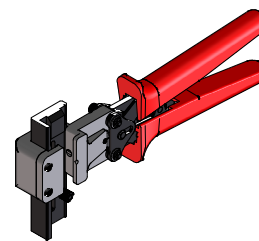


**RAST R5
IDT
Hand Tool**



**Application Tooling
Specification Sheet**



Order No. 63825-9900

FEATURES

- % Terminates wire directly into the direct and indirect R5 connectors
- % Accommodates 2 to 11 circuit connectors
- % A full cycle ratchet ensures complete terminations
- % This tool is designed for prototype or low volume work only and is not intended for production

SCOPE

Products: 5.0mm RAST R5 IDT Female Connectors, Direct and Indirect, Series 93055, 93065, 93244, and 93395.

Product List

The following is a partial list of the product order numbers that this tool is designed to run. Updates to this list are available on www.molex.com.

Connector Series No.	Connector Order No.							
93055	93055-0101	93055-0102	93055-0103	93055-0104	93055-0105	93055-0106	93055-0107	93055-0108
	93055-0109	93055-0110	93055-0111	93055-0112	93055-0113	93055-0114	93055-0116	93055-0117
	93055-0118	93055-0119	93055-0120	93055-0121	93055-0122	93055-0123	93055-0124	93055-0125
	93055-0126	93055-0128	93055-0129	93055-0130	93055-0131	93055-0132	93055-0133	93055-0134
	93055-0135	93055-0136	93055-0137	93055-0138	93055-0139	93055-0140	93055-0142	93055-0143
	93055-0146	93055-0144	93055-0145	93055-0147	93055-0148	93055-0149	93055-0150	93055-0151
	93055-0152	93055-0153	93055-0154	93055-0155	93055-0159	93055-0160	93055-0161	93055-0162
	93055-0163	93055-0164	93055-0201	93055-0202	93055-0203	93055-0204	93055-0205	93055-0206
	93055-0207	93055-0208	93055-0209	93055-0210	93055-0211	93055-0212	93055-0213	93055-0214
	93055-0215	93055-0216	93055-0217	93055-0218	93055-0219	93055-0220	93055-0221	93055-0222
	93055-0223	93055-0224	93055-0225	93055-0226	93055-0227	93055-0228	93055-0229	93055-0230
	93055-0231	93055-0232	93055-0233	93055-0235	93055-0236	93055-0237	93055-0238	93055-0239
	93055-0241	93055-0301	93055-0302	93055-0303	93055-0304	93055-0305	93055-0306	93055-0307
	93055-0308	93055-0309	93055-0310	93055-0311	93055-0312	93055-0313	93055-0314	93055-0315
	93055-0316	93055-0317	93055-0318	93055-0319	93055-0320	93055-0321	93055-0324	93055-0325
	93055-0326	93055-0401	93055-0402	93055-0403	93055-0404	93055-0405	93055-0406	93055-0407
	93055-0408	93055-0409	93055-0410	93055-0411	93055-0412	93055-0413	93055-0414	93055-0415
	93055-0416	93055-0417	93055-0418	93055-0419	93055-0420	93055-0421	93055-0422	93055-0423
	93055-0501	93055-0502	93055-0503	93055-0504	93055-0505	93055-0506	93055-0507	93055-0508
	93055-0509	93055-0510	93055-0511	93055-0601	93055-0602	93055-0603	93055-0604	93055-0605
	93055-0606	93055-0607	93055-0608	93055-0609	93055-0610	93055-0611	93055-0612	93055-0613
	93055-0614	93055-0615	93055-0616	93055-0617	93055-0618	93055-0701	93055-0702	93055-0703
	93055-0704	93055-0705	93055-0706	93055-0707	93055-0708	93055-0709	93055-0710	93055-0711
	93055-0712	93055-0713	93055-0801	93055-0802	93055-0803	93055-0804	93055-0805	93055-0806
	93055-0807	93055-0808	93055-0809	93055-0901	93055-0902	93055-0903	93055-0904	93055-0905
	93055-0906	93055-0907	93055-0908	93055-0909	93055-0910	93055-0911	93055-0912	93055-0913

