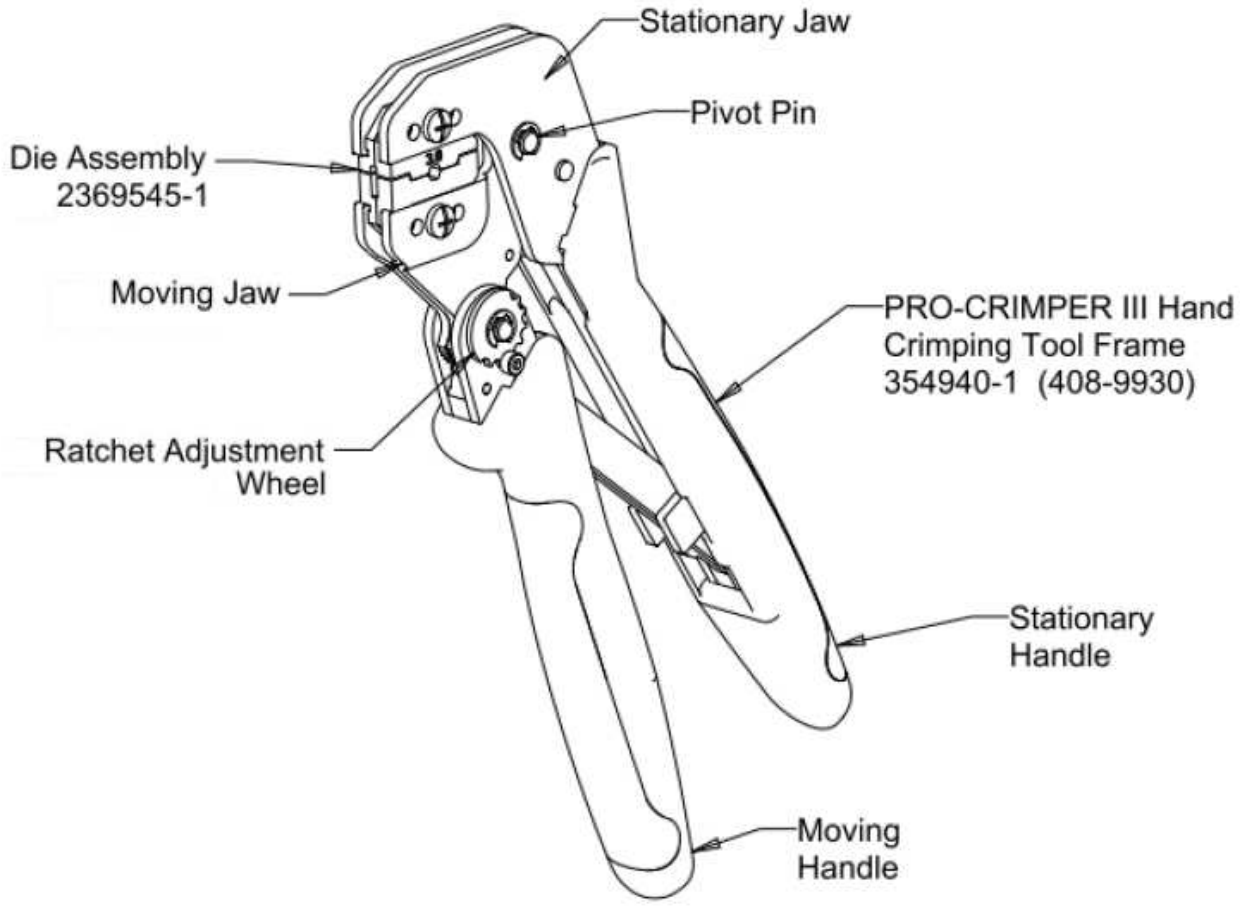


Figure 1

NOTE
Cumulative Trauma Disorders can result from the prolonged use of manually powered hand tools. Hand tools are intended for occasional use and low volume applications. A wide selection of powered application equipment for extended- use, production operations is available.

NOTE
The PRO- CRIMPER III Hand Crimping Tool is a "Commercial" grade tool and is designed primarily for field installation, repair, maintenance work, or prototyping in industrial, commercial, or institutional applications. Product crimped with this tool will meet the crimp height requirement for hand tools in the appropriate 114 series specification but may not comply with other feature parameters of the specification. TE Connectivity offers a variety of tools to satisfy your performance requirements. For additional information, contact the Tooling Assistance Center at 1- 800- 722- 1111.

1. INTRODUCTION

This instruction sheet covers the use and maintenance of Crimping Die 2369545-1, used in PRO-CRIMPER III Hand Tool Frame 354940-1 The die crimps FAKRA ferrules onto coaxial cable.

For additional information on the hand tool frame, refer to 408-9930.

