

PROPER USE GUIDELINES

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

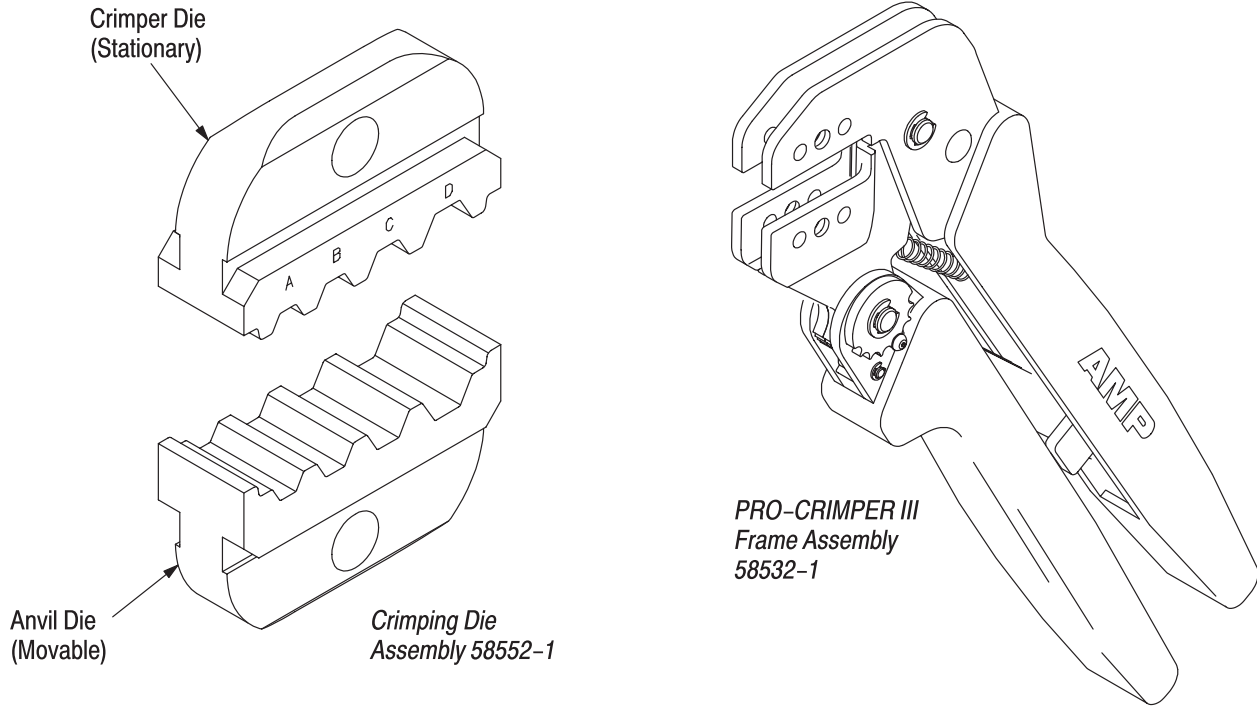


Figure 1

1. INTRODUCTION

This instruction sheet provides application and maintenance procedures for PRO-CRIMPER III Hand Tool Assembly 58551-1 and Crimping Die Assembly 58552-1. See Figure 1. The hand tool consists of the die assembly and PRO-CRIMPER III Hand Tool Frame Assembly 58532-1, and crimps STC Fiber Optic Connectors. The die assembly can be purchased separately, or purchased with the hand tool.

The information on connector part numbers and connector assembly procedures, refer to the appropriate instruction sheet packaged with the connector.

NOTE *All dimensions in this document are in millimeters [with inches in brackets]. Figures and Illustrations are for reference only and are not drawn to scale.*

Refer to Instruction Sheet 408-4020 for information concerning the use and maintenance of Hand Tool Frame Assembly 58532-1. Read these and all referenced materials before using the die assemblies.

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

2. DESCRIPTION

The die assembly features an anvil die and a crimper die. When closed, the dies produce four crimping chambers that crimp the ferrule of the connector onto the fiber-optic cable. Each die is held in the tool jaws with a single die-retaining screw. See Figure 2.

