

Figure 1

## 1. INTRODUCTION

90-Degree Snap-Lock Crimping Die Assembly 1338650-1 (shown in Figure 1) is designed to be used with PRO-CRIMPER\* III Hand Crimping Tool Frame Assembly 354940-1 to crimp the crimp claw of the right-angle ferrule for coaxial snap-lock cable connectors onto coaxial cable. Refer to Instruction Sheet 408-9930 for information concerning the tool frame assembly.

### NOTE



Dimensions in this instruction sheet are in millimeters [with inches in brackets]. Figures are not drawn to scale.

Reasons for reissue of this instruction sheet are provided in Section 7, REVISION SUMMARY.

## 2. DESCRIPTION

The die assembly consists of a nest die and an anvil die that when closed forms one crimping chamber. See Figure 1. Each die is secured in the tool by a single screw (included with tool).

## 3. DIE INSTALLATION (See Figure 2)

1. Install the anvil die in the moveable jaw of the tool frame. Align the screw hole of the die with the screw hole of the tool frame, then secure the die with the die retaining screw. DO NOT fully tighten the screw.

2. Secure the nest die in the stationary jaw of the tool frame using the die retaining screw. DO NOT fully tighten the screw.
3. Slowly cycle the tool, allowing the dies to align themselves. Then, cycle the tool until the dies are completely closed.
4. Securely tighten both die retaining screws.

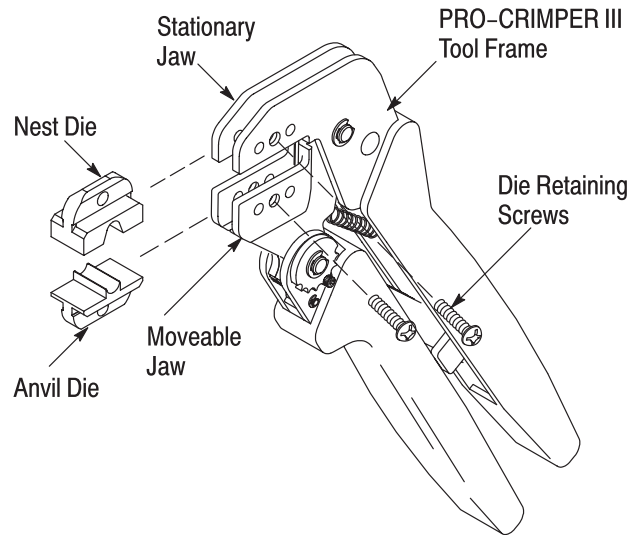


Figure 2

## 4. CRIMPING PROCEDURE

Refer to 408-4551 for cable strip length and assembly information for the connector; for detailed application requirements, refer to Application Specification 114-13010.

### NOTE



The center contact must be crimped onto the cable separately.

1. Crimp the straight portion of the ferrule according to 408-8589.
2. Assemble the connector according to 408-4551.
3. Place the crimp claw of the ferrule in the nest of the anvil die so that the shoulder of the connector butts against the edge of the die. See Figure 3.
4. Bend the cable and insert it into the crimp claw, while holding the connector at a 90° angle to the nest.
5. While holding the assembly together, cycle the tool until the dies have closed enough to hold the assembly in place.

6. Allow the dies to close fully, crimping the ferrule to the cable; then open fully so that the crimped connector can be removed from the dies.

**Note:** For clarity, die assembly shown not installed in tool

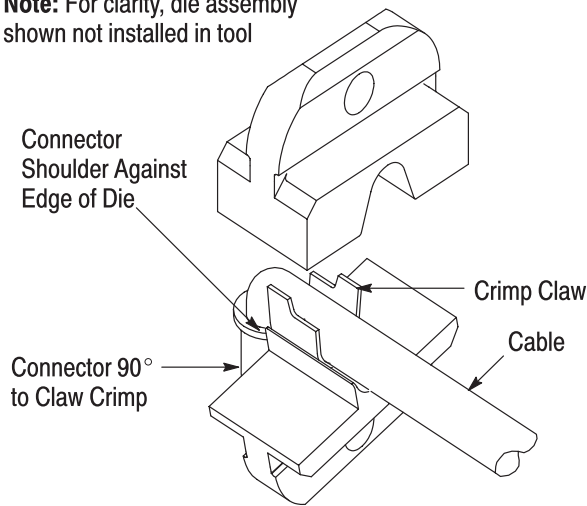


Figure 3

## 5. MAINTENANCE AND INSPECTION

### 5.1. Maintenance

1. Remove dust, moisture, and other contaminants with a clean, soft brush, or a clean, soft, lint-free cloth. DO NOT use any objects that could damage the dies or tool.
2. Make sure that the proper die retaining screws are properly secured.
3. When the dies are not in use, store them in a clean, dry area.

### 5.2. Inspection

The die assembly is inspected before shipment. It is recommended that the dies be inspected immediately upon arrival at your facility to ensure that the dies have not been damaged during shipment.

