Crimp Height Micrometer
Specification Sheet
Order No. 63800-2820

Features

- Measuring range: 0-1 in. (0-25 mm)
- Resolution: 0.00005 in (0.001 mm)
- Accuracy: ±0.0001 in (0.002 mm)
- Calibration certificate included (traceable to NIST)

Description

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

LCD Display

Absolute measuring
Set the origin
Data output to PC
Inch mode

Battery voltage is low

Figure 1

ABS INC Set

Figure 2
### Operation

1. There are two ways of pressing the function keys:
   - 🔄 Press and release or 🔄 Press and Hold (more than 1 second)

2. **ON/OFF...SET**
   - 🔄 = ON/OFF Power on/off.
   - 🔄 = SET Set the origin.

3. **ABS/INC...UNIT**
   - 🔄 = ABS/INC Absolute/Relative measuring mode conversion.
   - 🔄 = UNIT Metric/Inch measuring mode conversion.

4. Set the origin
   - Press and hold the “SET” key until the “SET” flashes once on the LCD and the display is set to the origin.

### Power

1. The battery is a SR44, 1.5V. Replace the battery when the display is blurring or the “ 🔄 ” appears.
2. If the micrometer is not in use, the power will shut off in 5 minutes. The micrometer will turn on when pressing the ON/OFF key or turning the spindle.
3. Power off the micrometer when not in use, by pressing the ON/OFF key.
4. Remove the battery if the micrometer is not being used for a long period of time.

### How to Measure Crimp Height (See Figure 4)

1. Complete the crimping tool set-up procedure.
2. Crimp a minimum of five samples.
3. Place the Anvil (flat blade) of the crimp micrometer across the top of the dual 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 crimp height readings. A minimum of five crimp height readings is necessary to confirm the crimping tool set-up. A minimum of 25 readings should be taken for determining process capability.

For additional information, please refer to the Molex Quality Crimping Handbook (TM-638000029)
Specifications
Measuring force: 5 ~ 10N  
Operation temperature: 0 ~ 40°C  
Protection class: IP54 (Resist water splash)  
IP65 (Resist water spray)  
Power consumption: <=35µA  
Storage temperature: -20 ~ 60°C

Troubleshooting

<table>
<thead>
<tr>
<th>Symptom</th>
<th>Cause</th>
<th>Resolution</th>
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<tbody>
<tr>
<td>Display “E 1”</td>
<td>1. Measuring value over display range.1”</td>
<td>Reset the origin or convert to relative measuring mode.</td>
</tr>
<tr>
<td>Display “Exxxxx”</td>
<td>1. The origin is too great.</td>
<td>Reset the origin.</td>
</tr>
<tr>
<td>Display “E 2”</td>
<td>1. Internal error in the micrometer.</td>
<td>Reset the battery.</td>
</tr>
<tr>
<td>Display “E 3”</td>
<td>1. Something wrong with the sensor.</td>
<td></td>
</tr>
<tr>
<td>No display</td>
<td>2. The origin is not correct.</td>
<td>2. Reset the origin.</td>
</tr>
<tr>
<td>Display is blurring or</td>
<td>1. Battery voltage is under 1.45V.</td>
<td>Replace the battery.</td>
</tr>
<tr>
<td>The output data is incorrect</td>
<td></td>
<td></td>
</tr>
</tbody>
</table>

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

1. Remove dust, moisture, and other contaminants with a clean brush, or soft, lint free cloth.
2. Do not use any abrasive materials that could damage the tool.
3. When tool is not in use, turn off and store in a clean, dry area.
4. There are no repair parts except for the batteries available for this tool. Should the tool be damaged a new tool is required.

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 to be free of manufacturing defects for (1) one year. 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, fixtureing, or use of handle extensions voids this warranty.

Contact Information
For more information on Molex application tooling please contact your nearest Molex location shown below.

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