Reasons for reissue of this instruction sheet are provided in Section 9, REVISION SUMMARY.

NOTE
All dimensions on this instruction sheet are in metric units [with U.S. customary units in brackets]. Figures are not drawn to scale.

NOTE
Read these instructions thoroughly before using the Crimp Die Tool.

2. DESCRIPTION

The tool features a tool frame with a stationary jaw and handle, a moving jaw, a moving handle, and an adjustable ratchet that ensures full connector crimping. The tool frame holds the die assembly.

The die assembly features an anvil and a nest containing a hex crimping cavity. Each die is held in the hand tool by a single screw.

3. INSTALLATION AND REMOVAL OF THE DIE ASSEMBLY (FIGURE 2)

1. Open the tool handles and remove the two die retaining screws from the tool jaws
2. Slide the die assembly into the partially opened tool jaws. See Figure 2 for normal orientation of the dies.
3. Insert the die retaining screws and tighten the screws just enough to hold the dies in place. Do *NOT* tighten the screws completely at this time.
4. Carefully close the tool handles, making sure the dies align properly. Continue closing the tool handles until the ratchet in the tool frame has engaged sufficiently to hold the die in place, then tighten both die retaining screws.
5. To disassemble, close the tool handles until the ratchet releases, remove the two die retaining screws, and slide the dies out of the tool jaws.

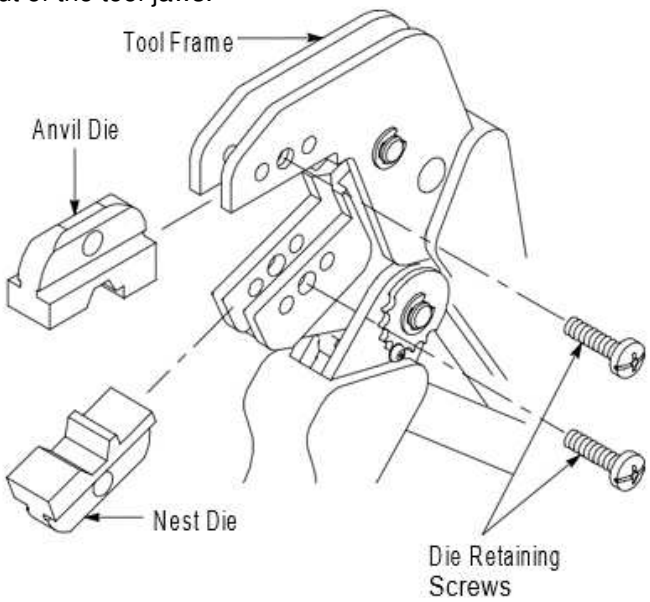


Figure 2

4. CRIMPING PROCEDURE (FIGURE 3)

NOTE
Before using the tool, the crimping chamber and tool ratchet should be inspected as specified in Paragraph 5, Measuring Die Opening, and Paragraph 6, Ratchet Adjustment.

Strip cable according to the proper dimensions and assemble the connector to the cable according to the instructions in the appropriate connector instruction sheet. Then proceed as follows

1. Slide the ferrule forward over the braid until the ferrule butts against the shoulder on the connector body.
2. Place the ferrule on the nest of the die assembly so that the shoulder on the connector body is butted against the die. See Figure 3.
3. Holding the assembly in place, close the tool handles until the ratchet releases.
4. Allow the tool handles to open and remove the crimped assembly from the crimping die.

