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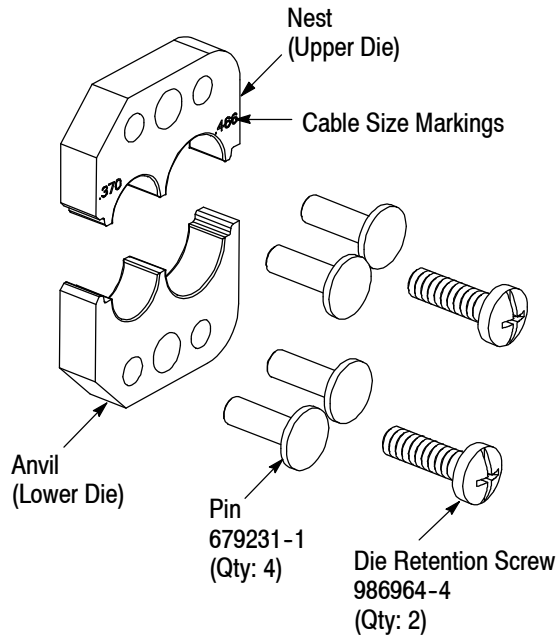
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**Die Assembly 1804018- 1**



TOOL FRAME	PRODUCT
PRO-CRIMPER* III Hand Tool Frame 354940-1 (408-9930) or SDE PEW 12 Hand Tool Frame 9-1478240-0 (408-8851)	1754518-1 to -12
	1754519-1 to -12
	1754520-1 to -12

Figure 1

**1. INTRODUCTION**

Die Assembly 1804018-1 is designed to be installed into one of the tool frames listed in Figure 1 to crimp a variety of expanded beam (EB) components of the connector kits listed in Figure 1. Refer to the instruction sheet (408-series) listed for information on the tool frame.

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

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

**2. DESCRIPTION**

The die assembly consists of a nest and an anvil. When closed, the dies form two crimping chambers. Each crimping chamber is marked with the acceptable cable size. 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 of the tool. Align the holes, and insert a pin into each of the outer holes of the die and into the jaw. Thread, but do not tighten, the 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 of the tool. Align the holes, and insert a pin into each of the outer holes of the die and into the jaw. Thread, but do not tighten, the 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 for the product. If the crimp cannot be made to conform to inspection requirements, the tool and/or dies are defective and must be replaced (refer to Section 6).

**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 re-terminated.*

**5. MAINTENANCE AND INSPECTION**

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

### 5.1. Maintenance

1. Remove dust, moisture, and other contaminants with a clean, soft brush, or a clean, soft, lint-free cloth. DO NOT use any objects that could damage the dies or tool.
2. Make sure that the retaining screws are properly secured.
3. When the dies are not in use, store them in a clean, dry area.

### 5.2. Inspection

1. Remove all lubrication and accumulated film from the dies by immersing the dies in a suitable commercial degreaser.
2. Make certain that all retaining screws and die components are properly secured.
3. Inspect the crimping surfaces for flattened, chipped, worn, or cracked areas. If damage is evident, the dies must be replaced. Refer to Section 8, REPLACEMENT.

### 5.3. Measuring the Die Opening

Measure the die opening to ensure that it meets the dimensions given in Figure 2.

## 6. REPLACEMENT

Customer-replaceable parts are given in Figure 1. A complete inventory should be stocked and controlled to prevent lost time when replacement of parts is necessary. Order replacement parts 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

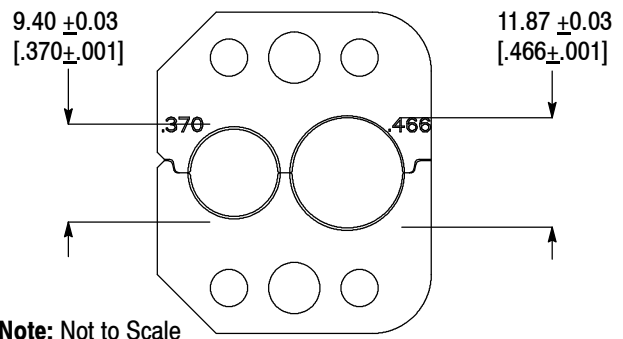


Figure 2

## 7. REVISION SUMMARY

Revisions to this instruction sheet include:

- Updated instruction sheet to corporate requirements
- Removed obsolete product from Figure 1
- Added installation of pins to Steps 2 and 3 of Section 3
- Modified Section 6