

**PROPER USE GUIDELINES**

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

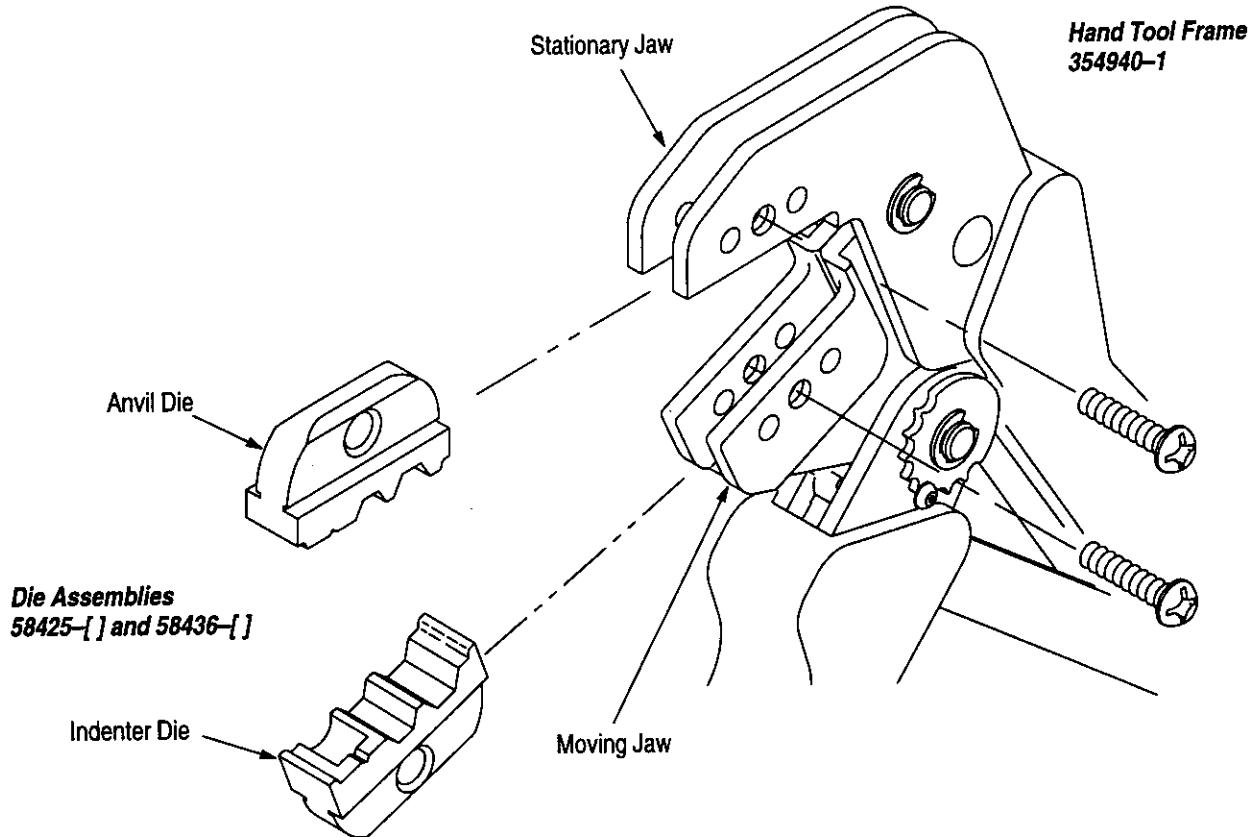


Figure 1

**1. INTRODUCTION**

This instruction sheet covers the use and maintenance of AMP Crimping Dies 58425 and 58436 (in their various configurations – denoted by the dash number following the base part number), used in AMP PRO-CRIMPER\* Hand Tool Frame 354940-1. The dies crimp AMP 75-Ohm Hex Crimp BNC and TNC plug connectors onto coaxial cable.

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

**NOTE**

*All dimensions are in millimeters [with inches in brackets].*

**2. DESCRIPTION (Figure 1)**

Each die assembly consists of an indenter die and an anvil die. When closed, the dies form either two or

three crimping chambers (depending on type) which crimp the center contact and ferrule of the connector onto the coaxial cable. Each die is held in the tool by a single screw.

**3. DIE INSTALLATION**

1. Close the tool handles until the ratchet releases and then allow them to open fully.
2. See Figure 1 for normal orientation of the dies. Insert the dies inside the tool jaws and align the retaining screw holes.
3. Thread the retaining screws into the holes and carefully close the tool handles. Tighten the screws with the appropriate hex wrench.