1. Remove all lubrication and accumulated film from the dies by immersing the dies in a suitable commercial degreaser.
2. Make certain that all die retaining screws and die components are properly secured.

3. Inspect the crimping surfaces for flattened, chipped, worn, or cracked areas. If damage is evident, the dies must be replaced. Refer to Section 6, REPLACEMENT.

### 5.3. Measuring Die Opening

The die assembly will perform correctly as long as: (1) the product is correct for the die assembly, (2) the tool has been adjusted correctly, and (3) the die opening is correct. Refer to Figure 4.

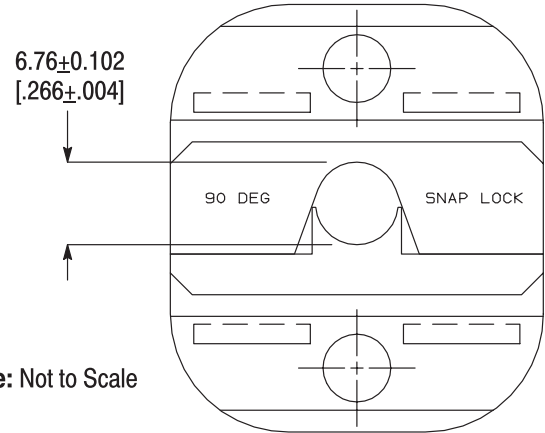


Figure 4

## 6. REPLACEMENT

Order die assemblies through your 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)  
TYCO ELECTRONICS CORPORATION  
PO BOX 3608  
HARRISBURG PA 17105-3608

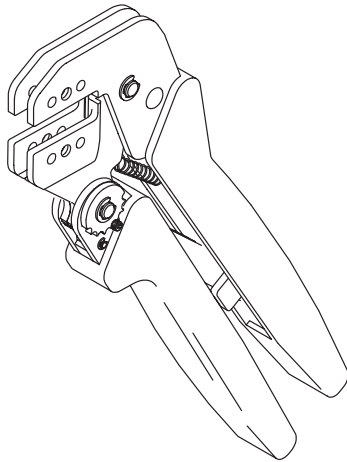
## 7. REVISION SUMMARY

Revisions to this instruction sheet include:

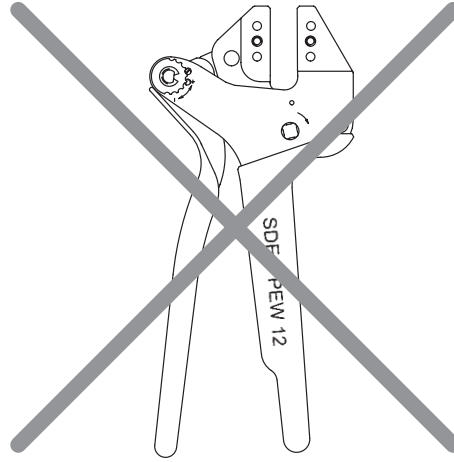
- Updated document to corporate requirements
- Added tool frame assembly
- Added text to Sections 1 and 2
- Modified Steps 2 and 3 of Section 3
- Added Figure 2

The die assembly will not fit properly into the crossed-out tools shown below.

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



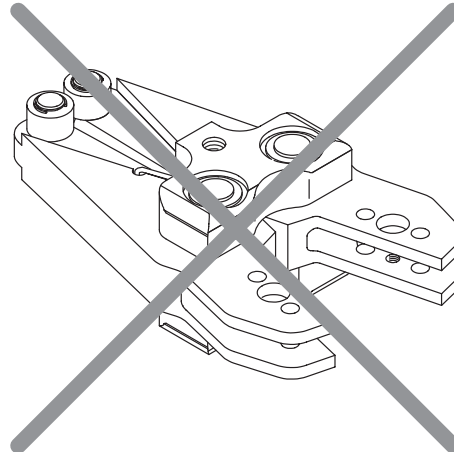
**SDE PEW-12 Hand Tool 9-1478240-0**  
(Instruction Sheet 408-8851)



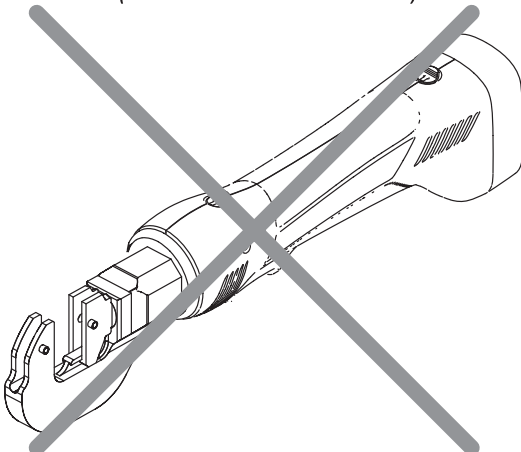
**SDE Bench Terminator 1490076-2**  
(Customer Manual 409-10052)



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



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



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