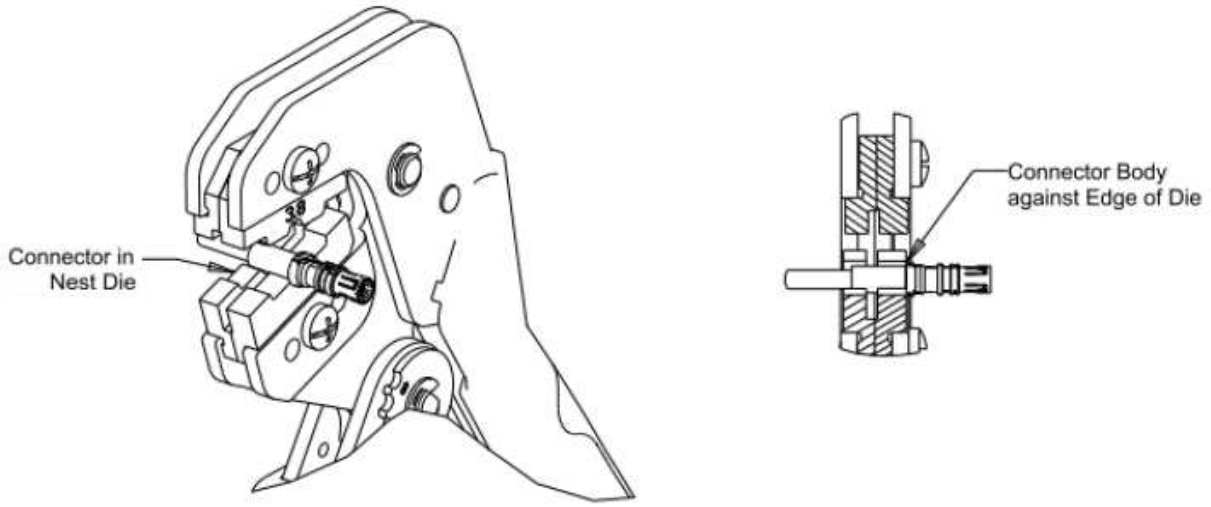


Figure 3

5. MEASURING DIE OPENING (FIGURE 4)

The die assembly will perform correctly as long as:

1. The product specified is correct for the application.
2. The specific die assembly is used.
3. The die assembly has been measured to ensure that the opening is correct.
4. The tool has been adjusted correctly.

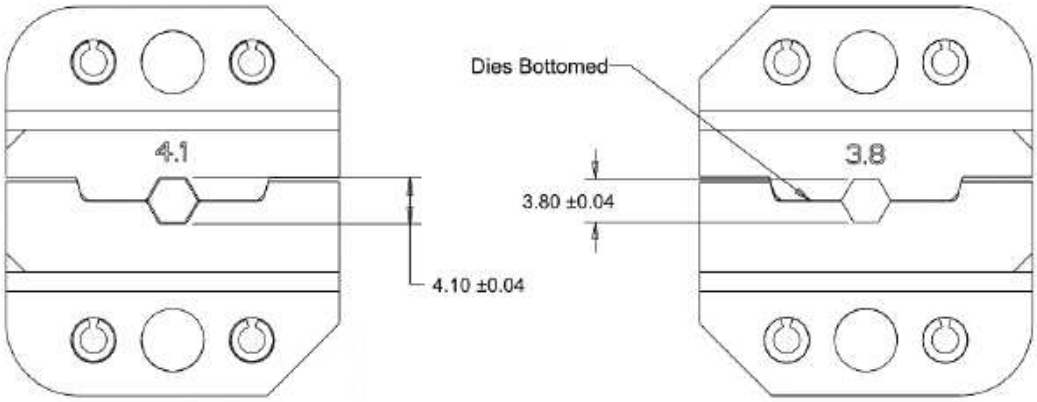


Figure 4

6. RATCHET ADJUSTMENT (FIGURE 5)

The ratchet mechanism features an adjustment wheel with eight settings. The adjustment wheel controls the amount of handle pressure exerted on the tool jaws and crimping dies during crimping. If the crimp is not acceptable, adjust the ratchet as follows:

1. Sufficiently loosen the screw at the ratchet adjustment wheel so that the wheel can be rotated above the post that engages the teeth in the wheel.
2. If the crimp is too loose, turn the wheel to a higher notch (for example, if the wheel is set at notch 5, move the wheel to notch 6). If the crimp is too tight, move the wheel to a lower notch.
3. Tighten the screw at the ratchet adjustment wheel.

If the crimp cannot be made to conform to the dimensions provided in the appropriate product application specification, the tool and/or dies are defective and must be replaced.

NOTE
Other dies for PRO- CRIMPER III hand tool frames may be used in this tool; however, the ratchet adjustment wheel may require adjustment to achieve acceptable crimp height.

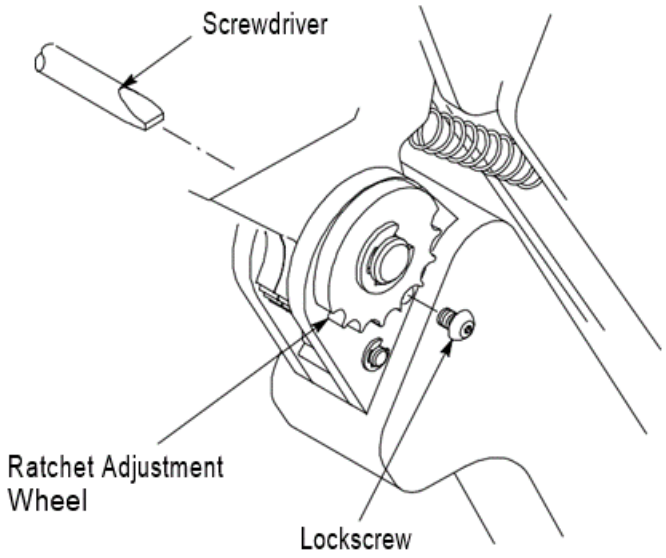


Figure 5

7. MAINTENANCE AND INSPECTION

The tool and dies are inspected before shipment. TE Connectivity (TE) recommends that the tool and die be inspected immediately upon arrival at the facility of use to ensure that it has not been damaged during shipment.