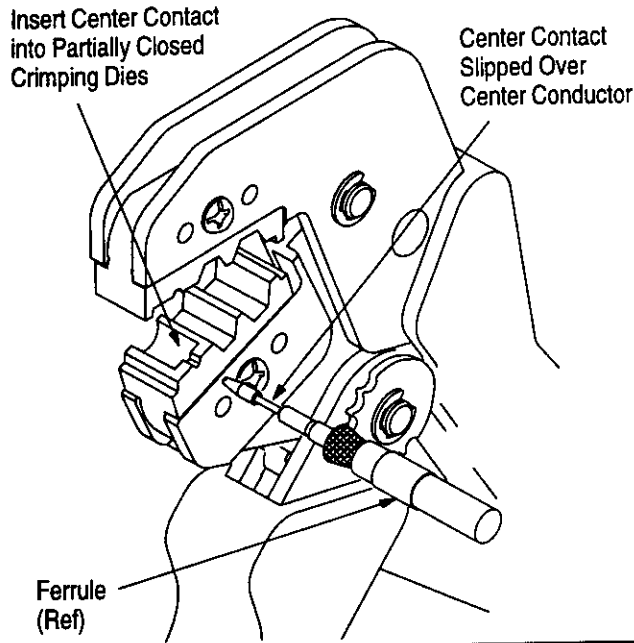


Figure 2

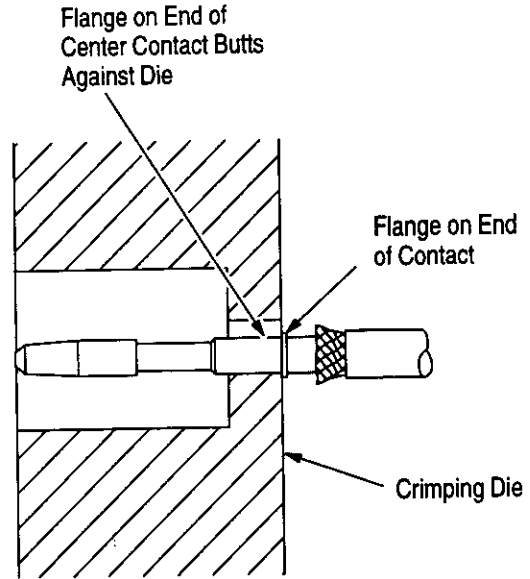


Figure 3

**4. CRIMPING PROCEDURE** (Figure 2)

**4.1. Center Contact**

1. Prepare the connector and the cable according to the instructions packaged with the connector.
2. Slide the center contact onto the center conductor of the cable; then insert the contact assembly into the center contact crimp section of the die.

**NOTE** *Make sure that the flange on the end of the center contact butts against the crimping die. See Figure 3.*

3. Crimp the center contact by holding the cable in place; then close the tool handles until the ratchet releases.

**4.2. Ferrule**

1. Insert the crimped center contact into the connector body until the cable dielectric butts against the dielectric inside of the connector body. The flared braid will then fit around the support sleeve of the connector body.
2. Slide the ferrule forward over the braid until the ferrule butts against the shoulder on the connector body.
3. Place the ferrule on the appropriate anvil of the die assembly so that the shoulder on the connector body is butted against the die. See Figure 4.
4. Holding the assembly in place, close the tool handles until the ratchet releases.

**5. INSPECTION**

**5.1. Visual Inspection**

Inspection of the crimping dies should be made on a regular basis to ensure that they have not become worn or damaged. 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 6, PARTS REPLACEMENT.