3. DIE INSTALLATION (Figure 2)

1. Close the tool handles until the ratchet releases; then allow the tool handles to open FULLY.
2. Install anvil die in the moving jaw of the hand tool. Align the die with the retaining screw hole; then secure die with the button head cap screw. Do NOT fully tighten.
3. Install crimper die in the stationary jaw of the hand tool. Slowly close the tool handles, allowing the die to align itself with the upper die. When dies are properly aligned, securely tighten both screws.

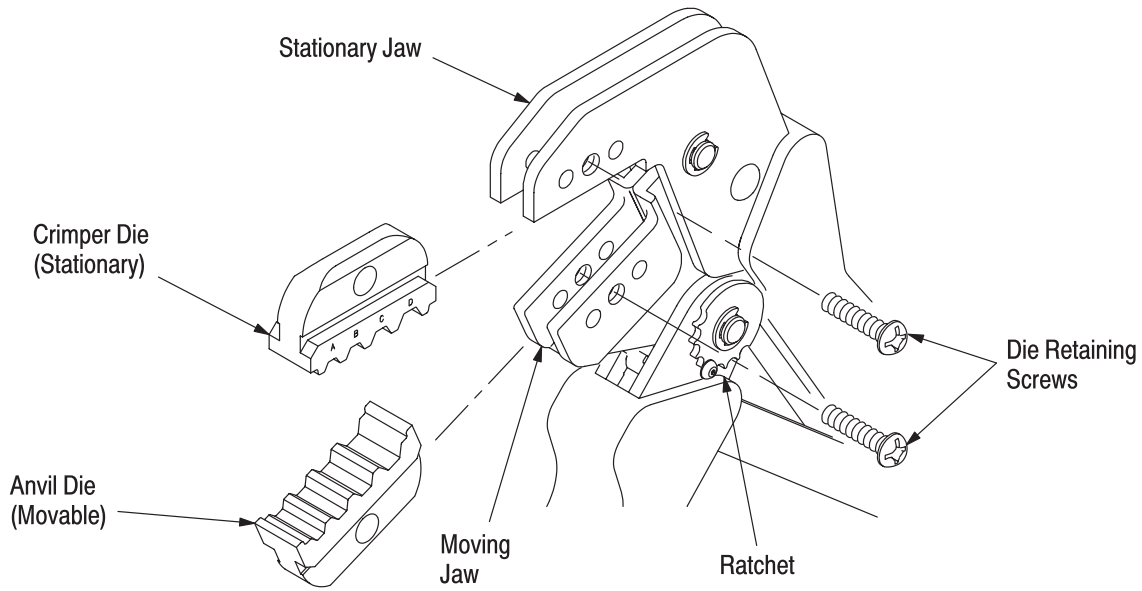


Figure 2

4. CRIMPING PROCEDURE (Figure 3)

Prepare connector and cable according to the instructions packaged with the connector, and proceed as follows:

1. Close the tool handles until the ratchet releases; then allow the tool handles to open FULLY.
2. Place connector in the appropriate crimping section of dies as shown in Figure 3.
3. Close the tool handles until the ratchet releases; then open the tool handles to remove the crimped connector.

2. Make certain that all die-retaining screws and die components are properly secured.

5. MAINTENANCE/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.
4. Store the tool with the tool handles closed to prevent objects from becoming lodged within the jaws.

5.2. Inspection

1. Remove all lubrication and accumulated film from the dies by immersing the dies in a suitable commercial degreaser.

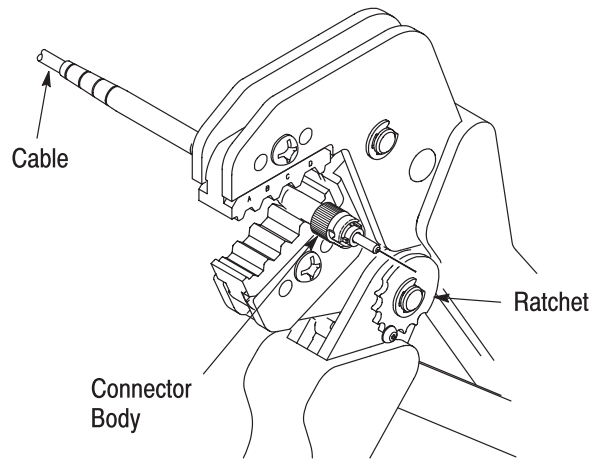


Figure 3

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 5 provides information on die openings.

