

Figure 1

1. INTRODUCTION

Crimping Die Assembly 1338650-1 is designed to crimp 90° Coaxial Snap-Lock Cable Crimp Crimp Claw Connector 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 one crimping chamber. The crimping chamber crimps the crimp claw of the connector onto coaxial cables.

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

The straight portion of the 90° ferrule must be crimped first. Refer to Instruction Sheet 408-8589.

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 90° claw portion of the ferrules onto the cable.*

1. Refer to 408-4551 to assemble the connector.
2. Place the crimp claw in the crimping chamber of the anvil die so that the connector body butts against the edge of the die.
3. Bend the cable and insert it into the claw portion of the ferrule, while holding the connector at a 90° angle to the crimp nest.
4. 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.
5. 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.

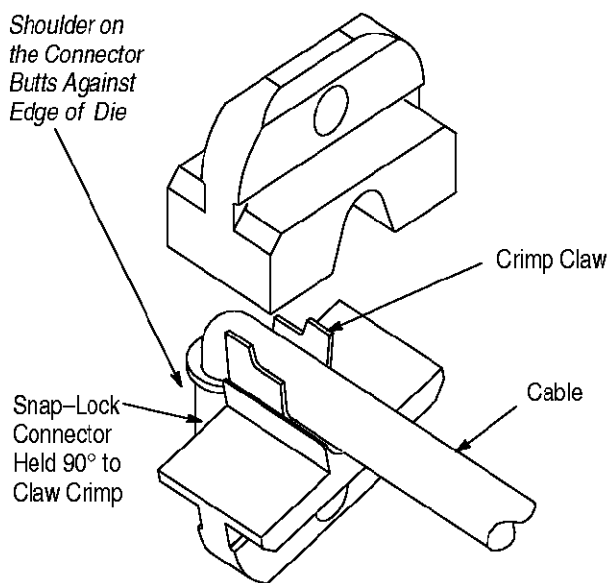


Figure 2

5. MAINTENANCE AND INSPECTION

5.1. Maintenance

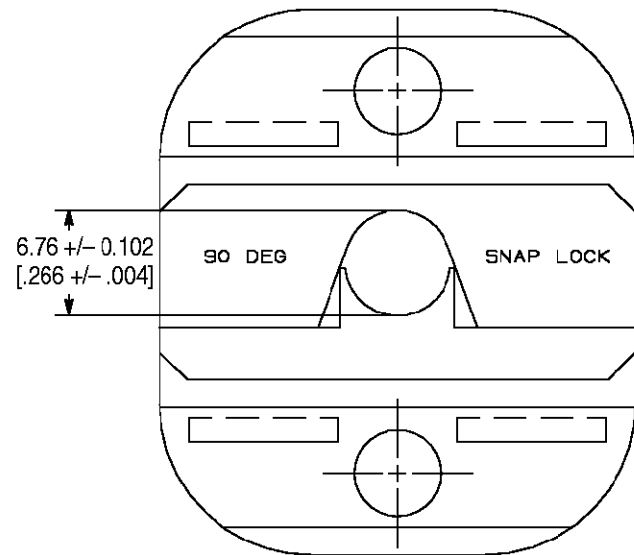
1. Remove dust, moisture, and other contaminants with a clean, soft brush, or a clean, soft, lint-free cloth. Do NOT use any objects that could damage the dies or tool.
2. Make sure that the proper die retaining screws are properly secured.
3. When the dies are not in use, store them in a clean, dry 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 1338650-1 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 0990-1150-01

- Initial release of instruction sheet