

Fig. 1

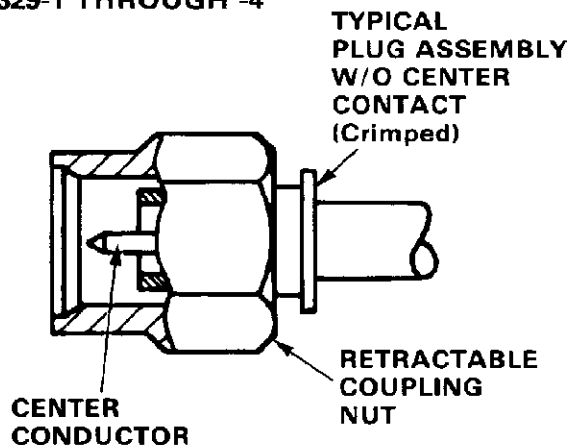
1. INTRODUCTION

AMP Die Set 59965-2, shown in Figure 1, is designed for use in AMP Pneumatic Tool 59964-1. The assembled tool is used to crimp SMA Series plugs with retractable coupling nuts to RG-402 (.141) semi-rigid coaxial cable shown in Figure 2. This instruction sheet (IS) provides recommended procedures for die installation. IS 6744, packaged with the tool, covers application and maintenance procedures for the pneumatic tool. Read all instructions thoroughly before proceeding.

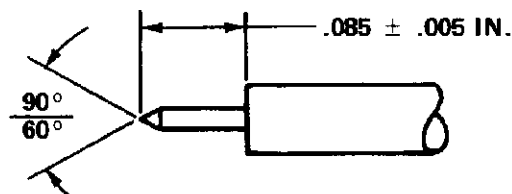
2. DESCRIPTION

The die set consists of a metal die and a spring

SMA PLUGS WITH RETRACTABLE COLLARS 227531-5 THROUGH -8 221329-1 THROUGH -4



RECOMMENDED STRIP LENGTH/POINTING



RG-402/U CABLE

Fig. 2

designed for each side of the tool, right side and left side. (Note that die "A" *must* be inserted into the left side of the tool, and die "B" into the right side.) The SMA Series plugs with retractable collars listed in Figure 2 *require* the use of Die Set 59965-2 for proper positioning and crimping. Each connector consists of a plug assembly (without center contact) and a retractable coupling nut. RG-402 cable must be properly stripped and pointed to ensure a sound connection. Refer to Figure 2 and to IS 6744.

3. DIE SET INSTALLATION

To install the die set in the pneumatic tool, refer to Figure 3 and proceed as follows:

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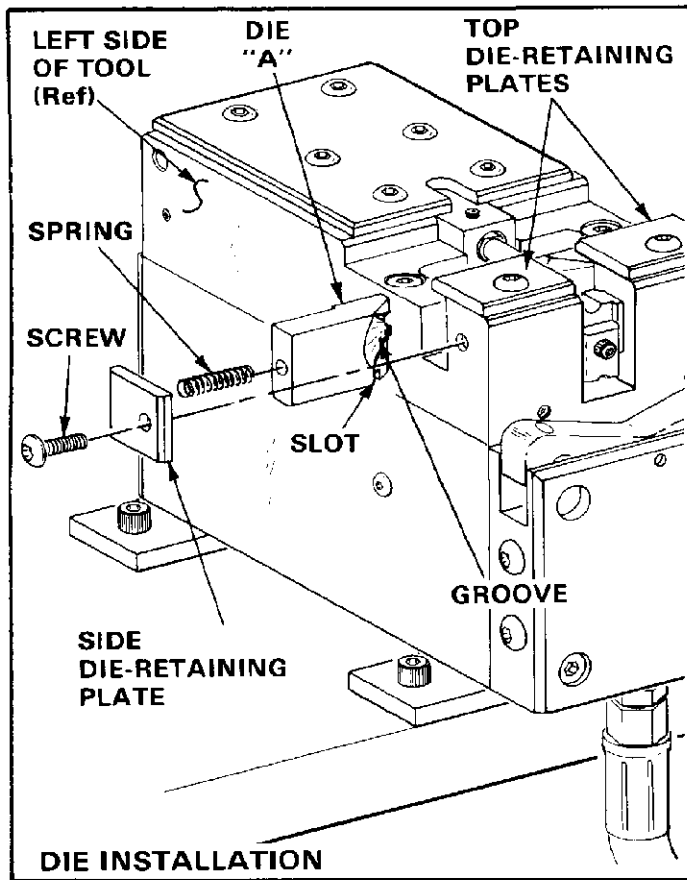


Fig. 3

1. Remove top and side die-retaining plates on left side of tool, as shown.
2. Insert spring into die "A" cavity.
3. Slide spring-loaded die "A" into left side of tool, making sure that slot on bottom of die straddles guide stop.

