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With the principle of “Quality Parts,Customers Priority,Honest Operation,and Considerate Service”,our business mainly focus on the distribution of electronic components. Line cards we deal with include Microchip,ALPS,ROHM,Xilinx,Pulse,ON,Everlight and Freescale. Main products comprise IC,Modules,Potentiometer,IC Socket,Relay,Connector.Our parts cover such applications as commercial,industrial, and automotives areas.

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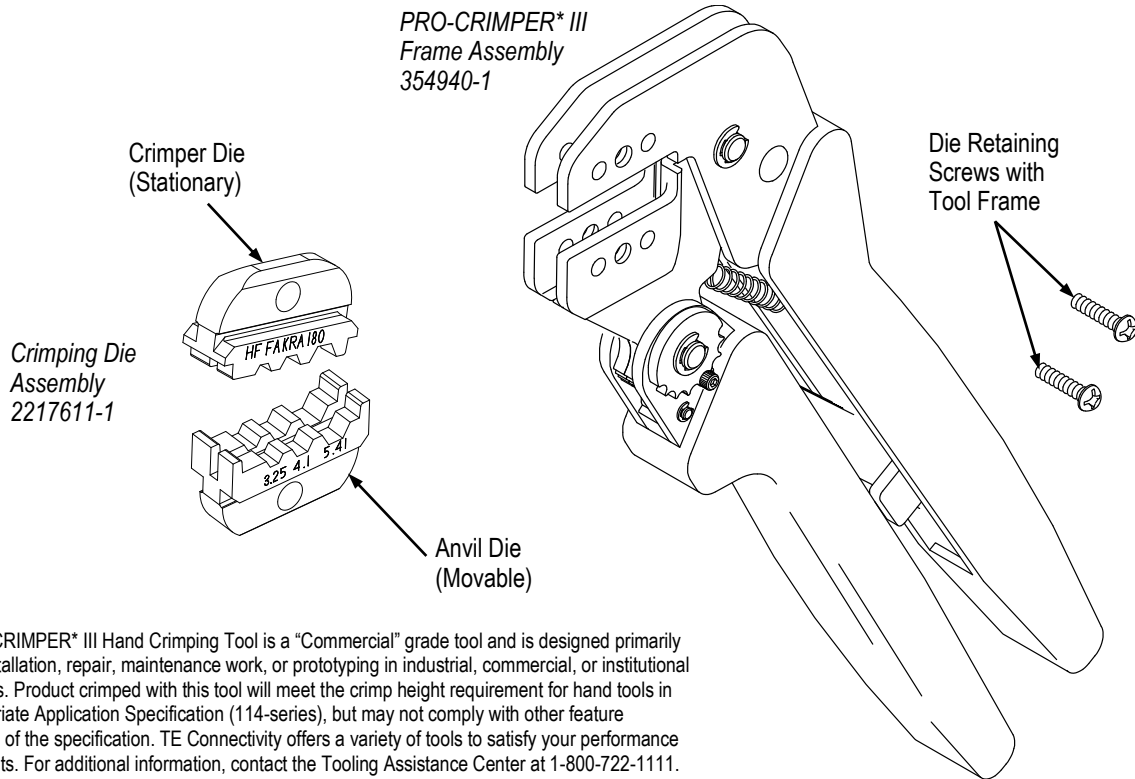
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**PROPER USE GUIDELINES**

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 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 Application Specification (114-series), but may not comply with other feature parameters of the specification. TE Connectivity offers a variety of tools to satisfy your performance requirements. For additional information, contact the Tooling Assistance Center at 1-800-722-1111.

Figure 1

**1. INTRODUCTION** (Figure 1)

This instruction sheet provides application and maintenance procedures for SDE die set 2217611-1. Figure 1 shows PRO-CRIMPER\* III hand tool frame (354940-1). See the last page of this document for other available compatible tooling frames and related instruction sheets to be used with this die set.

For information on connector part numbers and connector assembly procedures, refer to the appropriate instruction sheet packaged with the connector.



**NOTE**

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

Read these instructions and all referenced materials thoroughly before using the die and tool assembly.

**2. DESCRIPTION** (Figure 2)

The die assembly features an anvil die and a crimper die. When closed, the dies produce three crimping chambers that crimp the ferrule of the connector. Each die is held in the tool jaws with a single die-retaining screw.

**3. DIE INSTALLATION** (Figure 2)

1. Close the tool handles until the ratchet releases; then allow the tool handles to open FULLY.
2. Install anvil die in the moving jaw of the hand tool. Align the die with the retaining screw hole; then secure die with the button head cap screw. Do NOT fully tighten.
3. Install crimper die in the stationary jaw of the hand tool. Slowly close the tool handles, allowing the die to align itself with the upper die. When dies are properly aligned, securely tighten both screws.