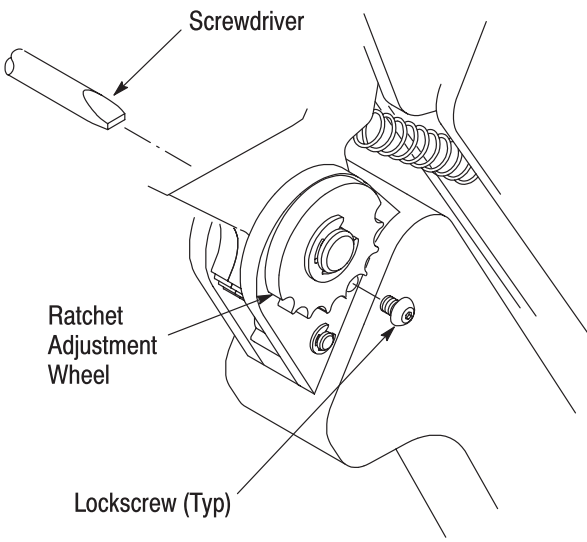


Figure 4

5.4. Ratchet Adjustment (Figure 4)

The tool frame assembly ratchet mechanism features an adjustment wheel with eight settings. If the crimp is not acceptable, adjust the ratchet as follows:

1. Remove the lockscrew from the ratchet adjustment wheel.
2. With a screwdriver, adjust the ratchet wheel from the opposite side of the tool.
3. Observe the ratchet adjustment wheel. If a tighter crimp is required, rotate the adjustment wheel COUNTERCLOCKWISE to a

higher-numbered setting. If a looser crimp is required, rotate the adjustment wheel CLOCKWISE to a lower-numbered setting.

4. Replace the lockscrew.

5. Make a sample crimp and measure the crimp height. If the crimp is acceptable, replace and secure the lockscrew. If the dimension is unacceptable, continue to adjust the ratchet, and again measure a sample crimp.

6. REPLACEMENT

PRO-CRIMPER III Hand Tool Assembly 58551-1 and Die Assembly 58552-1 are inspected before shipment. Tyco Electronics recommends 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 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

- Updated document to corporate requirements
- New format

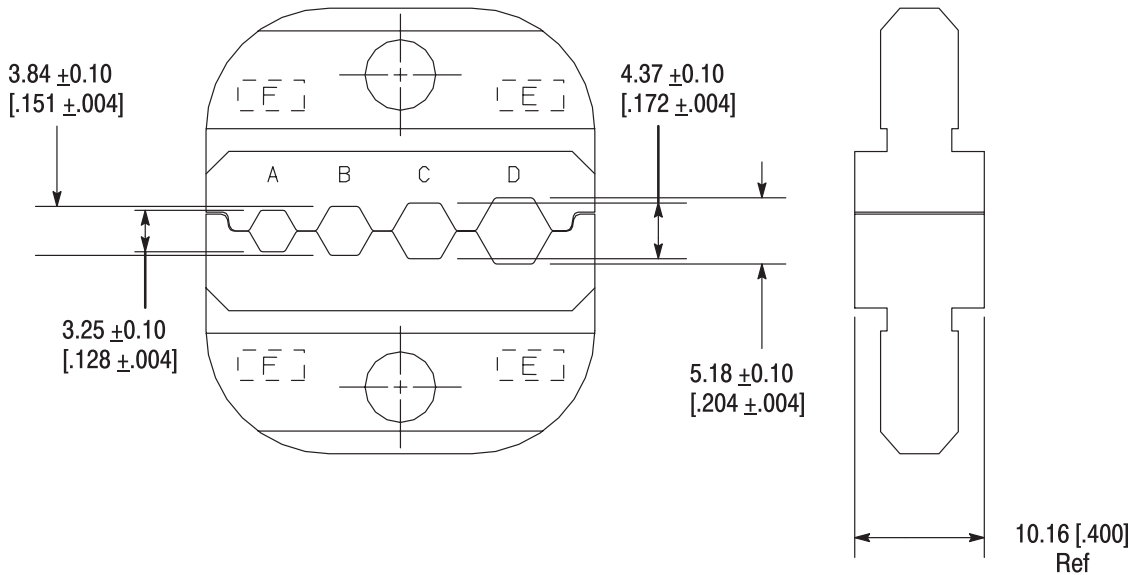


Figure 5