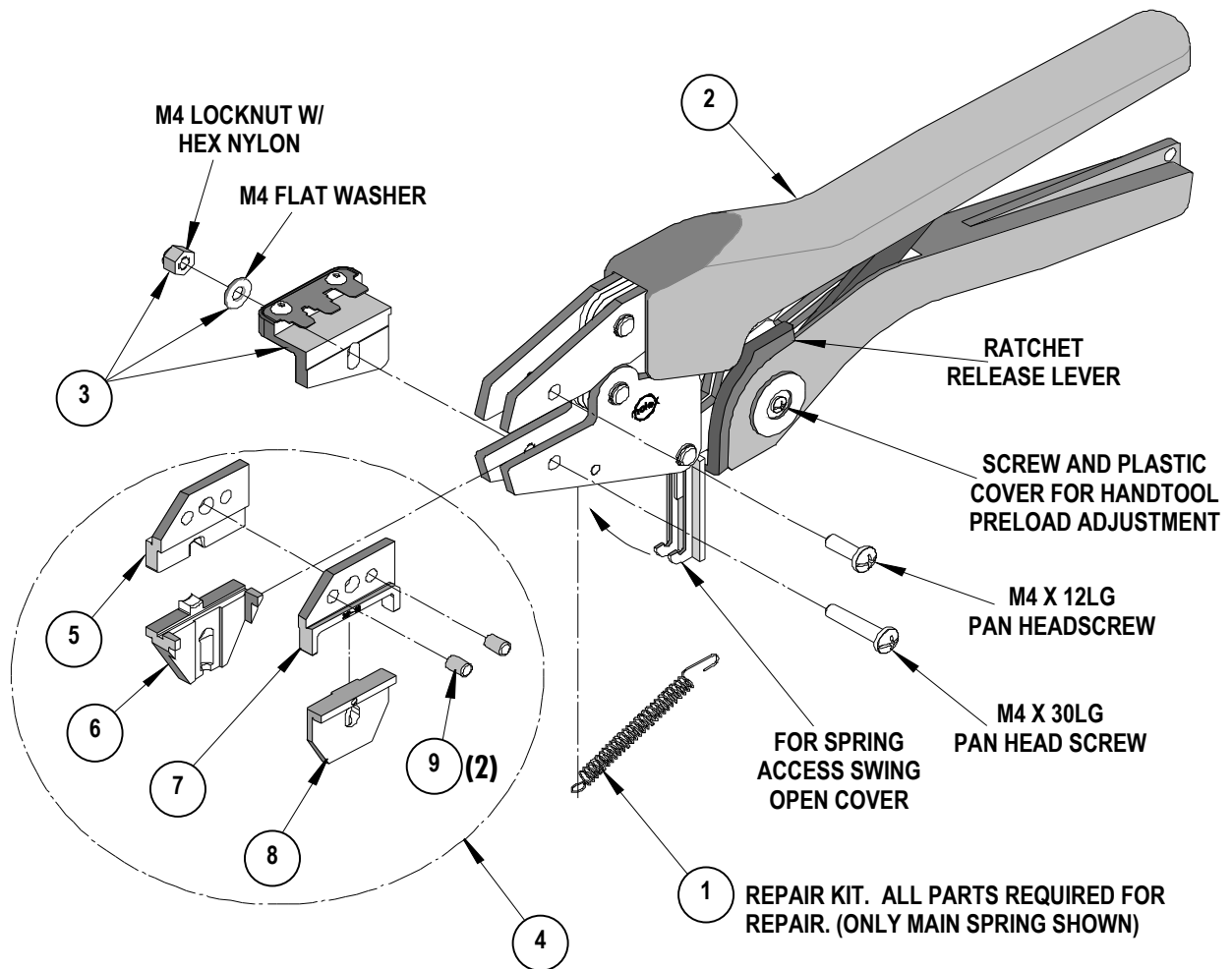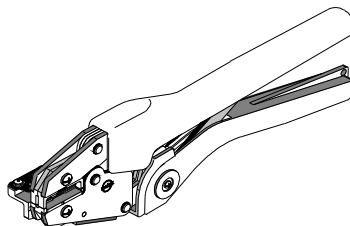| Item	Order No	Description	Quantity
	64001-1000	**Hand Crimp Tool**	**Figure 6**
1	64000-0076	Repair Kit (Springs, Pins and E-Rings)	1
2	63810-0000	Handle	1
3	64001-0475	Locator Assembly	1
4	64001-1070	Tooling Kit	1
		Tooling Kit Only	
5	64001-1001	Conductor Punch	1
6	64001-1002	Conductor Anvil	1
7	64001-1012	Insert Punch	1
8	64001-0011	Insert Anvil	1
9	N/A	4mm Diameter by 5.0mm LongRoll Pins	2**
** The following purchased parts are available from an Industrial supply company such as MSC (1-800-645-7270).			

M4 LOCKNUT W/ HEX NYLON

M4 FLAT WASHER

RATCHET RELEASE LEVER

SCREW AND PLASTIC COVER FOR HANDTOOL PRELOAD ADJUSTMENT

M4 X 12LG PAN HEADSCREW

M4 X 30LG PAN HEAD SCREW

FOR SPRING ACCESS SWING OPEN COVER

REPAIR KIT. ALL PARTS REQUIRED FOR REPAIR. (ONLY MAIN SPRING SHOWN)

Figure 6

RHT 5758-CC Hand Crimp Tool

Hand Crimp Tool InsulKrimp™	**molex®** **Certificate of Calibration**	**Order No. 64001-1000 Engineering No. RHT 5758-CC**

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

Doc No. ATS-640011000
Revision: D
Release Date: 12-11-02
Revision Date: 01-24-11
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