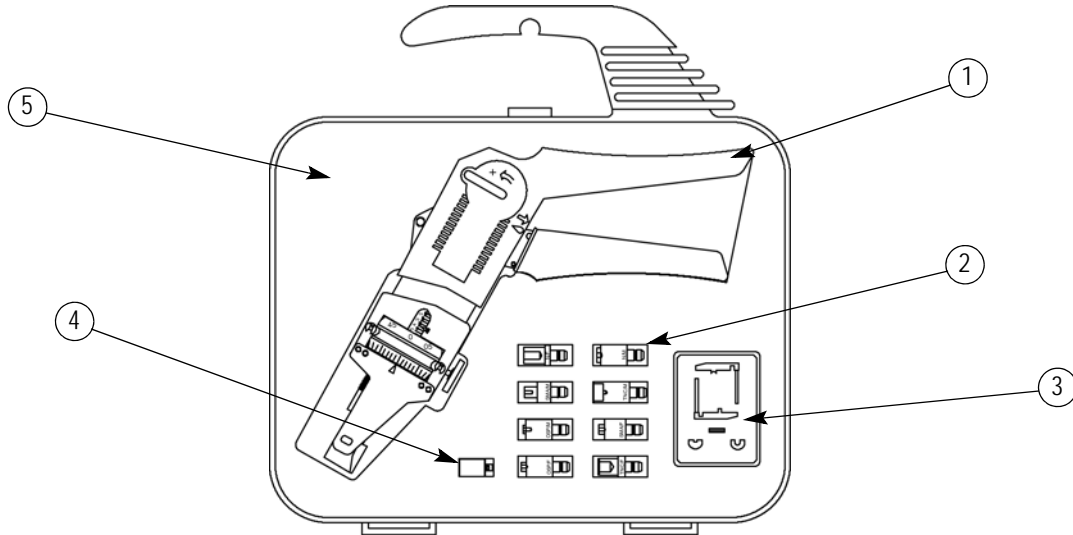


PROPER USE GUIDELINES

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.



UNIVERSAL COMPRESSION CRIMP TOOL KIT 1055835-1

ITEM NO.	PART NO.	DESCRIPTION	QTY PER KIT
1	1055831-1	Crimp Frame	1
2	--	Anvils[†]	--
	1055836-1	SMA Plug Anvil (SMA/M)	1
	1055837-1	SMA Jack Anvil (SMA/F)	1
	1055838-1	Type N Plug Anvil (N/M)	1
	1055839-1	Type N Jack Anvil (N/F)	1
	1055840-1	TNC Plug Anvil (TNC/M)	1
	1055841-1	TNC Jack Anvil (TNC/F)	1
	1055842-1	OSP Plug Anvil (OSP/M)	1
3	--	Cable Supports	--
	1055833-1	3.58 [.141] Cable Support	1 Set
	1055834-1	2.16 [.085] Cable Support	1 Set
4	1055832-1	Calibration Gage	1
5	--	Carrying Case	1

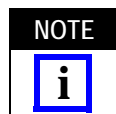
[†] Each anvil contains the appropriate connector marking.

Figure 1

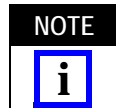
1. INTRODUCTION

Universal Compression Crimp Tool Kit 1055835-1, shown in Figure 1, contains everything necessary to crimp the connectors in Figure 2 to semi-rigid cable.

Reasons for revision are provided in Section 8, REVISION SUMMARY.



Dimensions are in metric units [with U.S. customary units in brackets], unless otherwise indicated. Figures and illustrations are for reference only and are not drawn to scale.



This document is for reference only. Refer to specific connector instructions for connector assembly.