NOTE

Upper section of each die contains a tapered groove. When dies are positioned properly, the tapered groove on each die will face the operator. Refer to Figure 3.

4. Replace top and side plates on left side of tool, and ensure that spring seats squarely on side plate. Tighten screws.

5. Repeat Steps 1 through 4 for right side of tool to install die "B."

NOTE

The SMA plugs with retractable collars listed in Figure 2 require Tool Locator 220241-1 for proper positioning and crimping. Refer to IS 6744 for locator installation and application procedures.

4. TOOLING CERTIFICATION

The die set listed on this instruction sheet should be certified with the information provided in Figure 4. It is recommended that the die set be inspected upon its arrival at your location and at regularly scheduled intervals to ensure that dies have not become worn or damaged. Die sets should be mated and kept in a clean, dry location when not in use.

Customer-replaceable parts are listed in Figure 4. If die set parts become lost or damaged, they can be replaced by sending a purchase order with the die set number to:

AMP Incorporated
 Customer Repair
 1523 North 4th Street
 Harrisburg, PA 17102-1604

or a wholly-owned subsidiary of AMP Incorporated.

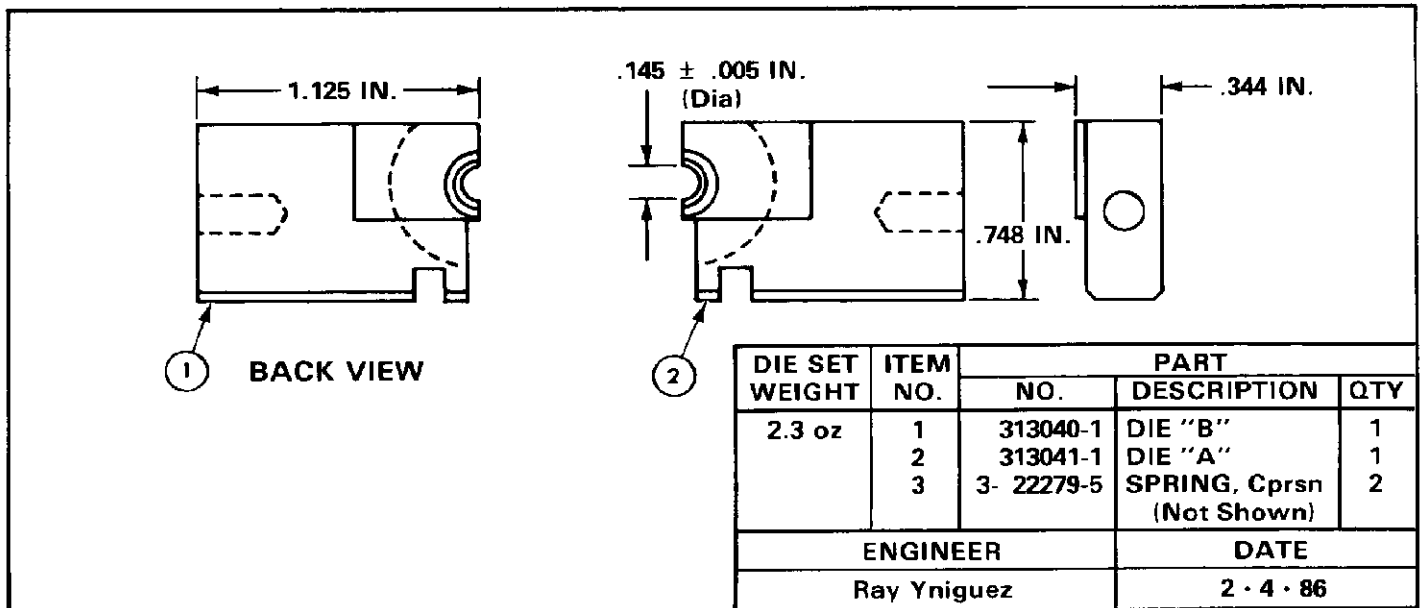


Fig. 4