7.1. Daily Maintenance

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

- Remove dust, moisture, and contaminants with a clean, soft brush or a lint-free cloth. DO NOT use objects that could damage the tool and die components.
- Inspect the crimp sections for flattened, chipped, worn, or broken areas. If damage or abnormal wear is evident, the dies must be replaced. Refer to Section 8, REPLACEMENT AND REPAIR.
- When the tool and die are not in use, store in a clean, dry area.

7.2. Periodic Inspection

Regular inspections should be performed by quality control personnel. A record of scheduled inspections should remain with the tool or be supplied to personnel responsible for the tool. Inspection frequency should be based on amount of use, working conditions, operator training and skill, and established standards.

8. REPLACEMENT AND REPAIR

If dies are damaged or worn excessively, they must be replaced by TE Connectivity to ensure quality and reliability. Order replacement parts through your TE representative, or call 1-800-526-5142, or send a facsimile of your purchase order to 717-986-7605, or write to:

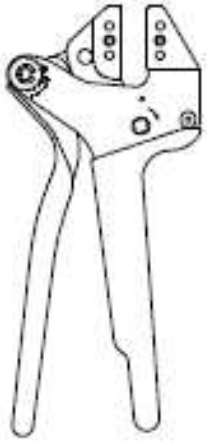
CUSTOMER SERVICE (038-035)
TE CONNECTIVITY CORPORATION
PO BOX 3608
HARRISBURG PA 17105-3608

9. REVISION SUMMARY

- Initial release of the document.

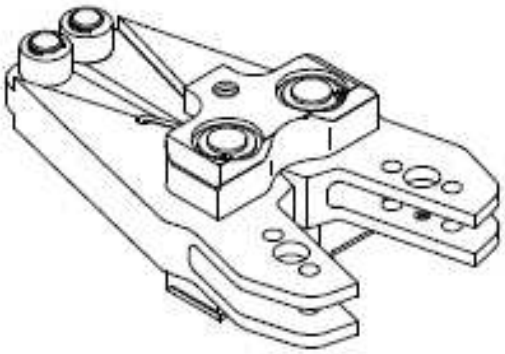
PRO-CRIMPER III Hand Tool 354940-1
(Instruction Sheet 408-9930)

SDE-SA Hand Tool 9-1478240-0
(Instruction Sheet 408-8851)

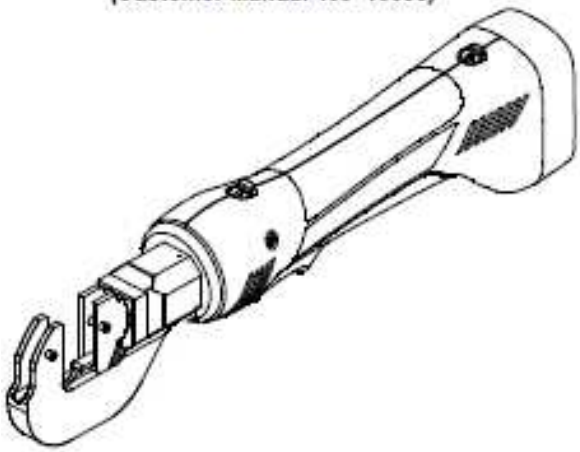


SDE Bench Terminator 1490076-2*
(Customer Manual 409-10052)
*OBSOLETE PART NUMBER

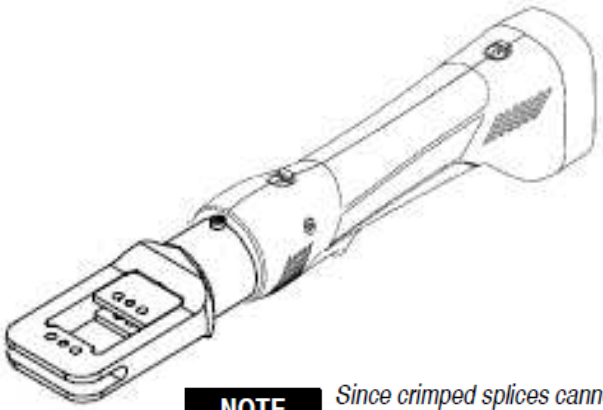
626 Adapter 679304-1
(Instruction Sheet 408-4070)



Battery Tool (Shouldered Die) 1725837-1, -2
(Customer Manual 409-10053)



Battery Tool (Pin/Shoulder Die) 1213890-1, -2
(Customer Manual 409-10065)



NOTE

*Since crimped splices cannot be removed from this tool, **DO NOT** crimp splices in this battery tool.*

Figure 6