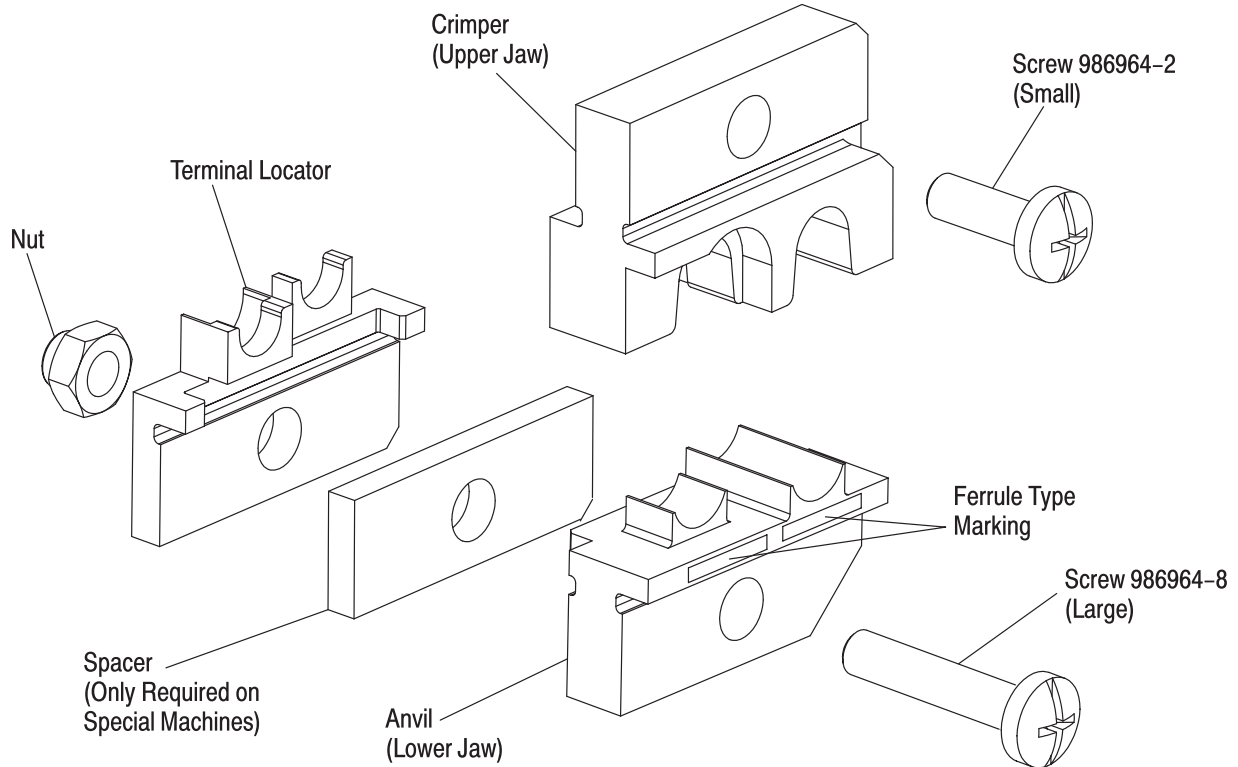


**SDE Die Assembly 1901280-1**

**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.



FERRULE TYPE	FERRULE PART NO.	CABLE TYPE	DIE ASSEMBLY	CRIMP TOOLING
Straight	1326646-1	RG-59, RG-62, RG-62U/M	1901280-1	Hand Tool 354940-1 (408-9930)
	1488922-2	RG-71, RG-71U/M		Hand Tool 9-1478240-0 (408-8851)
Right-Angle	1326510-1	RG-59, RG-62, RG-62U/M		Hand Tool 1725837-1, -2 (409-10053)
	1326510-3	RG-71, RG-71U/M		Bench Terminator 1490076-2 (409-10052)

Figure 1

**1. INTRODUCTION**


Die Assembly 1901280-1 is designed to crimp a variety of FAKRA Gen-4 ferrules listed in the table in Figure 1. This die assembly will fit into the tools provided in Figure 3.

