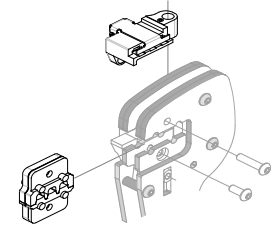




**Crimp Tool Kit
HD-50120-6**

**Application Tooling
Specification Sheet**



Order No. 63823-7870

FEATURES

- Tool kit is easily installed into the 63810-1060 (HD-50120-2) Hand Crimp Frame
- Many different Tool kits can be used in the Hand Crimp Frame.

SCOPE

Products: JAE #MX19 Series Pin and Socket Crimp Terminals crimped to 20 AWG TXL wire.

Terminal Series No.	Terminal Order No.	Wire Size	Insulation Diameter		Strip Length	
		AWG	mm	in	mm	in
JAE MX19	M19P09K3F2 pin	20	1.7 – 1.9	.067 - .075	2.0 – 2.5	.051 - .098
	M19S09K3F2 socket	20	1.7 – 1.9	.067 - .075	2.0 – 2.5	.051 - .098

CRIMPING TERMINALS

1. Swing the terminal locator away from the crimp tool. See Figure 1.
2. Load the terminal in the locator pocket that is aligned with the appropriate crimping nest profile for the wire being used: Nest A is for the pin contact and nest B is for the socket contact.
3. With the tool jaws in the open position, return the locator to its original position.
4. Insert the proper wire over the terminal with the tip against the wire stop. See Figure 2.

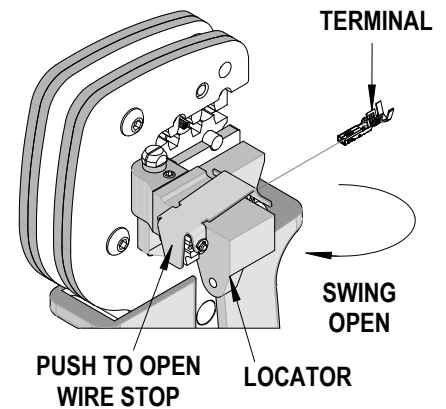


Figure 1

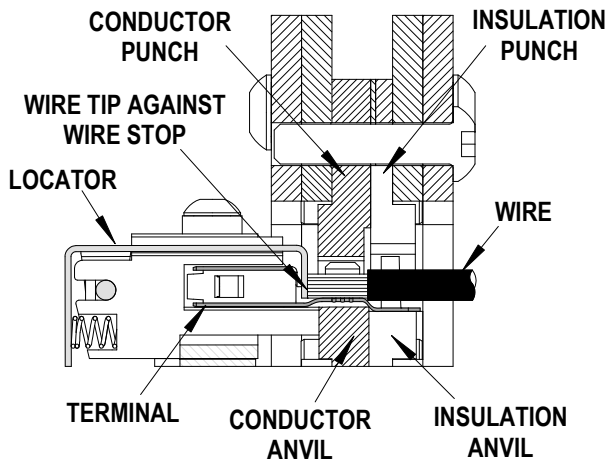


Figure 2

5. Compress the terminal by squeezing the tool handles until the ratchet mechanism cycle has been completed. Then release handles to open the jaws.
6. Remove and visually inspect the crimped terminal for proper crimp quality and location. See CONDITIONS.

CONDITIONS:

After crimping, the crimped terminals should measure as follows:

Terminal Series No.	Wire Size		Conductor Crimp				Insulation Crimp				Pull Force Minimum		Crimp Nest Profile	
			Height (Ref.)		Width (Ref.)		Height (Ref.)		Width (Ref.)					
	AWG	TYPE	mm	In.	mm	In.	mm	In.	mm	In.	N	Lb.	A	B
M19P09K3F2 pin	20	TXL	0.75 – 0.85	.030 -.033	1.58	.062	2.05	.081	1.9	.075	88.2	20	X	
M19S09K3F2 socket	20	TXL	0.75 – 0.85	.030 -.033	1.58	.062	2.05	.081	1.9	.075	88.2	20		X

Installation of Crimp Tool Kit in Frame:

1. Snap the flap locator on to the locator mounting post on the left side of the Hand Crimp Frame. See Figure 3.
2. Align the nest designator letters A and B on both dies and install the dies with the letters being visible (opposite side from the locator).
3. Install the M4 X 9mm (short screw) on the moving jaw and the M4 X 18mm (long screw) on the fixed jaw.

Figure 4, below, shows all components and their proper location for this Tool Kit.

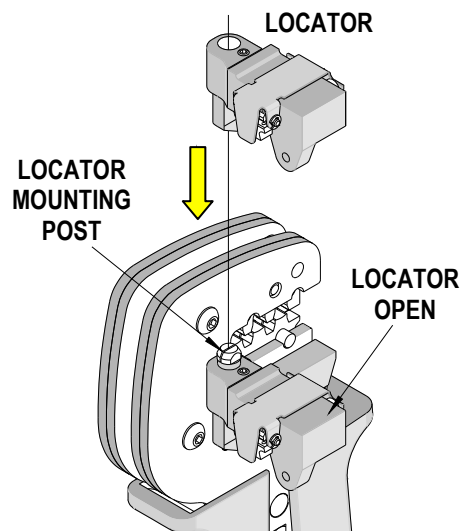


Figure 3

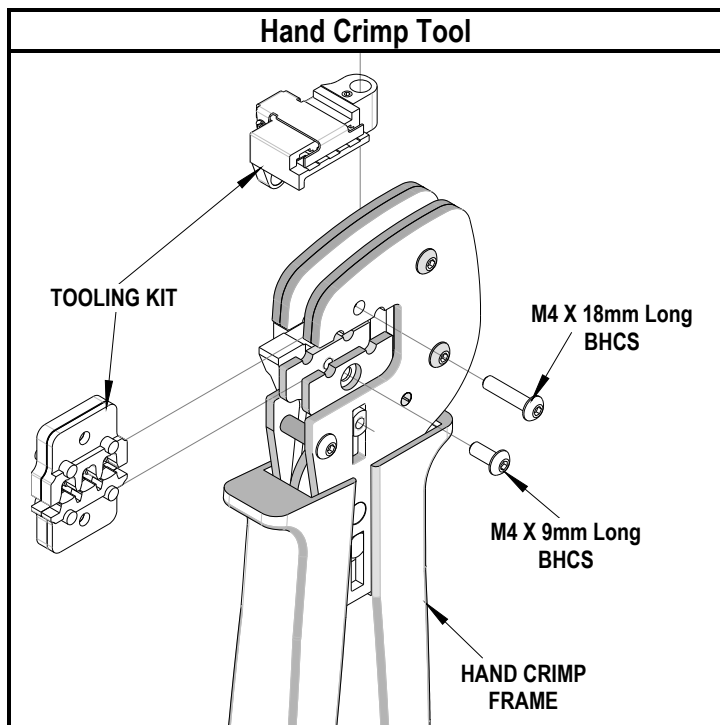


Figure 4

Tool Kit Order No.	Hand Crimp Frame No.
63823-7870 (HD-50120-6)	63810-1060 (HD-50120-2)

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