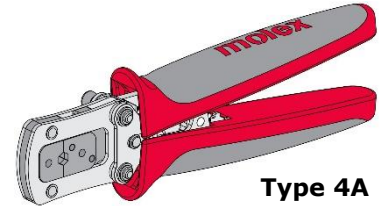


**Order Number
200218-3400**



Application Tooling Specification



FEATURES

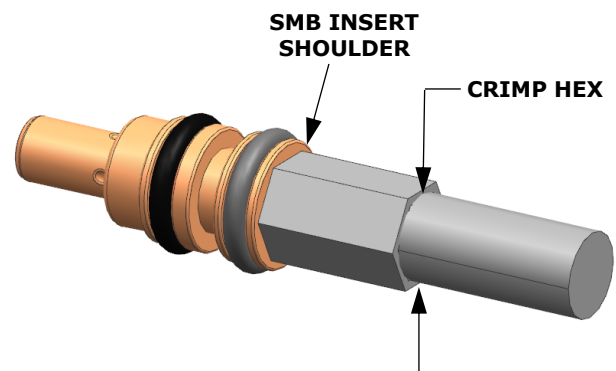
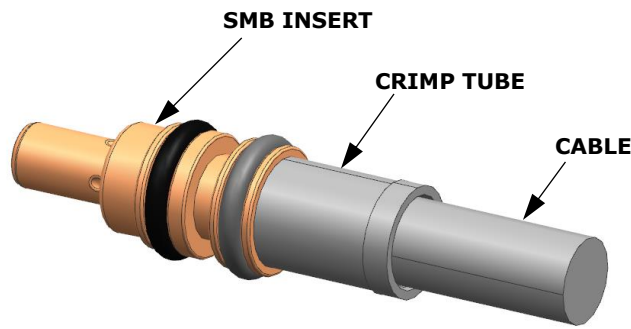
- A full-cycle ratcheting hand tool ensures complete crimps
- Ergonomically designed soft handles
- Easy handling due to outstanding force ratio
- Modular crimp head is removable and can be used in the Electric Crimp Machine (Order No. 63816-1500), accompanied by Battery Powered Crimp Adapter (Order No. 63816-0600)
- Can also be used in the Battery Powered Tool Order No. 63816-0270 (110 V) or 63816-0280 (220 V), accompanied by Battery Powered Crimp Adapter (Order No. 63816-0600)

SCOPE

Products: SMB RG58 Inserts (plug and jack) and crimp tube used in sealed FAKRA connectors.

Component Series No.	Component Order No.	Component Type	Applicable RG58 Cables	
73404	73404-3290	Jack Insert	LEONI DACAR 037	COMDUMEX 800315-49
73404	73404-3370	Plug Insert		
89558	89558-7990	Crimp Tube		
	89558-7991			
	89558-7992			

DEFINITION OF TERMS



CRIMP SPECIFICATION

After crimping, the crimp hex should measure as follows:

Insert Series No.	Crimp Tube Series No.	Crimp Hex	
		mm	In.
73404	89558	5.33-5.49	.210-.216

Notes

1. This tool should be used only with the products and cables specified in this document.
2. Variations in tools, products and cables may affect the crimp hex dimension.
3. Molex does not repair hand tools (see warranty below). The replacement parts listed are the only parts available for repair. If the handles or crimp tooling are damaged or worn, a new tool must be purchased.
4. The crimp hex dimension should be used as the final criterion for an acceptable tube crimp. Pull test requirements are not available.
5. Molex does not certify crimp hand tools.

