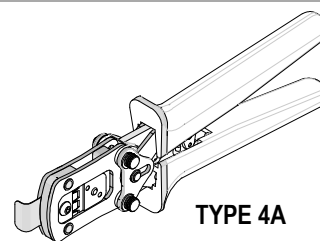


**Modular Crimp Head**  
Order No. 63825-9770

## Application Tooling Specification Sheet



**Hand Crimp Tool**  
Order No. 63825-9700

### FEATURES

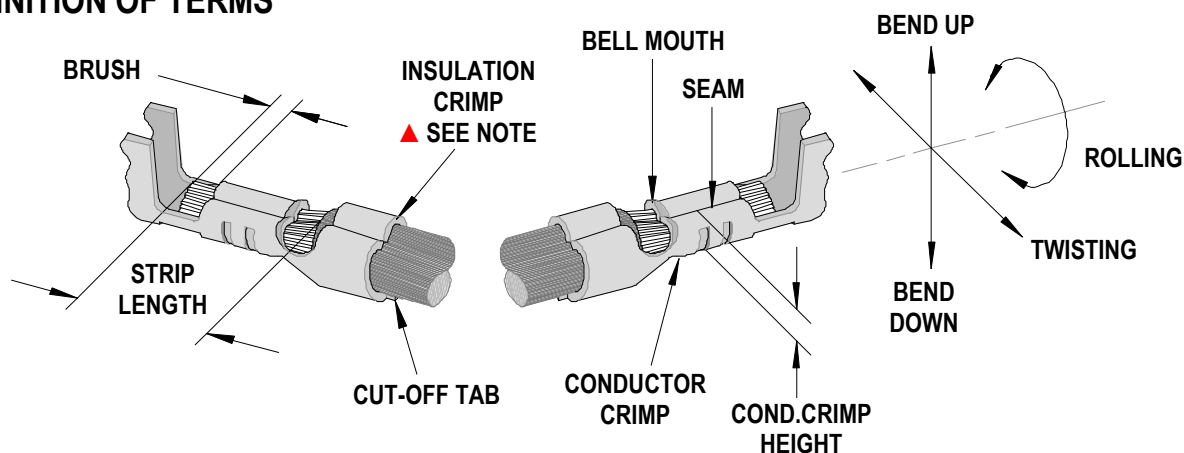
- % A full cycle ratcheting hand tool ensures complete crimps
- % Ergonomically designed soft handles
- % Precisely designed crimping profiles with simple contact positioning
- % Easy handling due to outstanding force ratio
- % A-620 Class 2 compliant and RoHS compliant
- % Modular Crimp Head is removable and can be use in the Air Powered Tool Order No.63816-0100, accompanied by Air Powered Crimp Adapter (Order No. 63816-0700).
- % Can also be used in the Battery Powered Tool Order No.63816-0200 (110 V) or 63816-0250 (220 V), accompanied by Battery Powered Crimp Adapter (Order No. 63816-0600).

### SCOPE

Products: 1.50mm (.059") Pico-SPOX™ Crimp Terminal, Female, 24-30 AWG.

Terminal Series No.	Terminal Order No.	Wire Size		(2) Insulation Diameter Maximum		Strip Length	
	(1) Available in Reel form only	AWG	mm <sup>2</sup>	mm	In.	mm	In.
87421	87421-0000	24	0.20	1.15	.045	1.05-1.54	.041-.061
		26-30	0.12-0.05	1.00	.039		
(1) Customer to cut off terminal from reel: 0.15mm (.006") maximum Cut-off Tab.							
(2) See Conditions on page 2.							

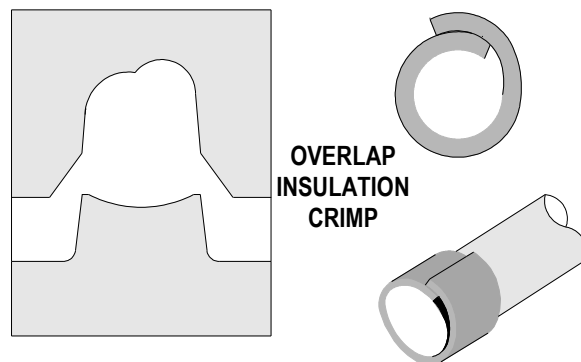
### DEFINITION OF TERMS



The above terminal drawing is a generic terminal representation. It is not an image of a terminal listed in the scope.

