

**Order Number
63800-2850**



Application Tooling Specification



FEATURES

- Measuring range: 0.0-25.0mm (0.00-1.00")
- Resolution: 0.001mm (.00005")
- Accuracy: ±0.002mm (.0001")
- Calibration certificate included (traceable to NIST)

DESCRIPTION



Figure 1

This micrometer is specifically designed to measure crimp height. It has a flat anvil (thin blade) that supports the top of the crimp while a pointed spindle contacts the bottom radial surface. See Figure 1.

LCD DISPLAY

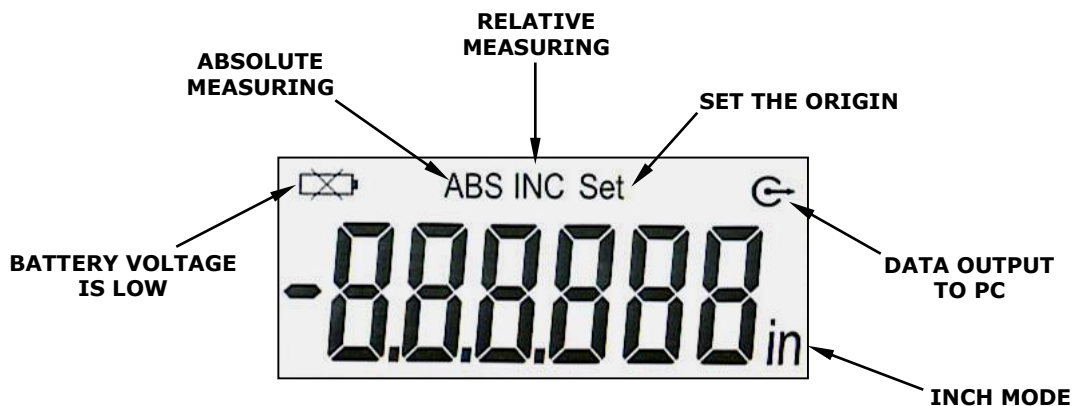


Figure 2

OPERATION

1. There are two ways of pressing the function keys:



Press (less than 2 seconds) and release



Press and hold (more than 2 seconds)

2. ON/OFF or SET



= ON/OFF = Power on/off



= SET = Set the origin ("SET" flashes once on the display, and the display is set to "0".)


3. ABS/INC or UNIT



= ABS/INC = Absolute/Relative measuring mode selection



= UNIT = Metric/Inch measuring mode conversion

4. DATA OUTPUT  (Requires data cable, Molex part number 638002855)




= Output data once ( flashes once)



= Output data continuously ( on continuously). To stop,  the key

- Do not press the keys with a sharp object.
- Do not press the keys with a sideways motion.

POWER

1. The battery is LR44, 1.5V. Replace the battery when the display is blurring or the  symbol appears.

Note: Be sure to wipe the battery clean before installation.

2. If the micrometer is not in use for 5 minutes, the device will shut off. The micrometer will turn on when pressing and releasing the ON/OFF key or turning the spindle.
3. Power off the micrometer when not in use by pressing and releasing the ON/OFF key.
4. Remove the battery before storing the micrometer.

HOW TO MEASURE CRIMP HEIGHT (See Figure 4)

1. Complete the crimping tool setup procedure.
2. Crimp a minimum of five samples.

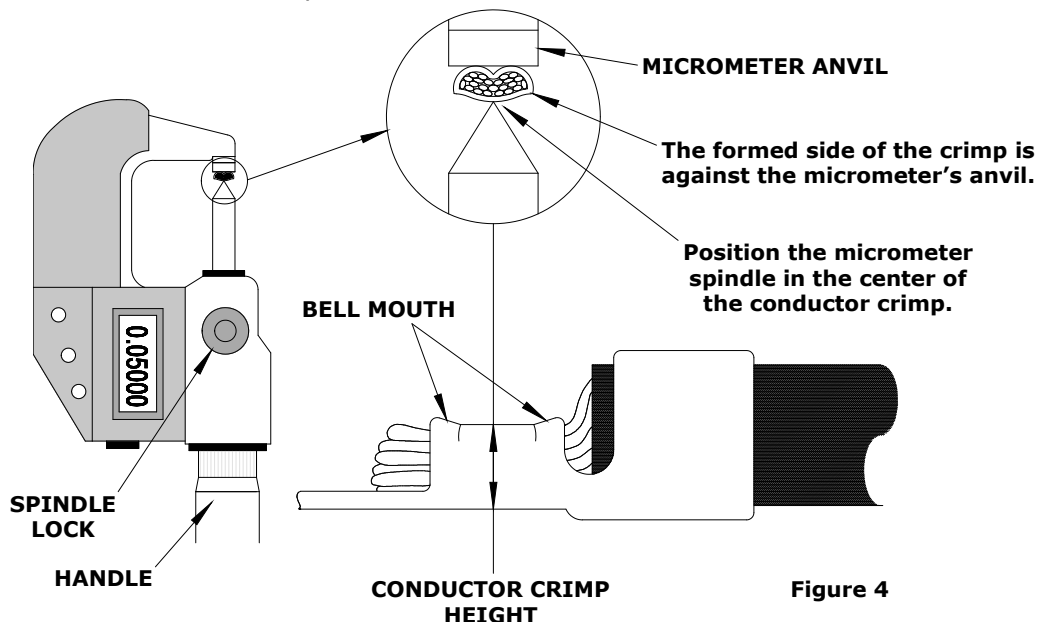


Figure 4


3. Place the micrometer anvil (flat blade) across the top of the form radii of the conductor crimp. Do not take the measurement near the conductor bell mouth.
4. Rotate the micrometer spindle until the point contacts the bottom radial (curved) surface. Do not excessively tighten the point against the terminal.
5. Record the crimp height readings. A minimum of five crimp height readings are necessary to confirm the crimping tool setup. A minimum of 25 readings should be taken for determining process capability.

For additional information, refer to the Molex Quality Crimping Handbook (TM-63800029).

SPECIFICATIONS

- **Measuring force:** 5-10N
- **Operation temperature:** 0-40°C (32-104°F)
- **Protection class:** IP65 (Resists water spray)

TROUBLESHOOTING

Symptom	Cause	Resolution
Display "E 1" Display "Exxxx"	Measuring value over display range .1"	Reset the origin or convert to relative measurement mode.
Display "E 2"	Origin is too great	Reset the origin.
Display "E 3" Display "E 8"	Internal error in the micrometer Something wrong with the sensor	Reset the battery.
Measuring value is incorrect	Measuring surfaces are dirty	Clean the measuring surfaces.
	Origin is not correct	Reset the origin.
No display Display is blurring or  appears	Battery voltage is low	Replace the battery.
Output data is incorrect	Battery voltage is low	Replace the battery.

MAINTENANCE

Each operator of the tool should be 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. When the tool is not in use, turn it off and store it in a clean, dry area.
4. There are no repair parts available for this tool except for the batteries. Should the tool be damaged, a new tool is required.

Warranty

This tool is only for measuring crimped terminals. All tools are warranted to be free of manufacturing defects for one year. Should such a defect occur, a repair or exchange of the tool would be 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.

Application Tooling Support

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