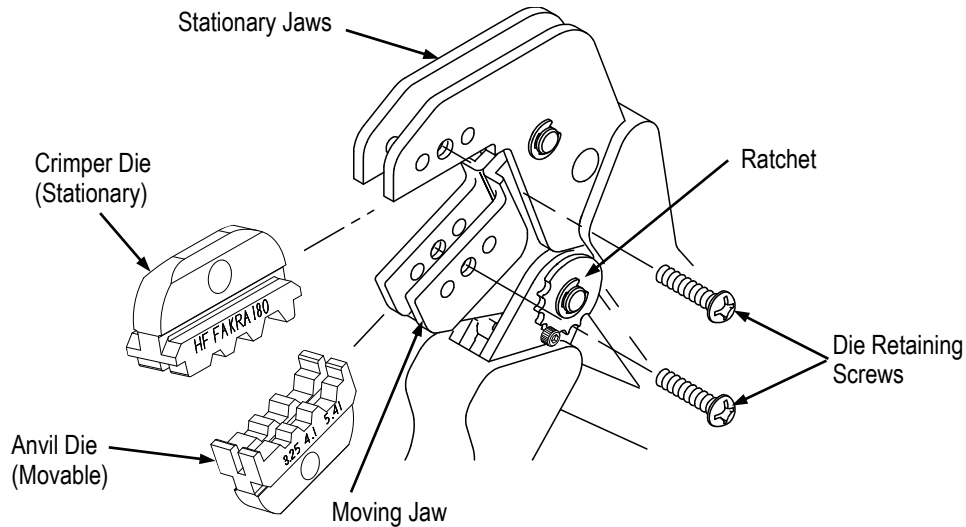


Figure 2

**4. CRIMPING PROCEDURE** (Figure 3)

Prepare connector and cable according to the instructions packaged with the connector, and proceed as follows:

1. Close the tool handles until the ratchet releases, then allow the handles to open FULLY.
2. Place connector in the appropriate crimping section of dies as shown in Figure 3.
3. Close the tool handles until the ratchet releases; then open the tool handles to remove the crimped connector.

**5. MAINTENANCE AND INSPECTION**

**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 proper die-retaining screws are properly secured.
3. When the dies are not in use, store them in a clean, dry area.
4. Store the tool with the tool handles closed to prevent objects from becoming lodged within the jaws.

**5.2. Inspection**

1. Remove all lubrication and accumulated film from the dies by immersing the dies in a suitable commercial degreaser.

2. Make sure that the proper die retaining screws and die components are properly secured.

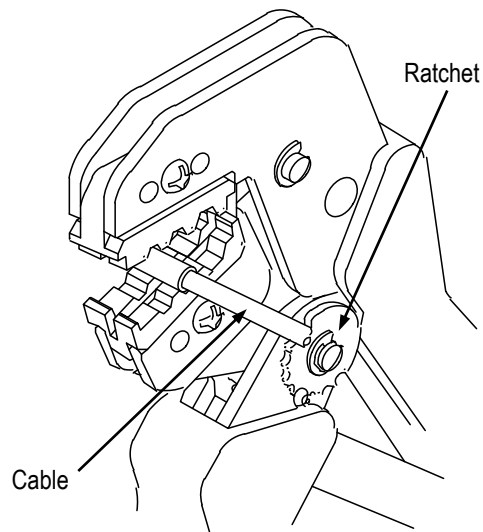


Figure 3

3. Inspect the crimping surfaces for flattened, chipped, worn, or cracked areas. If damage is evident, the dies must be replaced. Refer to Section 6, REPLACEMENT.

**5.3. 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 openings.

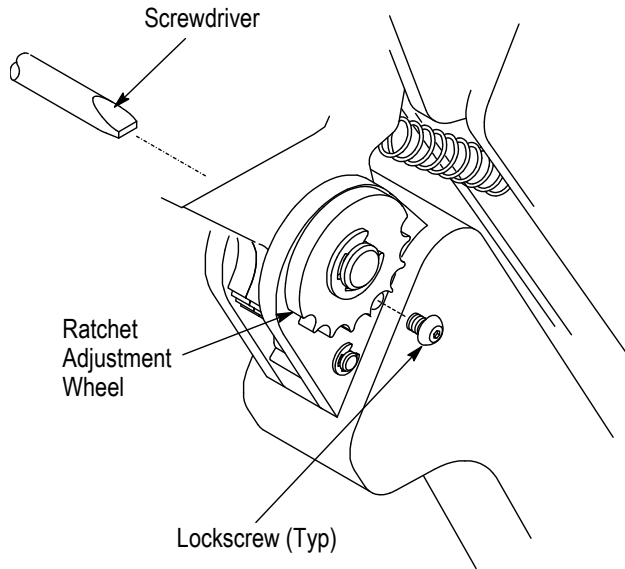


Figure 4

**5.4. Ratchet Adjustment** (Figure 4)

The tool frame assembly ratchet mechanism features an adjustment wheel with eight settings. If the crimp is not acceptable, adjust the ratchet as follows:

1. Remove the lockscrew from the ratchet adjustment wheel.
2. With a screwdriver, adjust the ratchet wheel from the opposite side of the tool.

3. Observe the ratchet adjustment wheel. If a tighter crimp is required, rotate the adjustment wheel **COUNTERCLOCKWISE** to a higher-numbered setting. If a looser crimp is required, rotate the adjustment wheel **CLOCKWISE** to a lower-numbered setting.
4. Replace the lockscrew.
5. Make a sample crimp and measure the crimp height. If the crimp is acceptable, replace and secure the lockscrew. If the dimension is unacceptable, continue to adjust the ratchet, and again measure a sample crimp.