**2. DESCRIPTION**

This die assembly has two crimp sections which are marked to identify the type of ferrules listed in the table in Figure 1.

**3. DIE INSTALLATION**

1. Close the tool handles until the ratchet releases, then allow the handles to open FULLY.
2. Insert the upper die into the stationary jaw. Thread, but do not tighten, a die retention screw through the hole in the jaw so that the die is held in place.

**NOTE**  Dimensions in this instruction sheet are in millimeters [with inches in brackets]. Figures and illustrations are for reference only, and are not drawn to scale.

3. Insert the lower die into the moving jaw. Thread, but do not tighten, a die retention screw through the hole in the jaw, terminal locator, and nut so that the die is held in place. See Figure 1.

**NOTE**

*On special bench machines, the spacer must be used. Add the spacer between the anvil (lower jaw) and the terminal locator as shown in Figure 1.*

4. Slowly close the tool handles, allowing the dies to mate and align. Continue closing the handles until the ratchet makes the fifth “click,” then tighten both die retention screws.

#### 4. CRIMPING PROCEDURE

The cable assembly has been stripped and prepared previously due to the mini applicator termination of the center contact.

1. Place the straight or right-angle ferrule over the cable assembly. Insert the center contact into the jack or plug kit until it is fully seated. Make sure that the braided shield is over the support sleeve of the connector and that no strands from the shield enter the connector body. A retention barb will hold the cable in place until the ferrule crimp is started.

2. Slide the ferrule up over the connector assembly until the ferrule butts against the shoulder on the connector body.

3. Place the connector sub-assembly in the appropriate crimping chamber with the rear ring of the sub-assembly in the locator.

**NOTE**

*While closing the tool, a forward force must be exerted on the coaxial wire to ensure that the center contact location is maintained.*

#### 5. DIE 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.

##### 5.2. Measured Die Opening

The dies will perform properly as long as: (1) the product specified is correct for the application, (2) the specified die set is used, (3) the die set has been measured to ensure that the openings are correct, and (4) the dies bottoms.

Figure 2 provides dimensions of the die openings.

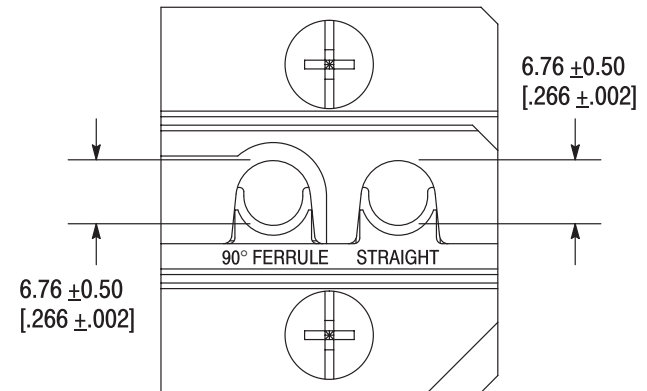


Figure 2

#### 6. REPAIR/REPLACEMENT

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.

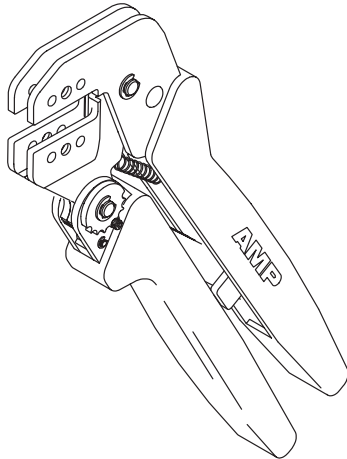
Order replacements through your representative, or call 1-800-526-5142, or send a facsimile of your purchase order to 717-986-7605, or write to:

CUSTOMER SERVICE (038-035)  
TYCO ELECTRONICS CORPORATION  
PO BOX 3608  
HARRISBURG PA 17105-3608

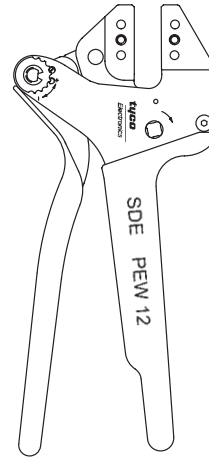
#### 7. REVISION SUMMARY

- Updated document to corporate requirements
- New format

**Pro-Crimper Hand Tool 354940-1**  
**(Instruction Sheet 408-9930)**



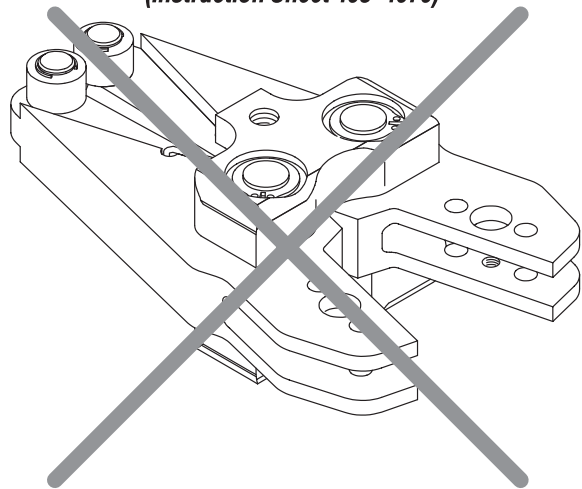
**SDE PEW-12 Hand Tool 9-1478240-0**  
**(Instruction Sheet 408-8851)**



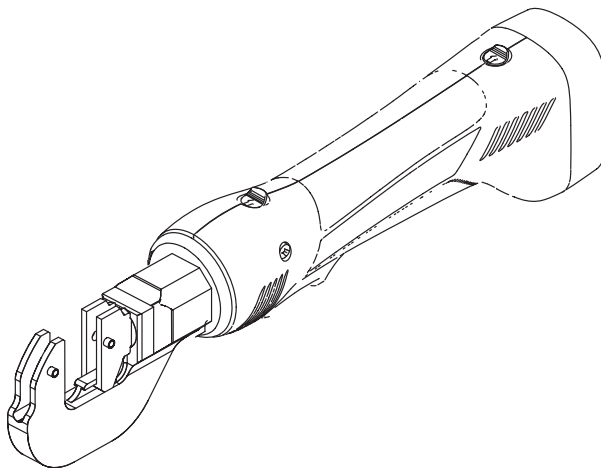
**SDE Bench Terminator 1490076-2**  
**(Customer Manual 409-10052)**



**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)**

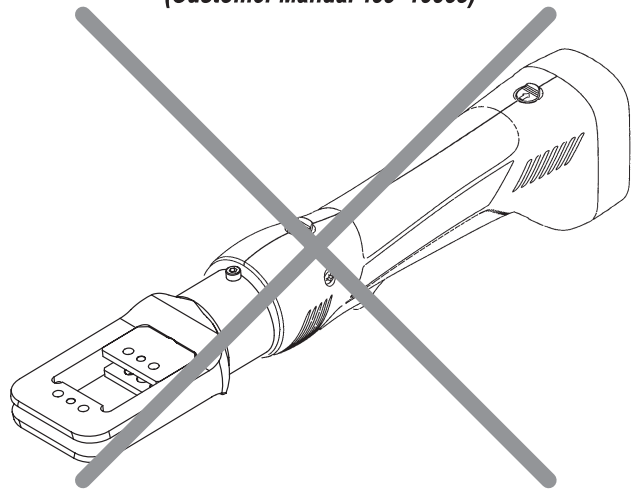


Figure 3