ASSEMBLY PREPARATION

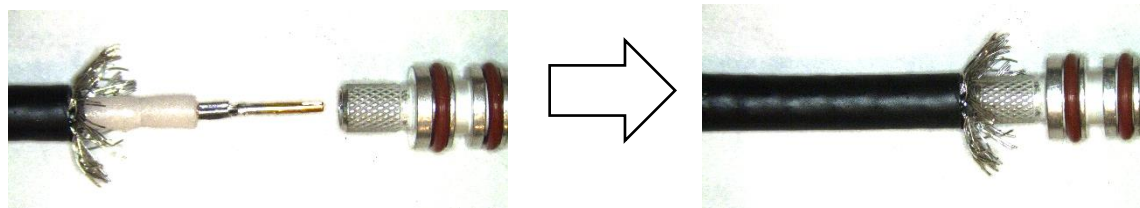
From the terminal crimping operation (hand tool 200218-3300), the FAKRA connector's end cap, cable seal and crimp tube should be loaded on the cable.

Prior to crimping the tube, assemble the connector as follows:

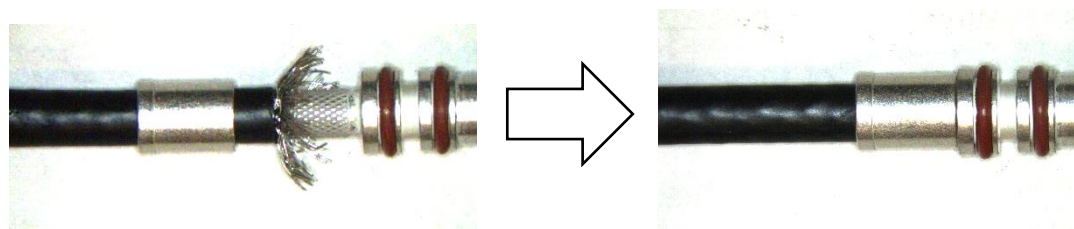
1. Flare open the cable braid and foil.



2. Insert the cable (with crimped terminal) into the SMB insert until it bottoms. Make sure the braid and foil stay on the outside of the insert.



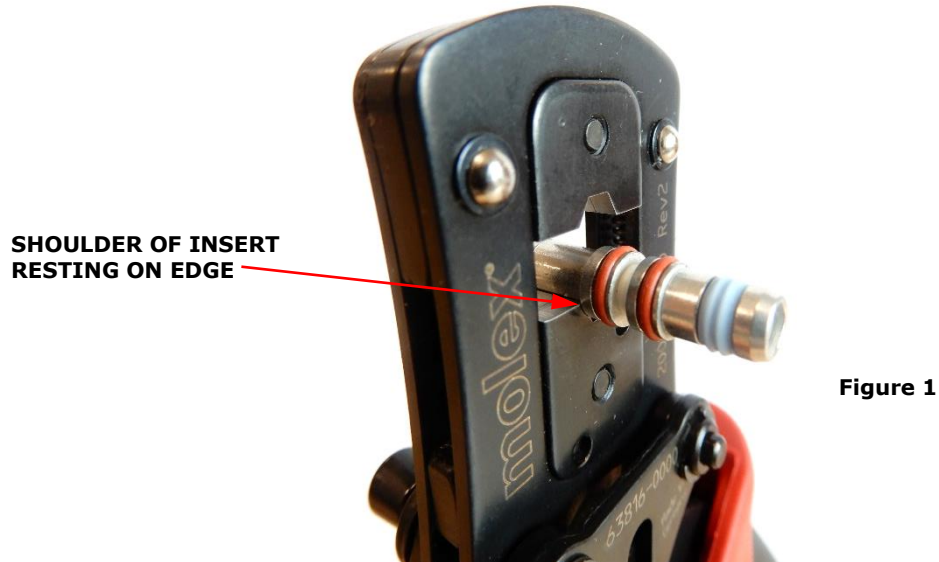
3. Slide the crimp tube over the braid and foil until it bottoms on the insert shoulder.



OPERATION

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.

1. Place the prepared insert assembly into the open crimp profile. The shoulder of the insert should rest on the edge of the profile. See Figure 1.



2. While holding the insert assembly in place, close the tool until the ratchet releases.
3. Release the handles and allow the tool to spring open. Carefully remove the crimped insert.