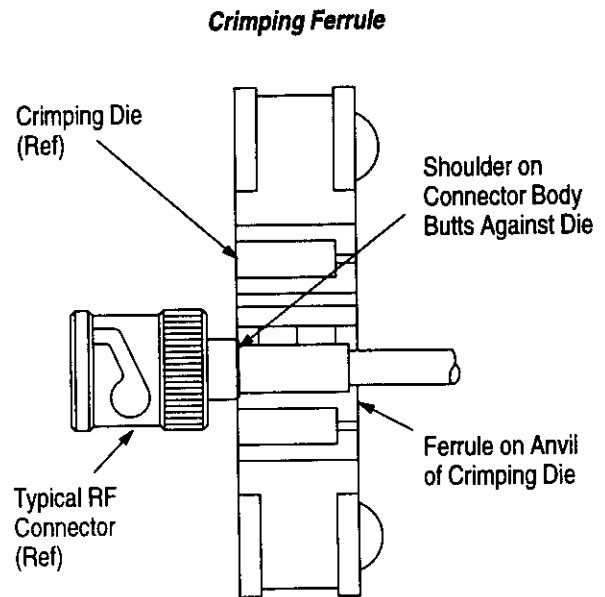
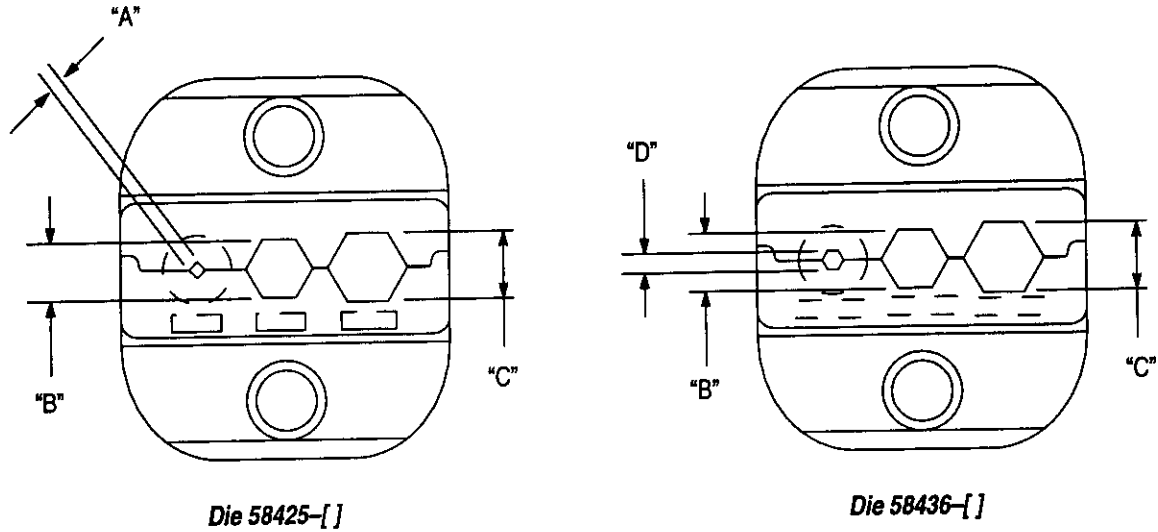


Figure 4



DIE ASSEMBLY PART NUMBER	CHAMBER CRIMP DIMENSION			
	"A" ±.10 [.004]	"B" ±.10 [.004]	"C" ±.10 [.004]	"D" ±.10 [.004]
58425-1	1.07 [.042] (square)	5.41 [.213] (hex)	6.48 [.255] (hex)	—
58425-2	1.07 [.042] (square)	3.25 [.128] (hex)	4.52 [.178] (hex)	—
58425-3	1.07 [.042] (square)	3.84 [.151] (hex)	8.23 [.324] (hex)	—
58436-1	—	5.41 [.213] (hex)	6.48 [.255] (hex)	1.73 [.068] (hex)
58436-2	—	2.54 [.100] (hex)	8.23 [.324] (hex)	1.73 [.068] (hex)
58436-3	—	3.84 [.151] (hex)	4.52 [.178] (hex)	1.73 [.068] (hex)

Figure 5

**5.2. Measuring Die Opening**

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 openings are correct, and (4) the tool has been adjusted correctly.

Figure 5 provides information on die opening sizes.

**5.3. Ratchet Adjustment**

The tool frame assembly 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 no. 5, move the wheel to notch no. 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 of the PRO-CRIMPER hand tool series may be used in this tool; however, the ratchet adjustment wheel may require adjustment to achieve acceptable crimp height.

**6. PARTS REPLACEMENT**

Customer-replaceable parts are shown in Figure 1. Available separately, AMP PRO-CRIMPER II Repair Kit 679221-1 includes a variety of pins, rings, screws, and springs. If the dies are damaged or worn excessively, they must be replaced. Order the repair kit and replaceable parts through your AMP 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 (38-35)  
AMP INCORPORATED  
P.O. BOX 3608  
HARRISBURG, PA 17105-3608

**7. REVISION SUMMARY**

Since the previous release of this sheet, the following changes were made:

Per EC A-3637-92:

- Obsoleted PN 58426-[ ] and related information
- Obsoleted PN 58425-4 in Figure 5

Per EC 0150-3375-95:

- Changed tolerance specified for dimensions "A" and "D" from  $\pm.05$  [.002] to  $\pm.10$  [.004] in Figure 5