**▲ Insulation Crimp Note:**

Due to the terminal's insulation grip design and/or insulation diameter range, this tool uses "overlap" form geometry in the insulation punch. This produces an overlap insulation crimp (A620 – compliant). While the insulation punch profile may appear "lopsided", this is a normal condition for this tool. See figure to the right. (Some tools with multiple crimp pockets may not have the "overlap" profile on all pockets).

**OVERLAP FORM GEOMETRY****CRIMP SPECIFICATIONS:**

Terminal Series No.	Bell mouth		Conductor Brush		Bend up	Bend Down	Twist Roll	
	mm	In.	mm	In.	Degree		Degree	
87421	0.05-0.40	.002-.016	0.00-0.50	.000-.020	3	3	3	3

After crimping, the crimp profiles should measure the following.

Terminal Series No	Wire Size		Conductor Crimp				Insulation Crimp				Pull Force Minimum		*Profile	
			Height (Ref.)		Width (Ref.)		Height (Ref.)		Width (Ref.)					
	AWG	mm²	mm	In.	mm	In.	mm	In.	mm	In.	N	Lb.	24	26-30
87421	24	0.20	0.56-0.60	.022-.024	1.00	.039	1.40	.055	1.10	.043	29.4	6.60	X	
	26	0.12	0.52-0.58	.020-.023	1.00	.039	1.24	.049	1.10	.043	19.6	4.40		X
	28	0.08	0.52-0.58	.020-.023	1.00	.039	1.24	.049	1.10	.043	9.8	2.20		X
	30	0.05	0.52-0.58	.020-.023	1.00	.039	1.24	.049	1.10	.043	6.7	1.50		X
*To Achieve IPC-A-620 Class 2 Crimps, the following over-all wire insulation diameter ranges are recommended: Profile 24: 0.90-1.15mm (.035-.045 inch) Profile 26-30: 0.80-1.00mm (.032-.040 inch)														

**Tool Qualification Notes:**

1. Pull Force should be measured with no influence from the insulation crimp.
2. The above specifications are guidelines to an optimum crimp.

**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. With the hand tool in the open position, pivot the terminal locator open by pulling on the locator knob and lift the wire stop blade up. See Figure 1.

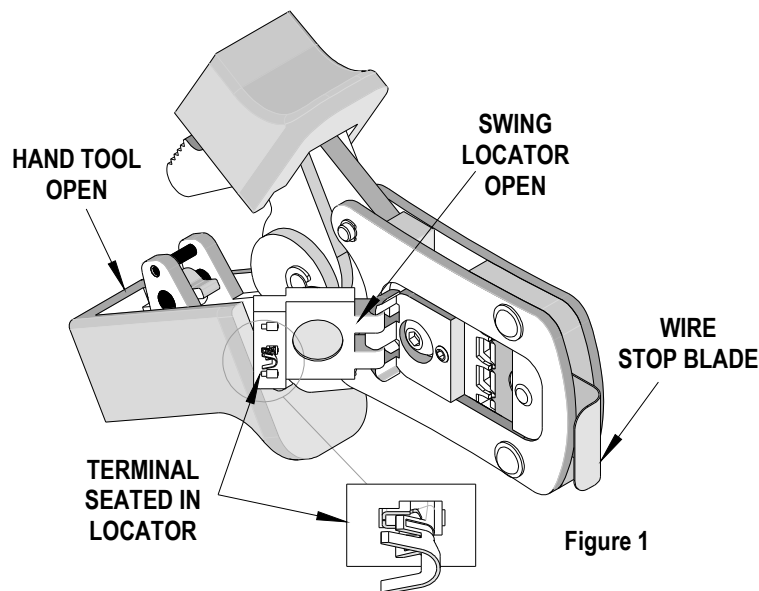


Figure 1