93065	93065-1001	93065-1101	93065-1102	93065-2001	93065-2002	93065-2003	93065-2004	93065-2005
	93065-2006	93065-2007	93065-3001	93065-3002	93065-3003	93065-3004	93065-3005	93065-3006
	93065-3007	93065-3008	93065-3009	93065-3010	93065-4001	93065-4002	93065-5001	93065-5002
	93065-5003	93065-5004	93065-6001	93065-6002	93065-7001	93065-7002	93065-7003	93065-8001
	93065-8002	93065-8003	93065-8004	93065-8005	93065-8006	93065-8007	93065-9001	93065-9002
	93065-9003	93065-9004	93065-9005	93065-9006				
93244	93244-0101	93244-0103	93244-0104	93244-0106	93244-0107	93244-0108	93244-0109	93244-0110
	93244-0111	93244-0112	93244-0113	93244-0114	93244-0115	93244-0116	93244-0117	93244-0118
	93244-0119	93244-0120	93244-0121	93244-0122	93244-0123	93244-0124	93244-0125	93244-0127
	93244-0128	93244-0130	93244-0131	93244-0136	93244-0137	93244-0138	93244-0139	93244-0201
	93244-0202	93244-0204	93244-0205	93244-0206	93244-0207	93244-0208	93244-0209	93244-0210
	93244-0211	93244-0212	93244-0213	93244-0214	93244-0215	93244-0216	93244-0217	93244-0219
	93244-0220	93244-0221	93244-0222	93244-0223	93244-0225	93244-0226	93244-0228	93244-0301
	93244-0302	93244-0303	93244-0304	93244-0305	93244-0306	93244-0307	93244-0308	93244-0309
	93244-0310	93244-0311	93244-0312	93244-0315				
93395	93395-0101	93395-0102	93395-0105	93395-0126	93395-0133	93395-0134	93395-0135	93395-0136
	93395-0201	93395-0202	93395-0203	93395-0218	93395-0227	93395-0228	93395-0229	93395-0230
	93395-0231	93395-0232	93395-0233	93395-0301	93395-0313			

Applicable Wires

Connector Series No.	Conductor Size	Insulation Diameter Maximum
93055 93065	0.5mm ²	2.10mm
	0.75mm ²	2.44mm
	1.0mm ²	2.55mm
93244 93395	1.5mm ²	2.90mm

Tool Set-Up

The tool is adjusted for connector circuit size as follows:

- Slide the connector nest out of the tool frame.
- Loosen the adjustable post by turning the knurled top counterclockwise (CCW) one-half turn.
- Slide the adjustable post to the end of its slot, the farthest away from the stop block. See Figure 1.
- Place the connector in the connector nest and slide it up against the stop block as shown in Figure 2.
- Move the adjustable post against the side of the connector and tighten it by turning the knurled top clockwise (CW). See Figure 3. Do not use tools to tighten the adjustable post; finger-tight is sufficient.

