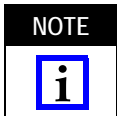


Figure 1

1. INTRODUCTION

Crimping Dies 1213841-1 and 1213841-2 are designed to be used in PRO-CRIMPER III Hand Tool Frame Assembly 354940-1 to crimp Quadrax pin or socket shell onto 4-position cable.



Dimensions in this instruction sheet are in metric units [with U.S. customary units in brackets]. Figures are not drawn to scale.

Reasons for reissue of this instruction sheet are provided in Section 7, REVISION SUMMARY.

2. DESCRIPTION

Each die assembly consists of an indenter die and an anvil die. When closed, the dies form two crimping chambers. Each die is held in the tool by a single screw. See Figure 1.

3. DIE ASSEMBLY INSTALLATION

1. Close the tool handles until the ratchet releases and then allow them to open fully.
2. See Figure 1 for orientation of the dies, and insert the dies inside the tool jaws. Align the retaining screw holes.
3. Thread the retaining screws into the holes and carefully close the tool handles. Tighten the screws with the appropriate hex wrench.

4. CRIMPING PROCEDURE (See Figure 2)

1. Insert the contact into the specific dielectric until fully bottomed. The back end of the dielectric should butt up against the ferrule and cable braid.
2. Insert and push the dielectric subassembly into the shell while keeping the slot of the dielectric aligned with the wiring key on the outside of the shell. Continue pushing until the dielectric subassembly until it visually bottoms.
3. Place the crimp portion of the shell into the appropriate crimping chamber, and actuate the tool. Check the crimp. The hex crimp should measure $5.54 +0.25/-0.05$ mm [$.218 +.010/-.002$ in.] nominal across all flats. An "O" crimp is also an option.

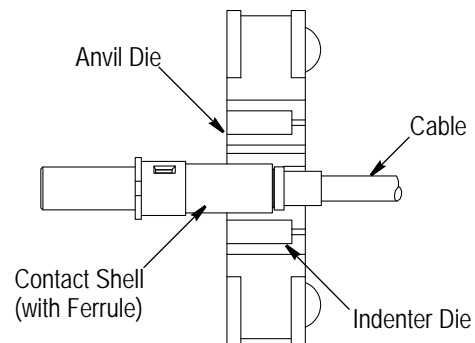


Figure 2

4. After crimping, slide the contact seal (if used), over the crimp area until the contact seal bottoms. Orient the seal alignment line with the contact positioning key.



*DO NOT use damaged or defective products.
DO NOT re-use the shell or ferrule by removing the wire.*

5. INSPECTION

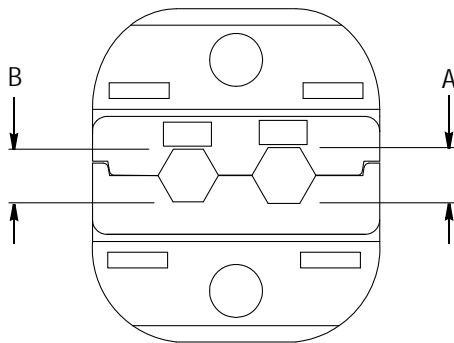
5.1. Visual Inspection

Inspect the dies on a regular basis to ensure that they have not become worn or damaged. Inspect the crimping chambers for flattened, chipped, worn, or broken areas. If damage or abnormal wear is evident, the dies must be replaced. Refer to Section 6, PARTS REPLACEMENT.

5.2. 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.

Refer to Figure 3 for information on die opening sizes.



DIE ASSEMBLY	CRIMPING CHAMBER HEX DIMENSION (mm [in.])	
	A ± 0.10 [.004]	B ± 0.10 [.004]
1213841-1	5.87 [.231]	5.54 [.218]
1213841-2	7.92 [.312]	7.14 [.281]

Figure 3

6. PARTS REPLACEMENT

If the dies are damaged or worn excessively, they must be replaced. Available separately, PRO-CRIMPER Repair Kit 679221-1 includes a variety of pins, rings, screws, and springs. Order the repair kit and die assembly through your 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 (038-035)
TYCO ELECTRONICS CORPORATION
PO BOX 3608
HARRISBURG PA 17105-3608

7. REVISION SUMMARY

Revisions to this instruction sheet include:

- Changed company name and logo
- Added tolerance to Step 3 of Section 3
- Modified Section 6