CONNECTOR PART NO.	MILITARY PART NO. MIL-C-39012	CRIMP LENGTH mm [In.]	ANVIL
1331197-1	--	11.2 [.440]	SMA/M
1050586-1	--	11.2 [.440]	
1050591-1	--	"5.82 [.229]"	
1044459-1	--	6.86 [.270]	
1050598-1	--	7.06 [.278]	
1044830-1	--	5.84 [.230]	
1044831-1	--	5.84 [.230]	
1050740-1	--	6.86 [.270]	
1050742-1	--	11.2 [.440]	
1050744-1	--	11.2 [.440]	
1050791-1	/92-3201	6.86 [.270]	
1089686-1	/79-3003	11.2 [.441]	
1050792-1	/79-3004	11.2 [.441]	
1050793-1	/79-3007	11.2 [.441]	
1050794-1	/79-3208	11.2 [.441]	
1050796-1	/92-3101	6.86 [.270]	
1050797-1	/79-3101	11.2 [.441]	
1050799-1	/79-3104	11.2 [.441]	
1050800-1	/79-3307	11.2 [.441]	
1050801-1	/79-3308	11.2 [.441]	
1050808-1	/92-3001	6.86 [.270]	
1080522-1	--	14.4 [.568]	
1051118-1	--	14.4 [.568]	
1051145-1	--	14.4 [.568]	
1051147-1	--	14.4 [.568]	
1059398-1	--	16.9 [.667]	
1059399-1	--	16.9 [.667]	
1050932-1	/81-3003	13.5 [.530]	
1050933-1	/81-3004	13.5 [.530]	
1050934-1	/81-3207	13.5 [.530]	
1050935-1	/81-3208	13.5 [.530]	
1051004-1	--	14.5 [.569]	
1051007-1	--	14.5 [.569]	
1051030-1	/83-3003	14.5 [.569]	
1051031-1	/83-3004	14.5 [.569]	
1051032-1	/83-3207	13.4 [.529]	
1051079-1	/83-3208	13.5 [.530]	
1051080-1	--	13.5 [.530]	
1051095-1	/82-3003	13.5 [.530]	
1051096-1	/82-3004	13.5 [.530]	
1051097-1	/82-3207	13.5 [.530]	
1051098-1	/82-3208	13.5 [.530]	
			OSP/M
			SMA/F

Figure 2 (Cont'd)

CONNECTOR PART NO.	MILITARY PART NO. MIL-C-39012	CRIMP LENGTH mm [In.]	ANVIL
1057077-1	--	20.6 [.811]	N/M
1057079-1	--	20.6 [.811]	
1057147-1	--	21 [.825]	N/F
1057149-1	--	21 [.825]	
1057624-1	--	19.3 [.761]	TNC/M
1057625-1	--	19.3 [.761]	
1057670-1	--	20 [.788]	TNC/F
1057671-1	--	20 [.788]	
1059408-1	--	18 [.710]	OSP/F
1059409-1	--	18 [.710]	
1059451-1	--	19.6 [.770]	
1059452-1	--	19.6 [.770]	

Figure 2 (End)

2. DESCRIPTION

Universal Compression Crimp Tool Kit 1055835-1 consists of eight marked crimping dies for SMA, N, TNC, and OSP connectors. The kit contains two cable supports: a 3.58 [.141] semi-rigid cable support; and a 2.15 [.085] semi-rigid cable support. See Figure 1. The kit also contains a calibration gage.

The crimp tool contains a piston that drives the anvil into the connector, and handles that power the piston. The safety release is capable of locking the handles. A thumb screw locks the adjustment wheel, which is used to set the crimp height. Crimp height can be read on the rough scale and on the fine adjustment scale next to the adjustment wheel. See Figure 3.

