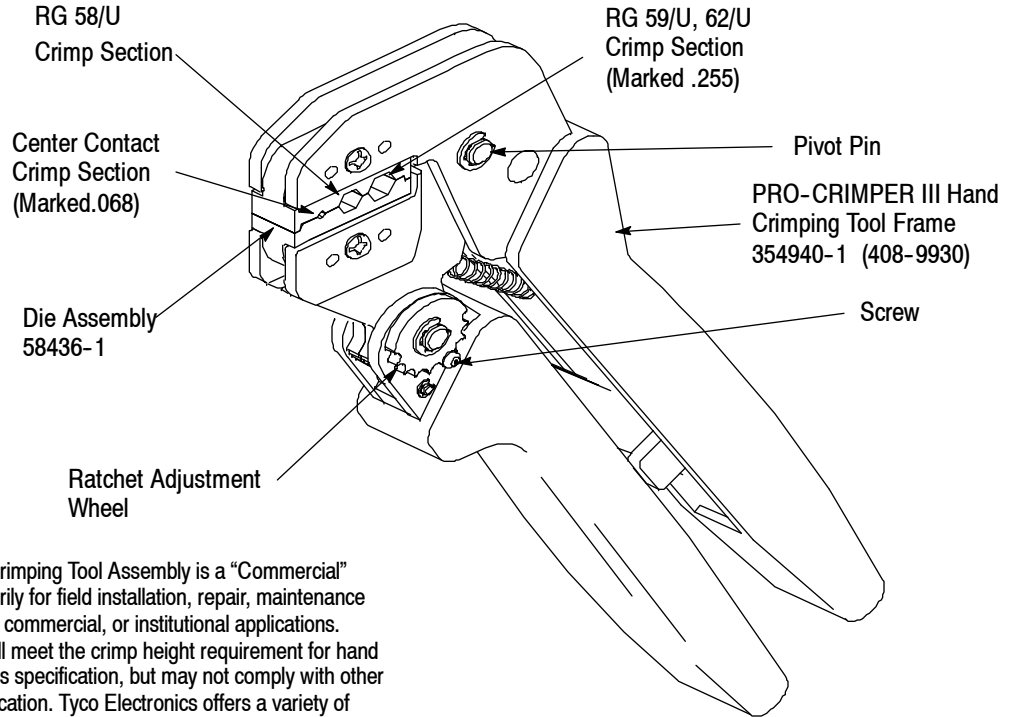


**PROPER USE GUIDELINES**

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.



The PRO-CRIMPER III Hand Crimping Tool Assembly is a “Commercial” grade tool and is designed primarily for field installation, repair, maintenance work, or prototyping in industrial, commercial, or institutional applications. Product crimped with this tool will meet the crimp height requirement for hand tools in the appropriate 114 series specification, but may not comply with other feature parameters of the specification. Tyco Electronics offers a variety of tools to satisfy your performance requirements. For additional information, contact the Tooling Assistance Center at 1-800-722-1111.

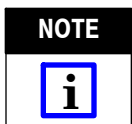
TE Tool Assembly	TE Die Assembly	Product†‡	Cable
58433-2	58436-1	50-Ohm Commercial BNC and TNC Hex-Crimp Plugs and Jacks	RG 58/U, RG 59/U, RG 62/U

† Contact the Tooling Assistance Center or Product Information at the number listed below for specific terminal and splice part numbers.

Figure 1

**1. INTRODUCTION**

PRO-CRIMPER III Hand Crimping Tool 58433-2 is designed to crimp 50-Ohm Commercial BNC and TNC Hex Crimp Plugs and Jacks onto RG 58/U, RG 59/U, and RG 62/U cable. Refer to Figure 1.



*Dimensions on this sheet are in millimeters [with inch equivalents provided in brackets]. Figures are for reference only, and are not drawn to scale.*

The ferrule crimp sections are identified by their applicable cable size markings (.213 and .255) above them.

The center contact crimp section, identifiable as the smallest of the three crimp sections, is marked .068.

Reasons for reissue of this sheet are provided in Section 6, REVISION SUMMARY.