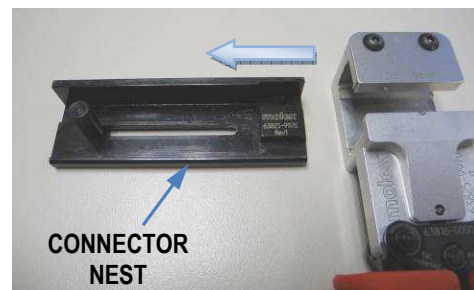


Figure 1

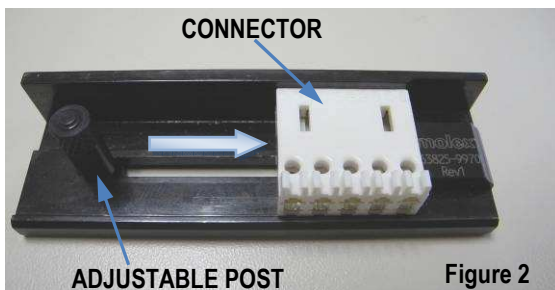


Figure 2

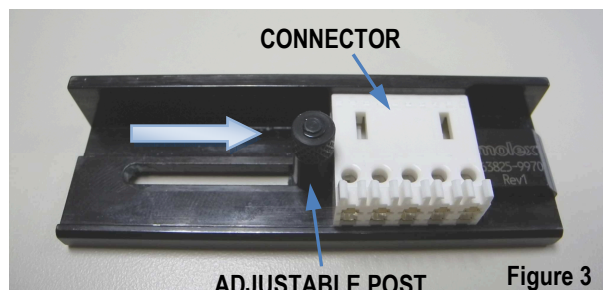
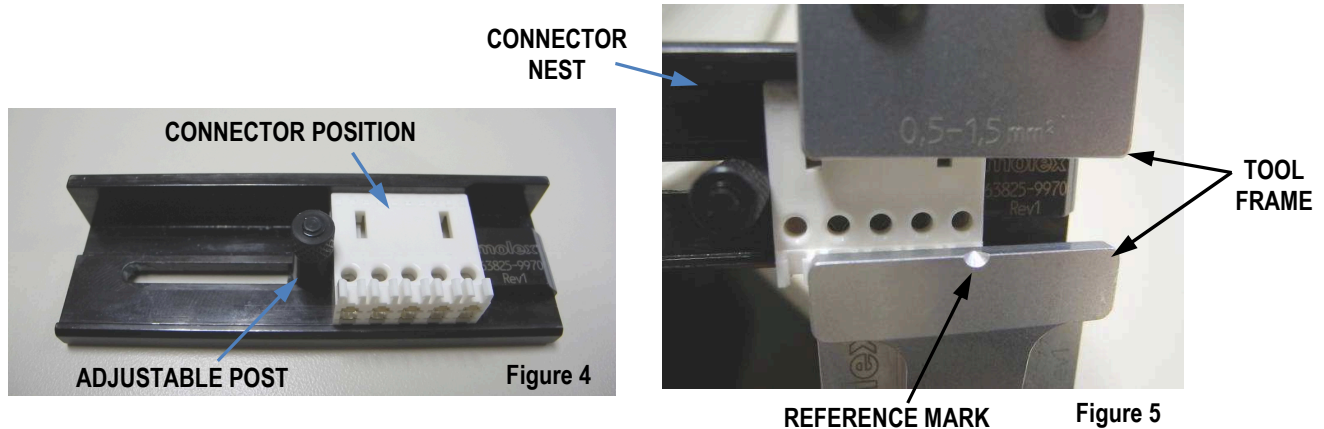


Figure 3

OPERATION

Open the hand tool by squeezing the handles together. At the end of the closing stroke, the ratchet mechanism will release and the handles will spring open.

1. Slide the connector nest out of the tool frame.
2. Place the proper connector into the nest as shown in Figure 4. The mating side of the connector should be against the top of the nest and the wire holes toward the bottom.
3. Slide the connector nest into the tool frame until the first termination position is aligned with the reference mark on the frame face. See Figure 5. The connector nest is detented and will “click” into place.



NOTE: If the connector nest is difficult to slide into the tool frame, slide it out and make sure the connector is fully seated in the nest.

4. Insert the appropriate wire into the connector hole until it stops.
5. Make sure the inserted wire is in alignment with the reference mark on the frame face, then squeeze the tool handles together until the ratchet releases.

NOTE: If the wire is not in alignment with the reference mark, connector and/or tool damage will occur if termination is attempted.

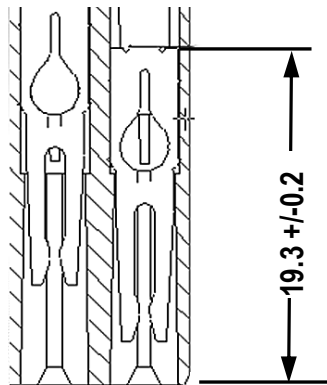
NOTE: The full cycle ratchet action will not release the tool until it has been fully closed.

NOTE: If something jams, the ratchet mechanism can be released by pushing upward on the ratchet pawl located between the tool handles. See Figure 9.

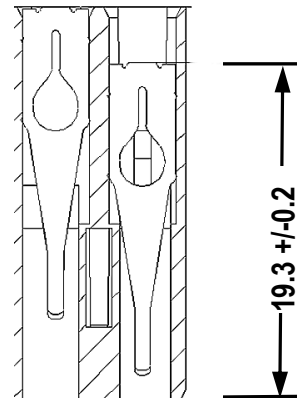
6. Release the tool handles and allow them to spring open.
7. Move the connector nest to the next termination position. The nest is detented and will “click” into place.
8. Repeat steps 4 through 7 until all terminations are complete.
9. Slide the connector nest out of the tool frame and remove the terminated connector.