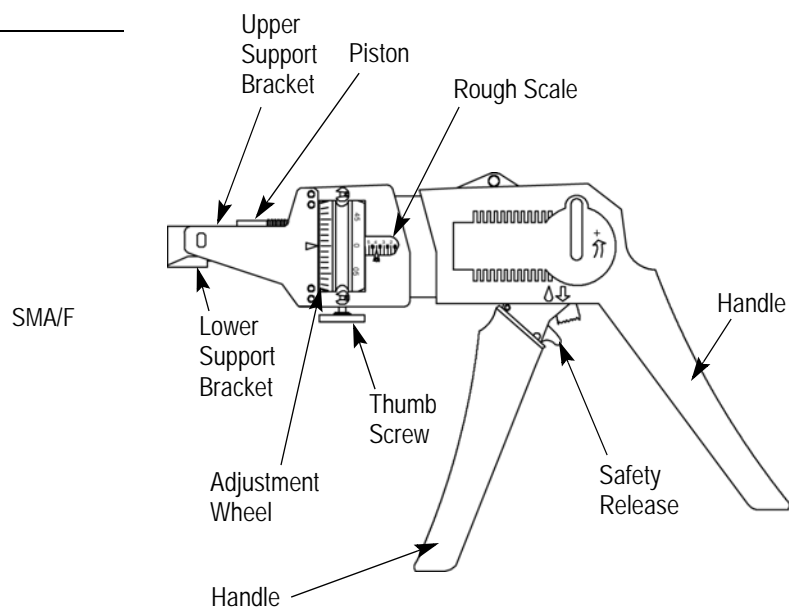


Figure 3

3. CALIBRATION

The compression crimp tool must be calibrated before it is set up and operated.

The adjustment mechanism is similar to that of a typical micrometer except that each full rotation of the adjustment wheel is 1.27 [.050]. Each graduation of the rough scale is 1.27 [.050]. Each graduation of the scale on the adjustment wheel is 0.0254 [.001].

1. Remove the tool from the carrying case and squeeze the handles to release the ratchet. The crimp tool should now be open.
2. Loosen the thumb screw (Figure 3).
3. Turn the adjustment wheel to set a crimp length of .150 in. minimum. See Figure 4.
4. Squeeze the handles and insert the calibration gage into the piston of the crimp tool, so that the pin of the calibration gage is engaged in the slot of the piston.
5. Insert the appropriate lower cable support into the cable support bracket.

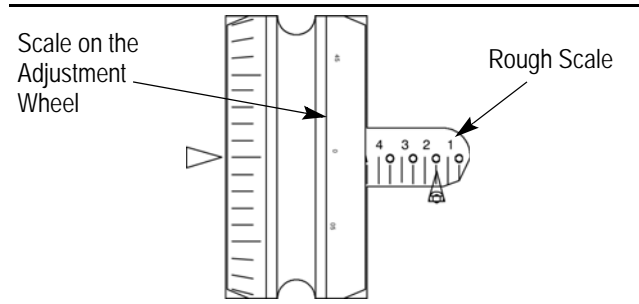


Figure 4

NOTE *The cable support for the 3.58 [.141] diameter semi-rigid cable has a larger slot than the support for 2.15 [.085] diameter semi-rigid cable.*

6. Turn the adjustment wheel until the crimp length on the rough scale and the length on the adjustment wheel are set at "0."
7. Tighten the thumb screw.
8. Slowly squeeze the handles to the sixth "click" of the ratchet. Maintain pressure on the handles to keep them fully closed.

NOTE *It may be necessary to turn the calibration gage so that it backs away from the lower support in order to be able to activate the crimp tool to the sixth "click."*

9. Turn the calibration gage so that it is resting firmly against the lower cable support.
10. Release the handles of the crimp tool. The tool should now be fully open.
11. Carefully remove the calibration gage. Do not rotate the gage during removal.

Calibration is now complete.

4. SETUP

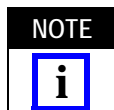
1. Calibrate the tool as described in Section 3, CALIBRATION.
2. Loosen the thumbscrew (Figure 3).
3. Turn the adjustment wheel to set a crimp length of .150 in. minimum. See Figure 4.
4. Select the proper anvil to be crimped to the connector (Figure 2). The anvils are identified as follows:
 - SMA/M = SMA male or plug interface
 - SMA/F = SMA female or jack interface
 - N/M = Type N male or plug interface
 - N/F = Type N female or jack interface
 - TNC/M = TNC male or plug interface
 - TNC/F = TNC female or jack interface
 - OSP/M = OSP male or plug interface
 - OSP/F = OSP female or jack interface

NOTE *The anvil type is clearly marked on each anvil.*



5. Insert the anvil (pin first) into the piston of the crimp tool.

6. Turn the adjustment wheel to set the appropriate crimp length. See Figure 2 for a listing of typical crimp lengths.



Crimp length is defined as the distance from the reference plane at the interface to the back of the connector after crimping. Exceptions to the crimp length definition include: crimp length on OSP female connectors, where the crimp length distance is from the front of the housing to the back of the connector; and crimp length on right-angle connectors, where the crimp length distance is from the top of the housing to the back of the connector after crimping.