**6. REPLACEMENT**

TE recommends that the dies be inspected immediately upon arrival at your facility to ensure that the dies have not been damaged during shipment.

Order replacements through your TE 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**

- Initial release of document

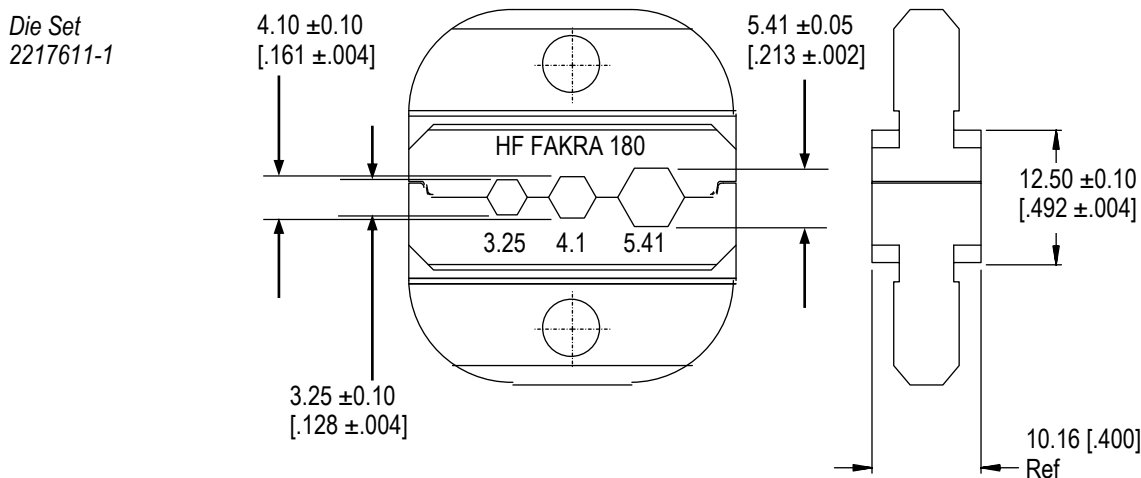
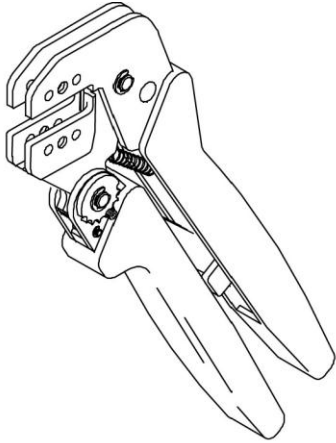


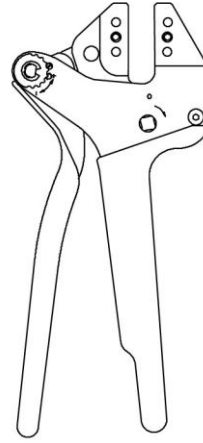
Figure 5

**Tooling Compatible with Die Assembly 2217611-1**

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



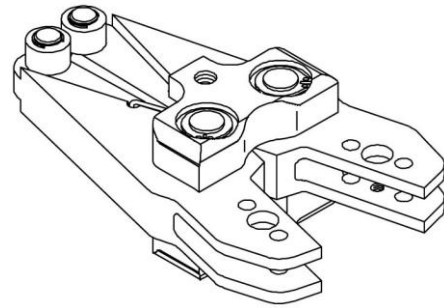
*SDE-SA Hand Tool 9-1478240-0  
(Instruction Sheet 408-8851)*



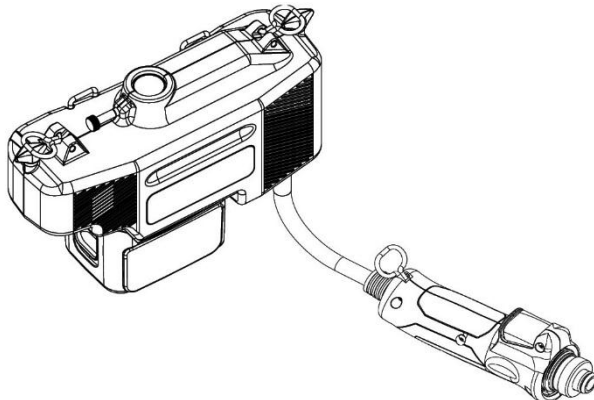
*SDE Bench Terminator 1490076-2  
(Customer Manual 409-10052)*



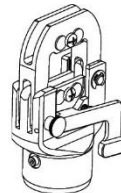
*626 Adapter 679304-1  
(Instruction Sheet 408-4070)*



*Electro-Hydraulic (BT 3500 Battery-Hydraulic)  
Hand Tool Kits 2031400-[ ]  
(Customer Manual 409-10095)*



*Closed Head Assembly 2031460-1  
(Instruction Sheet 408-10312)*



*"C"-Head Assembly 2031450-1  
(Instruction Sheet 408-10311)*

