

Crimp Tool Assembly.

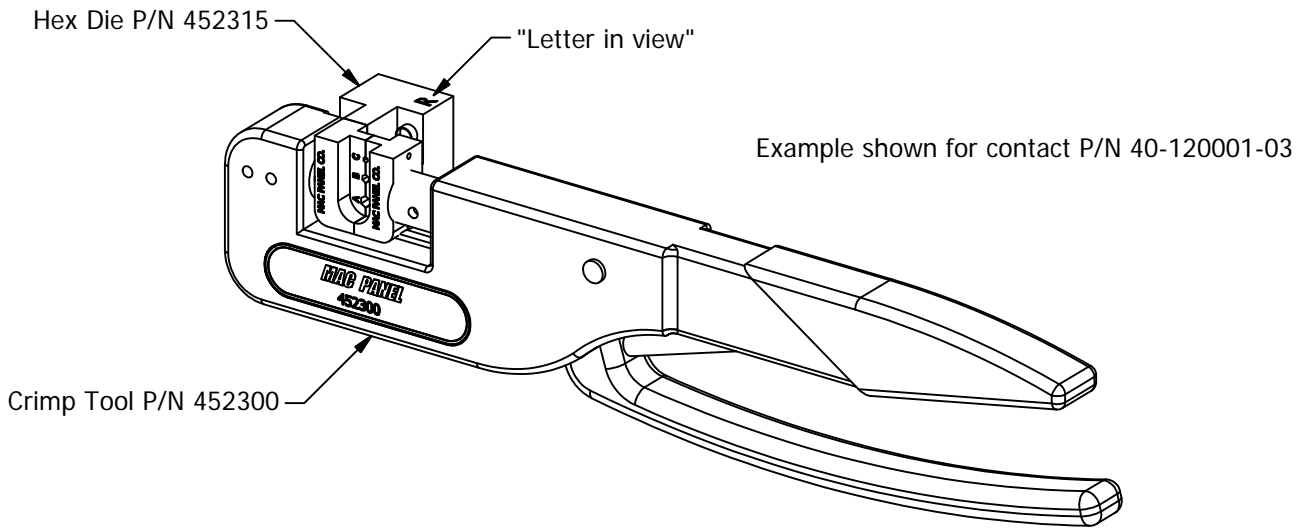
Step 1

From the "Crimp Information" table below, select the correct Crimp Tool and Hex Die for the contact you are using.

Crimp Information						
Contact P/N	Wire Type	Crimp Tool	Hex Die	Letter in view	Large Crimp	Small Crimp
40-120001-02	JOY 014	452300	452315	R	A	C
40-120001-03	RG178, JOY 05, 06 & 018	452300	452315	R	A	B
561201	JOY 05	452300	452315	R	A	B

Step 2

Attach the Hex Die to the Crimp Tool with the appropriate "letter in view" on the top face.



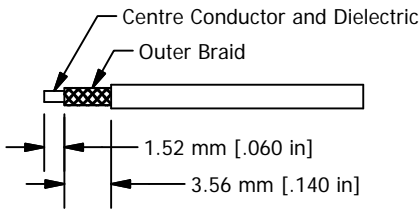
The crimp tool will automatically re-open the hex die when the handles are fully closed.

Your crimp tool is now ready to crimp the contacts when they have been fully assembled.

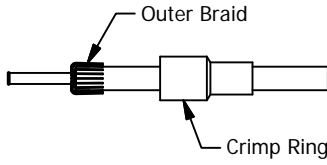
See the following page for the correct contact assembly procedure.

Contact Assembly Procedure.

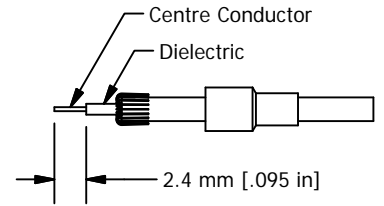
1) Using appropriate tooling for your cable type, Strip one end to the dimensions shown below.



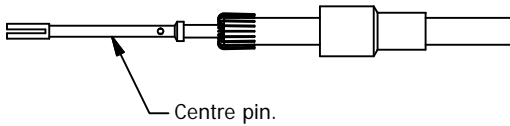
2) Slide crimp ring over cable, Pull outer braid back over cable covering.



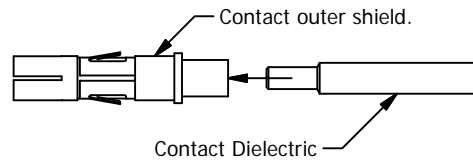
3) Strip 2.4 mm [.095 in] from dielectric leaving centre conductor exposed.



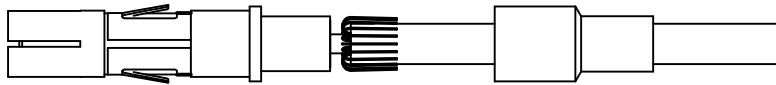
4) Solder the centre conductor into the contact centre pin.



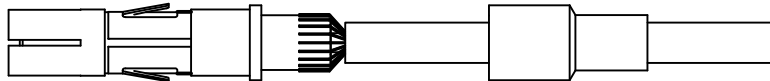
5) Ensure Contact Dielectric is pushed firmly into the contact outer shield.



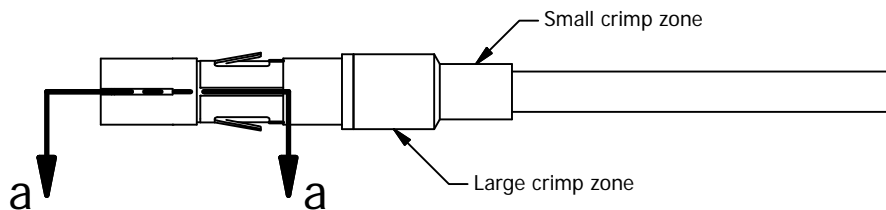
6) Push the centre pin and cable assembly fully inside the contact dielectric.



7) Ensure outer cable braid is folded over contact body.

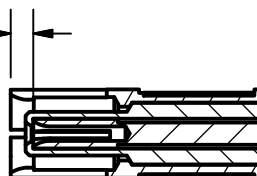


8) Push crimp ring over contact body and crimp large and small crimp zones using A, B or C part of Hex Die. Correct letters for the contact you are using can be found in the "Crimp Information" table on sheet 1.



0.4mm ± 0.2mm [.016in ± .008 in]

Is the distance the centre pin should be below the front face of the contact if it has been assembled correctly.



SECTION a-a