The setup procedure is now complete

5. CRIMP PROCEDURE

1. Carefully crimp the first assembly with the new tool setting.



Improper crimp length could damage the cable support.



Never re-terminate a used or damaged connector.



If the crimp cycle is interrupted, be sure to press the safety release on the inside of the handles.

2. Proceed as follows:

- a. Assemble the prepared cable into the connector, bottoming the cable onto the cable reference plane. Refer to the appropriate connector instructions for cable preparation.
- b. Position the connector onto the anvil. Be sure that the connector reference plane is properly seated against the anvil (center contacts and/or dielectrics that protrude past the connector reference plane should be seated into the hole in the anvil). The cable should then rest in the lower cable support.

NOTE For right-angle connectors, bottom on the flat section of the housing as shown in Figure 5.

3. To properly crimp connectors requiring 3605 of coverage, perform the following steps:

- If necessary, remove the rubber stops from the upper cable support.
- Insert the upper cable support into the slot of the support bracket and place over the cable.
- Replace the rubber stop.

4. Gently push the cable toward the anvil and squeeze the handles of the crimp tool together until the ratchet releases.

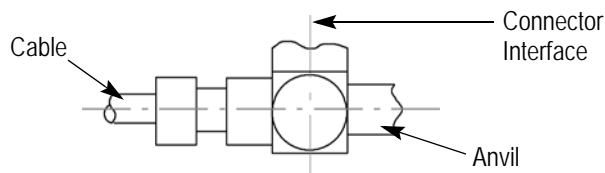


Figure 5

The crimp procedure is complete.

6. MAINTENANCE

It is recommended that a maintenance and inspection program be performed periodically to ensure dependable and uniform terminations.

Frequency of inspection should be adjusted to suit your requirements. Frequency of inspection depends on:

- The care, amount of use, and handling of the crimping head.
- The type and size of the product crimped.
- The degree of operator skill.
- The presence of abnormal amounts of dust and dirt.
- Your own established standards.

Each tool is thoroughly inspected before packaging. Since there is a possibility of damage during shipment,

new tooling should be inspected immediately upon arrival at your facility.

6.1. Daily Maintenance

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

1. Remove dust, dirt, and other contaminants with a clean brush, or a soft, lint-free cloth. Do NOT use objects that could damage the tooling.
2. Make certain the anvils are protected with a THIN coat of any good SAE 20 motor oil. Do NOT oil excessively.
3. When the tooling is not in use, store it in its carrying case.

6.2. Periodic Inspection

Regular inspections should be performed by quality control personnel. A record of scheduled inspections should remain with the kit and/or be supplied to supervisory personnel responsible for the crimp tool kit. Though recommendations call for at least one inspection a month, the inspection frequency should be based on the amount of use, ambient working conditions, operator training and skill, and established company standards. These inspections should be performed in the following sequence:

1. Remove all lubrication and accumulated film by immersing the anvils in a suitable commercial degreaser that will not affect paint or plastic material.
2. Make sure all holding screws, retaining rings, and components are in place. Refer to the drawings shipped with the tool if replacement parts are required.
3. Check components for wear. Remove and replace worn components.
4. Inspect the crimp area for flattened, chipped, cracked, worn, or broken areas. If damage is evident, the tooling must be repaired before returning it to service (see Section 7, REPLACEMENT AND REPAIR).

7. REPLACEMENT

Order replacement parts listed in Figure 1 through your TE Connectivity Representative, or call 1-800-526-5142, or send a facsimile of your purchase order to 1-717-986-7605, or write to:

CUSTOMER SERVICE (038-035)
 TYCO ELECTRONICS CORPORATION
 PO BOX 3608
 HARRISBURG PA 17105-3608

8. REVISION SUMMARY

- Updated company name and logo.