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 a 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 crimps or 3 months will significantly enhance the tool life.
4. Wipe excess oil from the hand tool, particularly from the crimping area. Oil transferred from the crimping area onto certain terminations may affect the electrical characteristics of an application.
5. When the 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 shut**. The tool will open easily by lifting the ratchet release lever. See Figure 5.

Warranty

This tool is for SMB insert 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, Molex 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 use 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 inserts and crimp tubes specified for this tool.

CAUTION: Molex crimp specifications are valid only when used with Molex products 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.

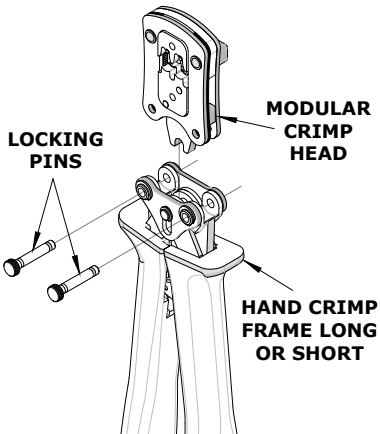
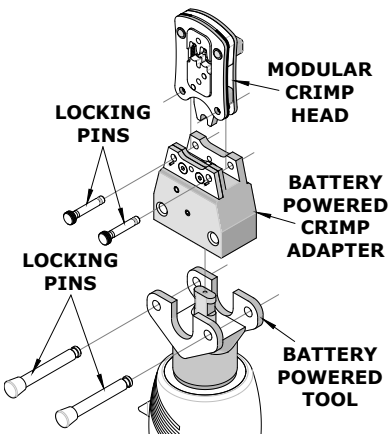
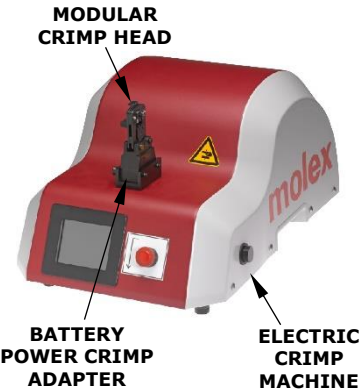
WARNING: NEVER install tooling or service this tool while it is connected to any power source. Disconnect the power by unplugging or by removing the battery.

CAUTION: Keep fingers away from the crimping 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:

Tool Order No.	Tool Description	Adapter Order No.	Adapter Description	Figure No.
63816-0000	Hand Crimp Frame (Short)	—	—	2
63816-0050	Hand Crimp Frame (Long)	—	—	2
63816-0270	Battery Power Tool (110 V)	63816-0600	Battery Power Crimp Adapter	3
63816-0280	Battery Power Tool (220 V)	63816-0600	Battery Power Crimp Adapter	3
63816-1500	Electric Crimp Machine	63816-0600	Battery Power Crimp Adapter	4

Applications for the Modular Crimp Head		
Hand Crimp Tool	Battery Powered Tool	Electric Crimp Machine
 <p>LOCKING PINS</p> <p>MODULAR CRIMP HEAD</p> <p>HAND CRIMP FRAME LONG OR SHORT</p>	 <p>LOCKING PINS</p> <p>MODULAR CRIMP HEAD</p> <p>BATTERY POWERED CRIMP ADAPTER</p> <p>BATTERY POWERED TOOL</p>	 <p>MODULAR CRIMP HEAD</p> <p>BATTERY POWER CRIMP ADAPTER</p> <p>ELECTRIC CRIMP MACHINE</p>
Figure 2	Figure 3	Figure 4

PARTS LIST

Item	Order Number	Description	Quantity
1	63816-0000	Hand Crimp Frame (Short)	1
2	63816-0001	Locking Pin	2
3	63600-0525	Ratchet Spring	1
4	63600-0520	Crimping Spring	2

