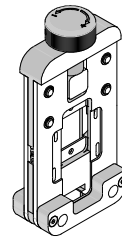




**Type 4D  
Power Crimp Head**

## Application Tooling Specification Sheet



**Order No. 63816-0800**

### Features

- The Quick Change Power Crimp Head is easily installed onto the Battery Power Crimp Tool (Order No. 63816-0200)
- Powered crimp tools help reduce fatigue and discomfort from repetitive manual crimping and allows portability
- A precision user-friendly terminal locator wire stop holds terminals in the proper crimping position

### SCOPE

The 63816-0800 Power Crimp Head was created for use with Type 4D Crimp Dies and Locator when used with the Battery Powered Tool (Order No. 63816-0200).

### Installation

To install the Power Crimp Head onto the Battery Powered Tool, (Order No. 63816-0200), refer to the Instruction Manual TM-638160200, Section 3, "Set-Up and Adjustments".

### Locator Installation and Removal

#### To remove the locator

1. Open the Power Crimp Head to remove the locator.
2. Squeeze gently on the lower area of the locator assembly, shown in Figure 1, with your thumb and index finger. The lower tabs of the locator should disengage from the Power Crimp Head.
3. Lift and pull away from the Power Crimp Head. The top locator hooks should slip out of the top slots easily. See Figure 1.

#### To install the locator

1. Install the locator assembly.
2. Press the red insert down as far as it will go. See Figure 2.
3. The locator goes on the opposite side from the dies with the wire gauge markings.
4. While holding onto the lower part of the locator with your thumb and index finger, insert the locator top hooks (2) into the Power Crimp Head top slots.
5. Rotate the locator down and press the lower tabs into the two bottom slots of the head. To secure the locator into place, the lower tabs must snap into place on the head frame.

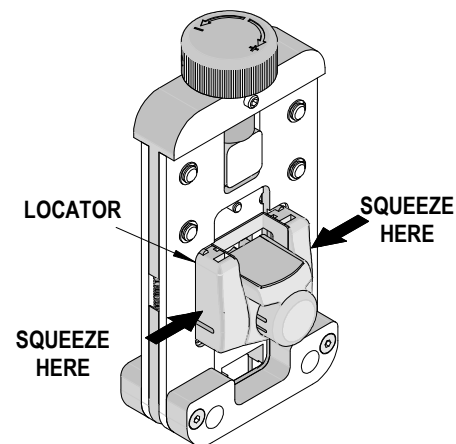
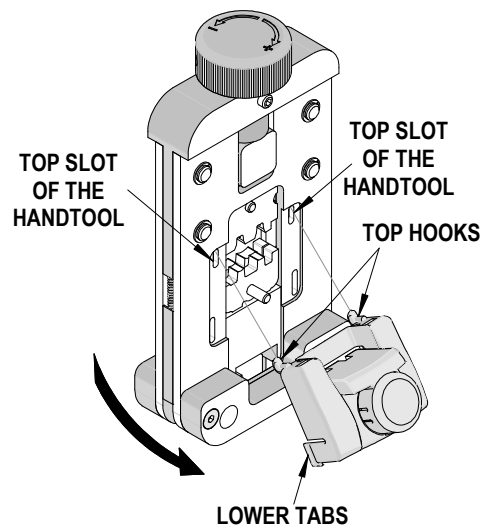


Figure 1



### Removing the Crimp Dies from the Power Crimp Head

1. Open the Power crimp Head.
2. Remove the two M3 BHCS.
3. Remove the crimp dies as shown in Figure 3.
4. Make sure all of components removed from the Power Crimp Head are reinstalled into the Power Crimp Head in the same manner.

### Installing the Crimp Dies in the Power Crimp Head

1. Select the desired crimping dies.
2. Insert the Anvils or dies (E1 and I1) into the bottom slots of the nest. Install the M3 x 14 long BHCS and lightly tighten in place.

