

Figure 1

### 1. INTRODUCTION

Crimping Die Assembly 1338120-1 is designed to crimp Coaxial Snap-Lock 90° and Straight Cable Ferrules. Refer to Instruction Sheet 408-4551 for information concerning Coaxial Snap-Lock Cable Plug Connectors.

### 2. DESCRIPTION

The die assembly consists of an indenter die and an anvil die, which when closed form two crimping chambers. Each of the two crimping chambers are capable of crimping the ferrule of the connector onto the coaxial cable.

Each die is secured in the tool by a single screw. Refer to Figure 1.

### 3. DIE INSTALLATION

1. Install anvil die in the tool frame. Align the die with the retaining screw hole, then secure die with the die retaining screw. Do NOT fully tighten.
2. Install indenter die in the tool frame. Slowly cycle the tool, allowing the dies to align themselves.
3. Cycle the tool until the dies are completely closed.
4. Securely tighten both die holding screws.

### 4. CRIMPING PROCEDURE

Select the appropriate cable size and connector. The wire size and insulation diameter must be within the specified range for the connector.

For detailed information on cable strip lengths and proper assembly of the connector, refer to the instructions packaged with the connector. If available, refer to 408-4551, *Coaxial Snap-Lock Cable Plug Connectors*, and 114-13010, *Coaxial Snap-Lock Connectors*.

**NOTE**

*The center contact is crimped onto the cable separately. These dies are used to crimp the ferrules onto the cable.*

1. Refer to 408-4551 to assemble the connector.
2. Place the ferrule in appropriate crimping chamber of the anvil die so that the shoulder on the connector body butts against the edge of the die.

**NOTE**

*Refer to the instruction sheet packaged with the connector to determine the appropriate crimping chamber for the ferrule.*

3. While holding the assembly together, begin to cycle the tool so that the dies begin to close. Continue to hold the assembly until the dies have closed enough to clamp the assembly in place.

**CAUTION**

*Make sure that both sides of the ferrule are started evenly into the crimping chamber. Do NOT attempt to crimp an improperly positioned ferrule.*

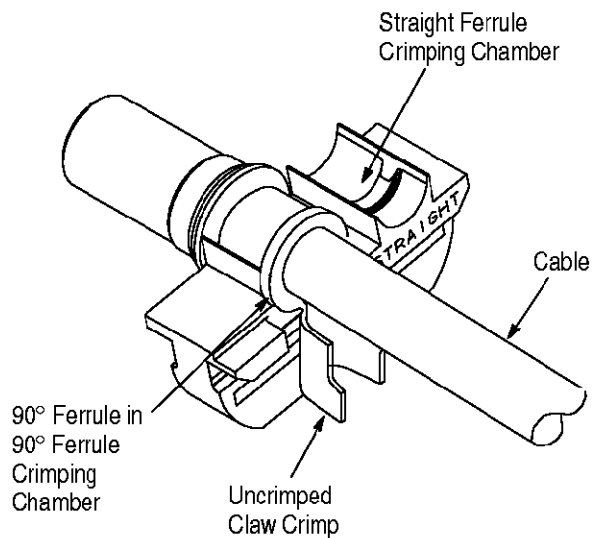


Figure 2

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

**5. MAINTENANCE AND INSPECTION**

**5.1. Maintenance**

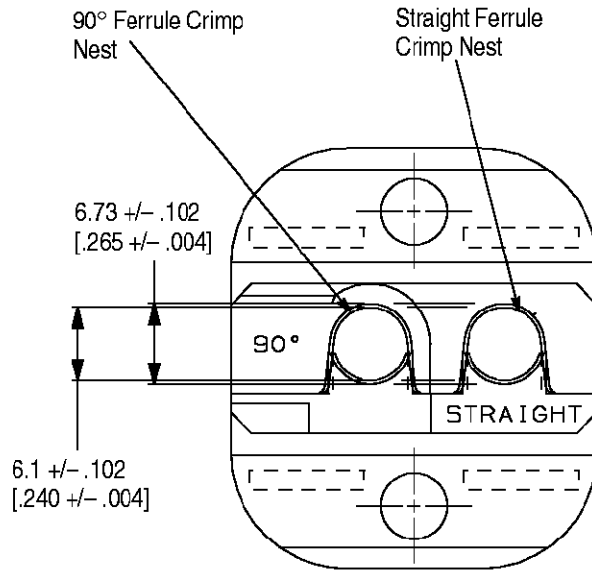
1. Remove dust, moisture, and other contaminants with a clean, soft brush, or a clean, soft, lint-free cloth. Do NOT use any objects that could damage the dies or tool.
2. Make sure that the proper die retaining screws are properly secured.
3. When the dies are not in use, store them in a clean, dry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

**5.2. Inspection**

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 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 3 provides information on die opening sizes.



**NOTE:** Not To Scale

Figure 3

**6. REPLACEMENT**

Crimping Die Assembly 1338120-1 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.

Order replacements through your local Tyco Electronics 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)  
TYCO ELECTRONICS CORPORATION  
P.O. BOX 3608  
HARRISBURG, PA 17105-3608

**7. REVISION SUMMARY**

Per EC 0990-1149-01

- Initial release of instruction sheet