**2. DESCRIPTION** (Figure 1)

The tool features a die assembly with two ferrule crimp sections and one center contact crimp section.

**3. CRIMPING PROCEDURE** (Figure 2 and Figure 3)

**3.1. Center Contact**

1. Slide the ferrule onto the cable, then strip the cable according to the dimensions in the appropriate connector instruction sheet.

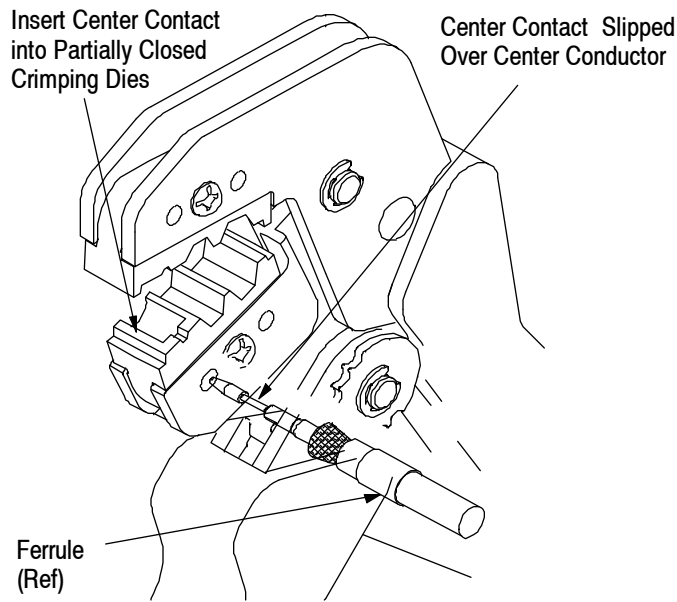


Figure 2

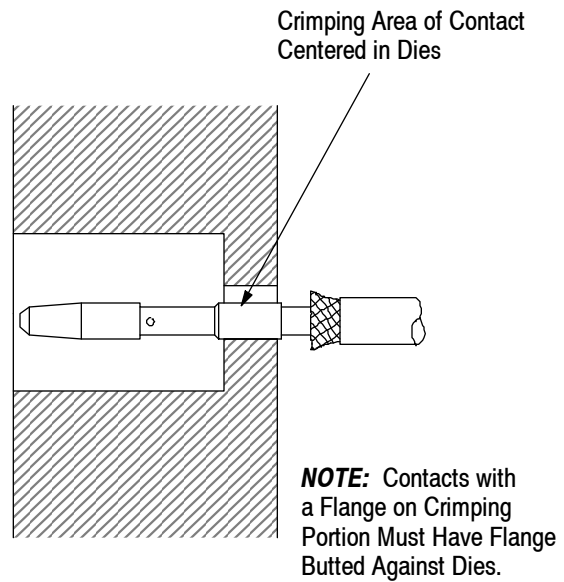
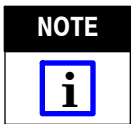


Figure 3



**NOTE** Center the crimping area of the contact in the dies. See Figure 2. If contacts have a flange on the crimping portion, butt the flange against dies (Figure 3).

2. Slide the center contact onto the center conductor of the cable; then insert the contact assembly into the center contact crimp section of the dies.
3. Crimp the center contact by holding the cable in place; then close the tool handles until the ratchet releases.
4. Remove the crimped center contact assembly from the crimping die.

**3.2. Ferrule**

1. Insert the crimped center contact into the connector body until the cable dielectric butts against the dielectric inside the connector body. The flared braid will then fit around the support sleeve of the connector body.
2. Slide the ferrule forward over the braid until the ferrule butts against the shoulder on the connector body.
3. Place the ferrule on the appropriate anvil of the die assembly so that the shoulder on the connector body butts against the die. See Figure 4.
4. Holding the assembly in place, close the tool handles until the ratchet releases.