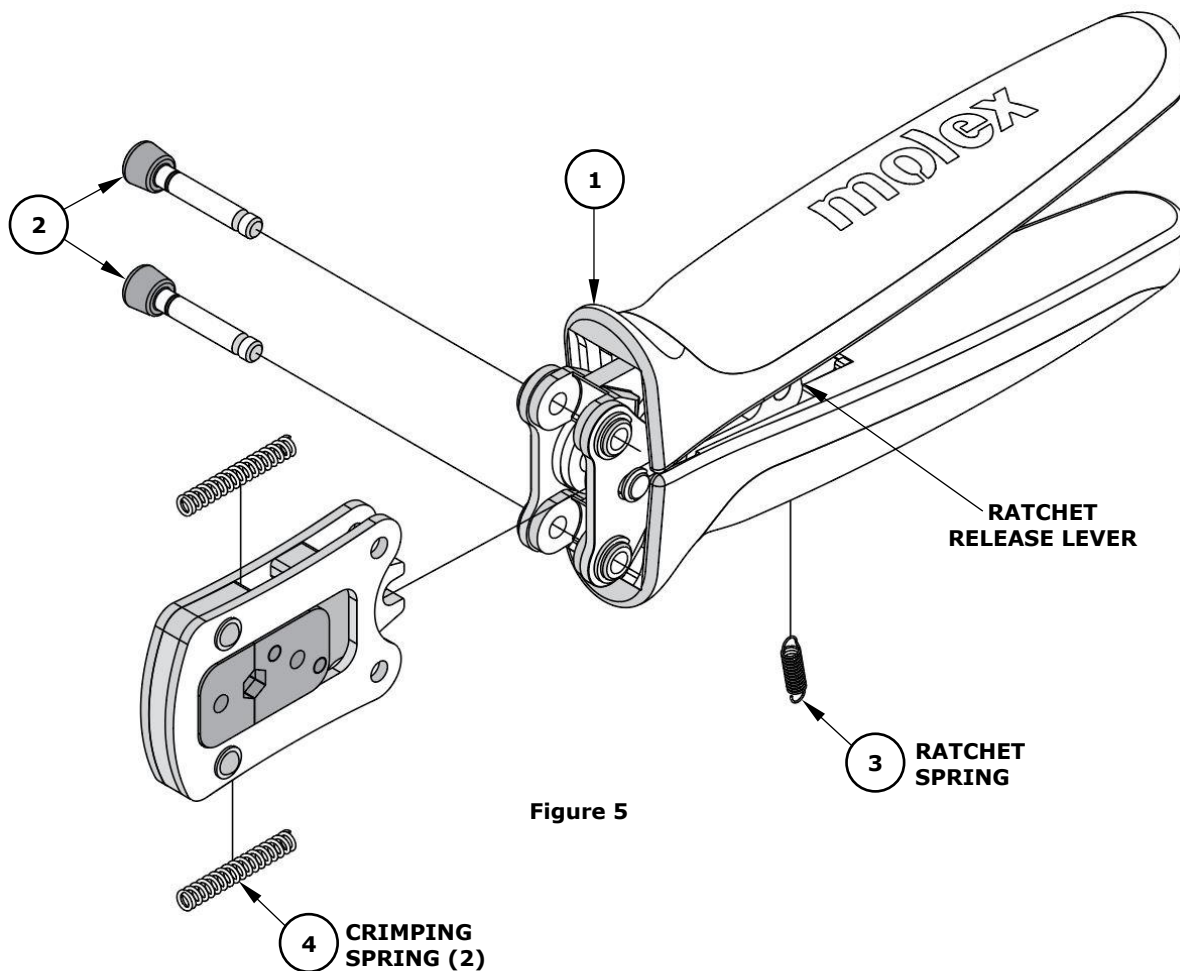


Figure 5

Application Tooling Support

Phone: (402) 458-TOOL (8665)
E-Mail: applicationtooling@molex.com
Website: www.molex.com/applicationtooling

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