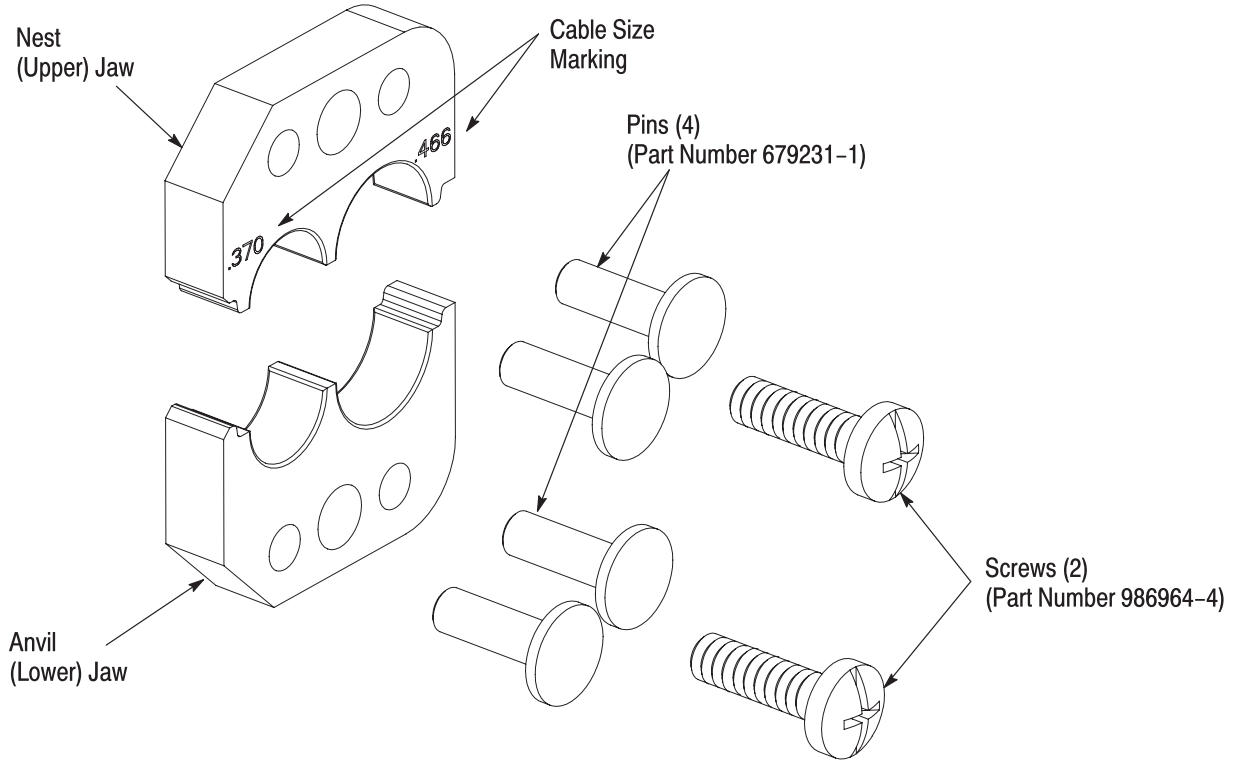


**PROPER USE GUIDELINES**

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 may be available.



DIE ASSEMBLY	CRIMP TOOLING	PRODUCT PART NUMBERS
1804018-1	PRO-CRIMPER Hand Tool Frame 354940-1 or SDE PEW 12 Hand Tool Frame 9-1478240-0	1754518-1 thru -12 1754519-1 thru -12 1754520-1 thru -12 1828413-1

Figure 1

**1. INTRODUCTION**

Die Assembly 1804018-1 is designed to crimp a variety of Expanded Beam Crimp Rings and products listed in the table in Figure 1. This die assembly will fit into the following tools: PRO-CRIMPER\* III Hand Tool Frame 354940-1 (Instruction Sheet 408- 9930); or SDE PEW 12 Hand Tool Frame 9-1478240-0 (Instruction Sheet 408-8851).

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

**2. DESCRIPTION**

This die assembly has two crimp sections which are marked to identify the cable sizes used with the products listed in the table in Figure 1. The cable sizes are 9.40 and 11.84 [.370 and .466].

**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.

3. Insert the lower die into the moving jaw. Thread, but do not tighten, a die retention screw through the hole in the jaw so that the die is held in place.
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

1. Squeeze the tool handles together until the ratchet releases. Allow the tool handles to open FULLY.
2. Place the product in the appropriate nest of the lower die.

**NOTE** For proper crimp location, make sure to position the crimp sleeve in the nest according to the instruction sheet for the connector.

3. Squeeze the tool handles together until the ratchet releases. Allow the tool handles to open FULLY.
4. Remove the product from the tool, and inspect the crimp according to the instruction sheet or application specification for the connector.

**CAUTION** Damaged product should not be used. If damaged product is evident, it should be removed and replaced with a new one. Product should not be reterminated.

#### 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.

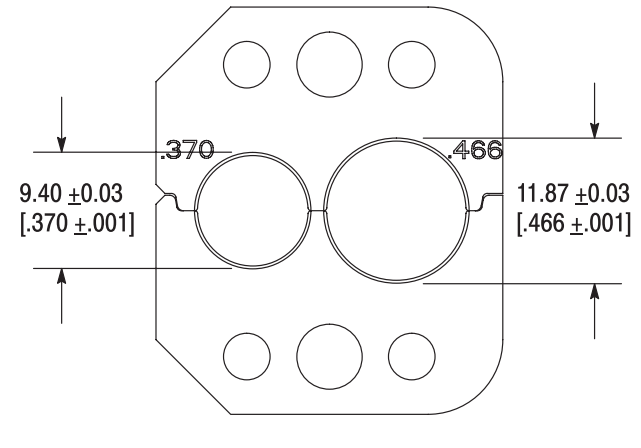


Figure 2

#### 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

- Initial release of document