5. Remove the crimped assembly from the crimping die.

**4. INSPECTION**

**4.1. 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. Refer to Section 5, PARTS REPLACEMENT.

**Crimping Ferrule**

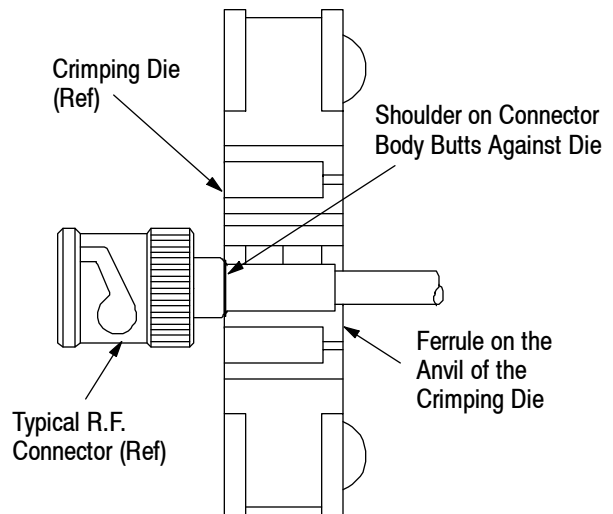


Figure 4

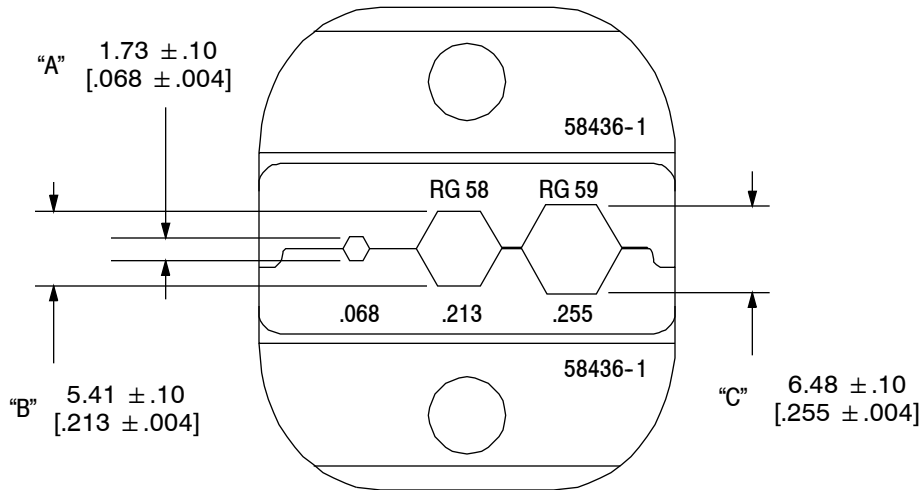


Figure 5

**4.2. 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.

Figure 5 provides information on die opening sizes.

**4.3. Ratchet Adjustment** (Figure 6)

The ratchet mechanism features an adjustment wheel with eight settings. The adjustment wheel controls the amount of handle pressure exerted on the tool jaws and crimping dies during crimping. If the crimp is not acceptable, adjust the ratchet as follows:

1. Sufficiently loosen the screw at the ratchet adjustment wheel so that the wheel can be rotated above the post that engages the teeth in the wheel.
2. If the crimp is too loose, turn the wheel to a higher notch (for example, if the wheel is set at notch no. 5, move the wheel to notch no. 6). If the crimp is too tight, move the wheel to a lower notch
3. Tighten the screw at the ratchet adjustment wheel.

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.

**NOTE** *Other dies of the PRO-CRIMPER III series may be used in this tool; however, the ratchet adjustment wheel may require adjustment to achieve acceptable crimp height.*

**5. PARTS REPLACEMENT**

Customer-replaceable parts are shown in Figure 1.

Available separately, PRO-CRIMPER III Hand Crimping Tool Repair Kit 679221-1 includes a replacement nut and a variety of pins, rings, screws, and springs.

If the dies are damaged or worn excessively, they must be replaced.