Assembly Inspection

After termination, the contacts must be seated to the dimension shown below:



Series: 93055, 93244, 93395



Series: 93065

Maintenance

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

1. Do not use any abrasive materials that could damage the tool.
2. 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, it needs cleaning and lubrication for maximum service life. Light oil used at the pivot points every 5,000 terminations or 3 months, will significantly enhance the tool life.
3. Wipe excess oil from hand tool, particularly from the terminating area.
4. When tool is not in use, keep the handles closed to prevent objects from becoming lodged in the termination punch 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 closed**. The tool will open easily by pressing the ratchet release lever up. See Figure 9.

Tool Frame Preload

Tool frame preload is not available on this type of frame. The tool should be replaced when it fails to meet assembly dimensions.

Warranty

This tool is for terminating individual wires into insulation displacement connectors only. 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.

CAUTION: Molex specifications are valid only when used with Molex connectors and tooling.

CAUTIONS:

1. Manually powered hand tools are intended for low volume, prototyping, or field repair. This tool is **NOT** intended for production use. Repetitive use of this tool should be avoided.
2. Insulated handles are not protection against electrical shock.
3. Wear eye protection at all times.
4. Use only the Molex connectors and wires specified for this tool.

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.

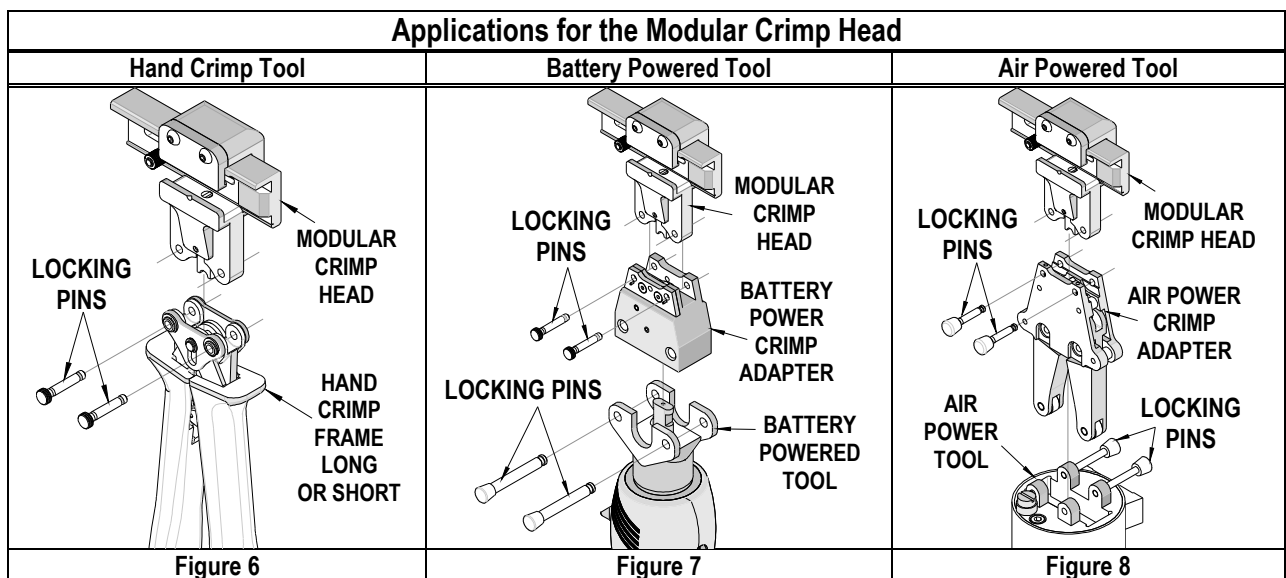
WARNING: NEVER install tooling or service a powered tool while it is connected to any power source. Disconnect the power source (electric or pneumatic) from the actuator

CAUTION: Keep fingers away from the crimping area when operating a powered tool. It can cause severe injury.

CAUTION: Wear safety glasses when operating or servicing this tool.

The chart below shows all applications for this Modular Crimp Head.