MAKE SURE  
CENTER OF LOCATOR  
IS IN THE  
DOWN POSITION

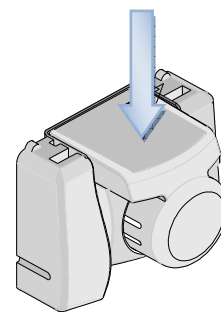


Figure 2

**Note:** The tool part number markings on the dies go inward so they will not be visible when installed.

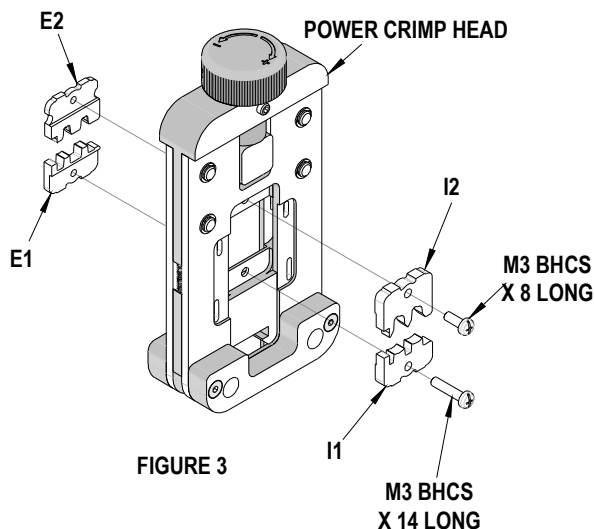


FIGURE 3

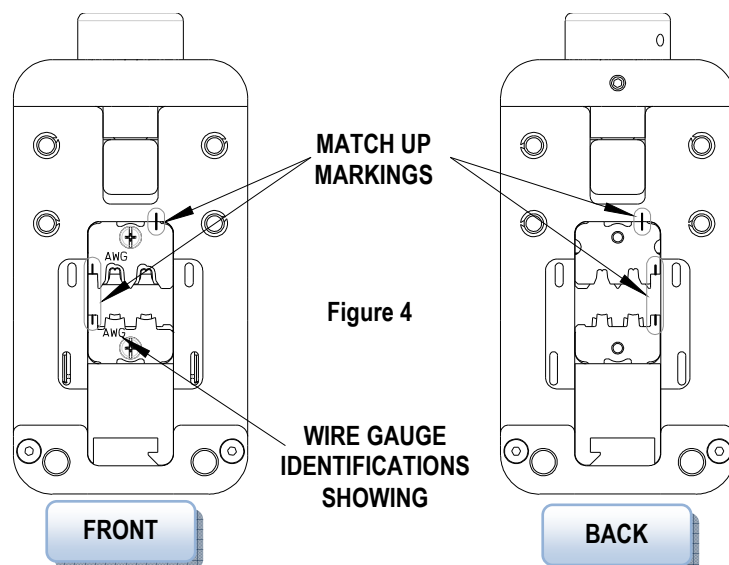


Figure 4

3. Insert the Punches or dies (E2 and I2) into the top slots of the nest. Install the M3 x 8 long BHCS and lightly tighten in place. See Figure 3.
4. Make sure the small markings on the individual dies match up and wire gauge identification (AWG) marks should be facing out and aligned as shown in Figure 4.

**Note:** Make sure the longer screw only goes into the lower dies.

5. Completely close the crimp dies until they are touching, and then securely tighten the M3 BHCS.

### Adjustments

The crimp height on the 63816-0800 Power Crimp Head can be adjusted, if necessary. To do this, first measure the conductor crimp height of a crimped terminal and compare to the crimp specification listed in the product specification for that terminal. If an adjustment is required, follow the procedure, below:

1. Loosen the locking set screw located just below the knurled knob at the top of the Power Crimp Head. See Figure 5.
2. If the crimp height is too loose, rotate the knob, a small amount, in the counter-clockwise direction. Crimp another terminal and re-check the crimp height.
3. If the crimp height is too tight, turn the knob clockwise and follow the same procedure.
4. Do this until the proper crimp height is achieved.
5. When the proper crimp height is achieved, lock the set screw.

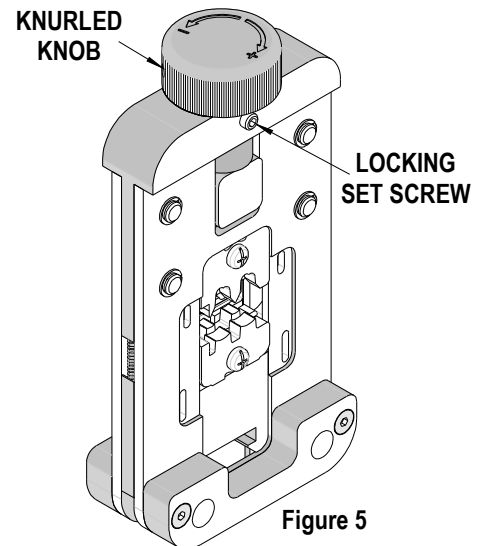


Figure 5

### Operation

1. To load a terminal and position the wire in the terminal in the Power Crimp Head, follow the loading procedure as explained in the Hand Crimp Tool Specification sheet.
2. Crimp the terminal by squeezing the trigger on the side of the battery actuator until the tool cycles and returns and the jaws open.
3. Remove the terminal from the locator and inspect the crimp for proper quality.