Order the repair kit and replaceable parts 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  
 PO BOX 3608  
 HARRISBURG, PA 17105-3608

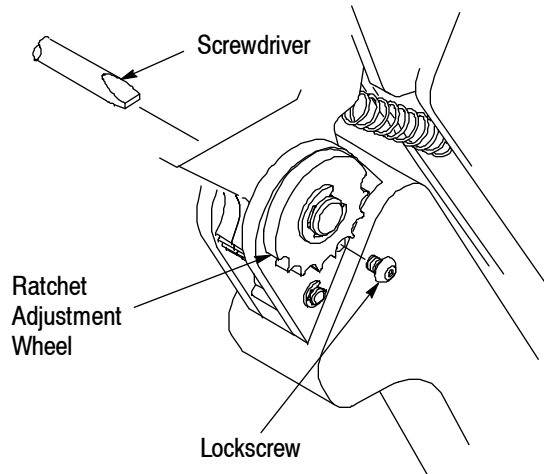


Figure 6

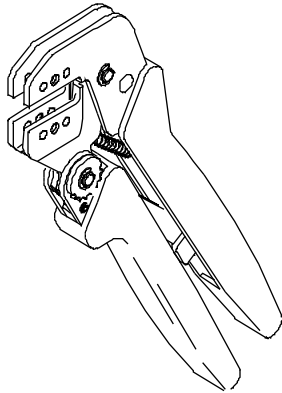
**6. REVISION SUMMARY**

Revisions to this instruction sheet include:

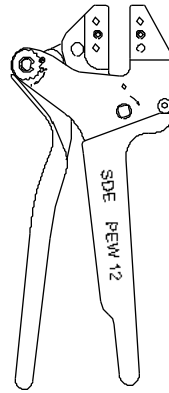
- PRO-CRIMPER Hand Tool was changed to the PRO-CRIMPER III Hand Tool;
- Added TE logo; and
- Added ratchet adjustment picture.

**Die Assembly 58436-1 Can Also Be Used In the Following Tools:**

**PRO-CRIMPER III Hand Tool 354940-1**  
(Instruction Sheet 408-9930)



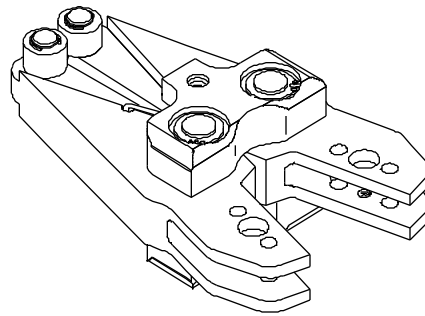
**SDE PEW-12 Hand Tool 9-1478240-0**  
(Instruction Sheet 408-8851)



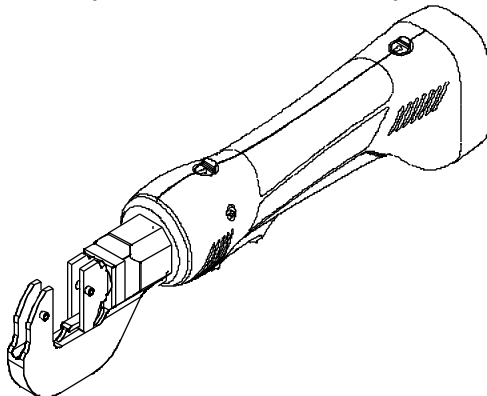
**SDE Bench Terminator 1490076-2**  
(Customer Manual 409-10052)



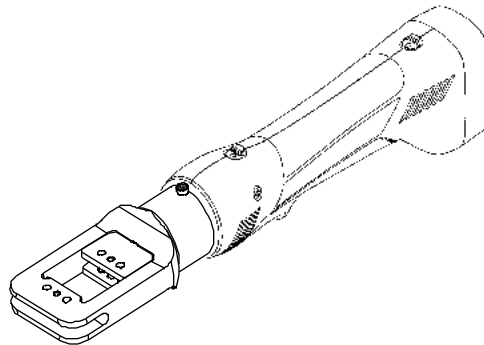
**626 Adapter 679304-1**  
(Instruction Sheet 408-4070)



**Battery Tool (Shouldered Die) 1725837-1, -2**  
(Customer Manual 409-10053)



**Battery Tool (Pin Die) 1213890-1, -2**  
(Customer Manual 409-10065)



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