Modular Crimp Head Order No.	Tool Order no.	Tool Description	Adapter Order No.	Adapter Description	Figure No.
63825-9970	63816-0000	Hand Crimp Frame (Short)	N/A	N/A	6
	63816-0050	Hand Crimp Frame (Long)	N/A	N/A	6
	63816-0200	Battery Power Tool (110 V)	63816-0600	Battery Power Crimp Adapter	7
	63816-0250	Battery Power Tool (220 V)	63816-0600	Battery Power Crimp Adapter	7
	63816-0100	Air Power Tool	63816-0700	Air Power Crimp Adapter	8



PARTS LIST

IDT Hand Tool 63825-9900			
Item	Order No	Description	Quantity
1	63825-9970	Modular Crimp Head	1
2	63816-0000	Hand Crimp Frame (Short)	1
3	63816-0001	Locking Pin	2
4	63600-0525	Handle Spring	1

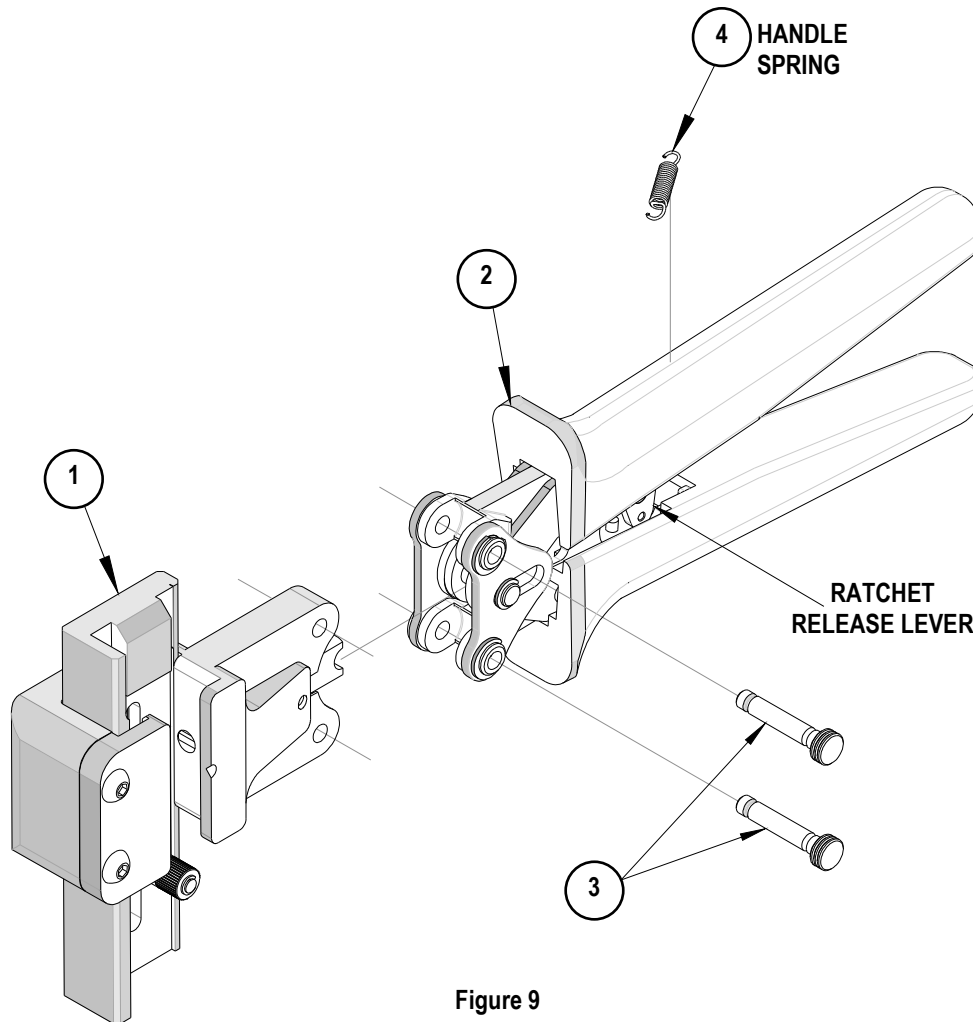


Figure 9

Visit our Web site at <http://www.molex.com>