**CAUTION:** Never place fingers into the tooling nest area.

### Maintenance

It is recommended that each operator of the tool be made aware of, and responsible for, the following maintenance steps:

1. 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.
2. Remove dust, moisture and other contaminants with a clean brush, or soft, lint-free cloth.
3. Do not use any abrasive materials that could damage the tool.
4. The use of a light oil, such as SAE 30 weight automotive oil, every 5,000 crimps, or monthly, will significantly enhance the tool life and ensure a stable calibration. Make certain all sliding surfaces in the tool head are protected with a thin coat of high quality machine oil. See Figure 1 for lubrication points. Do not oil excessively and wipe excess oil from the tool frame when complete.
5. Store the tool in a clean and dry area when not in use.

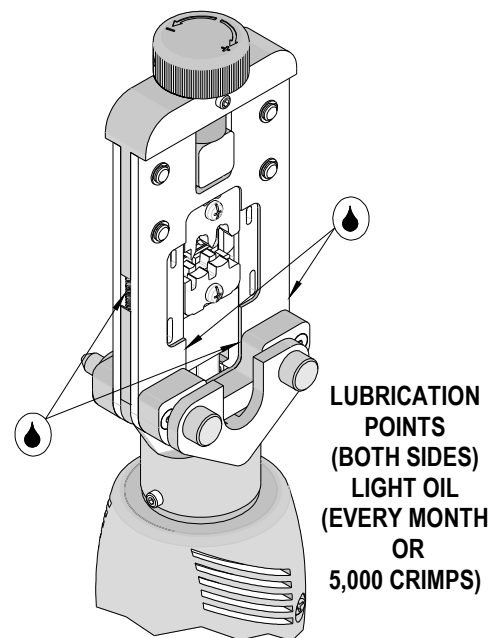


Figure 6

### 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 will repair or exchange the tool free of charge. This repair or exchange will not be applicable to altered, misused, or damaged tools.

### Parts List

Item	Order No	Description	Quantity
1	63816-0800	Power Crimp Head (for style 4D crimp tools)	1
2	63816-0801	Return Spring	2

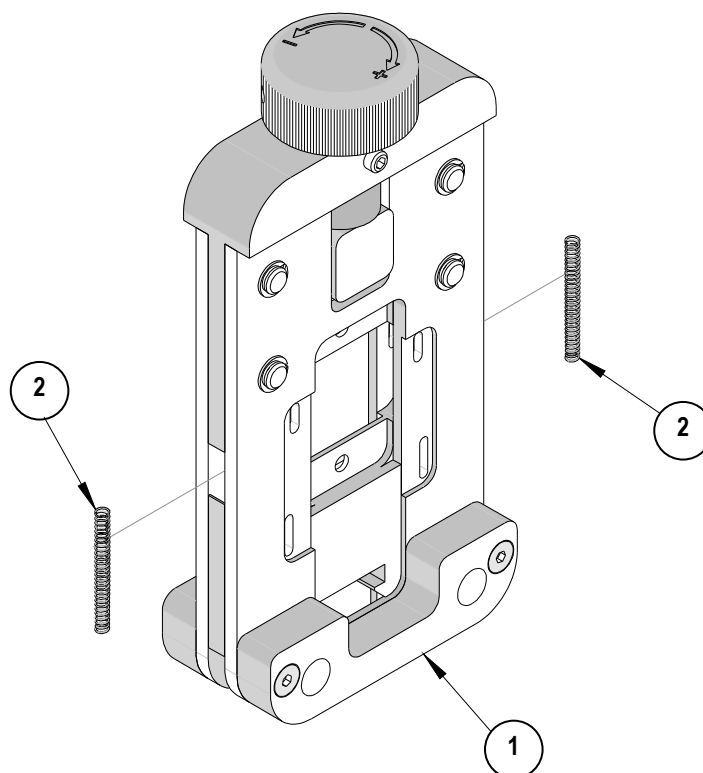


Figure 7

<http://www.molex.com>