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AMPAMP INCORPORATED
Harrisburg, Pa. 17105

AMP★ CRIMPING DIE SET 313113-1

Instruction Sheet

IS 9210

RELEASED 1 - 30 - 86

REDUCED FOR PACKAGING

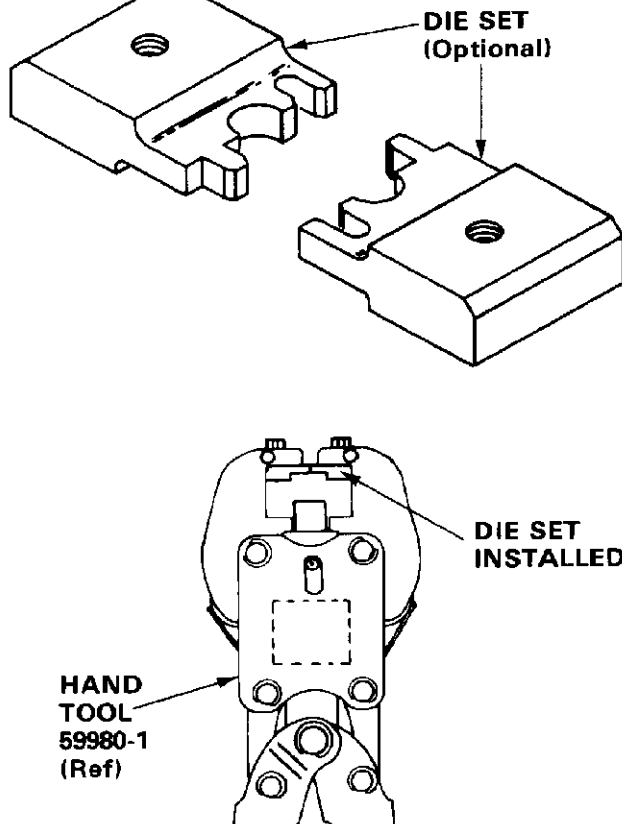
AMP CRIMPING DIE SET 313113-1
(Used with AMP Hand Crimping
Tool 59980-1)

Fig. 1

1. INTRODUCTION

AMP Crimping Die Set 313113-1, shown in Figure 1, is designed for optional use in AMP Hand Tool 59980-1. The assembled tool is used to crimp SMA Series (short) Plugs 221447-1 through -4 to RG-405 (.086) semi-rigid coaxial cable, as shown in Figure 2. This instruction sheet (IS) covers recommended procedures for die installation. IS 6788, packaged with the tool, covers application and maintenance procedures for the hand crimping tool. Read all instructions thoroughly before proceeding.

NOTE

All dimensions on this sheet are in inches unless otherwise specified.

2. DESCRIPTION (Figures 1 and 2)

This *special* die set consists of two identical crimping dies (crimp inserts) which are *not* provided with the tool and which must be ordered separately. The die set features a machined crimp area which is thinner

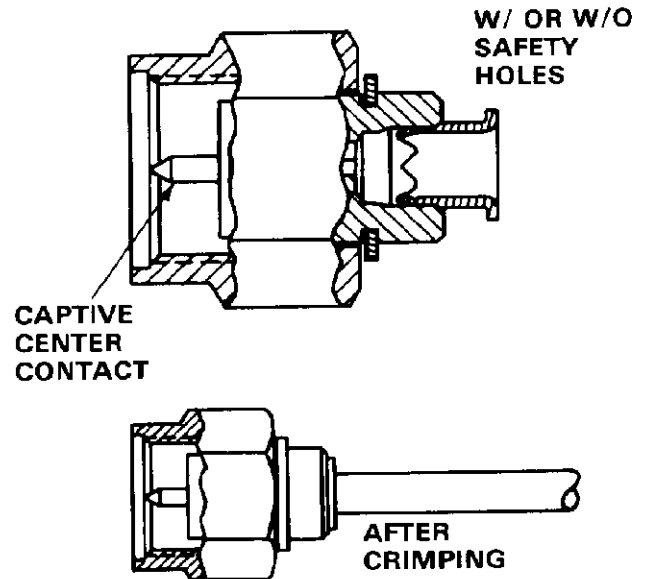
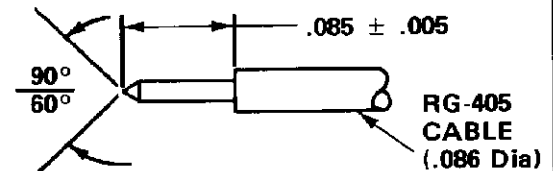
SMA SERIES PLUGS
221447-1 THROUGH -4**RECOMMENDED STRIP LENGTH**
AND POINTING

Fig. 2

than the standard die set provided with the tool. The thinner crimp area requires .320 in. (min) of straight cable for application of the SMA connector.

NOTE

Standard Inserts 312253-2 for RG-405 cable (provided with the tool) can also be used for SMA Plug 221447 terminations. However, a minimum of .360 in. of straight cable is required when using the standard dies.

SMA Plugs 221447-1 through -4 feature a plug body assembly with *captive* center contact. Plugs 221447-3 and -4 are plugs *with* safety wire holes; the -1 and -2 plugs do not have these holes. RG-405 cable must be properly stripped and pointed, according to the dimensions in Figure 2, to ensure a sound connection.

3. TOOL SETUP PROCEDURE (Figure 3)

Before prepared cable can be crimped to an SMA short plug, the AMP hand crimping tool must be set up as follows:

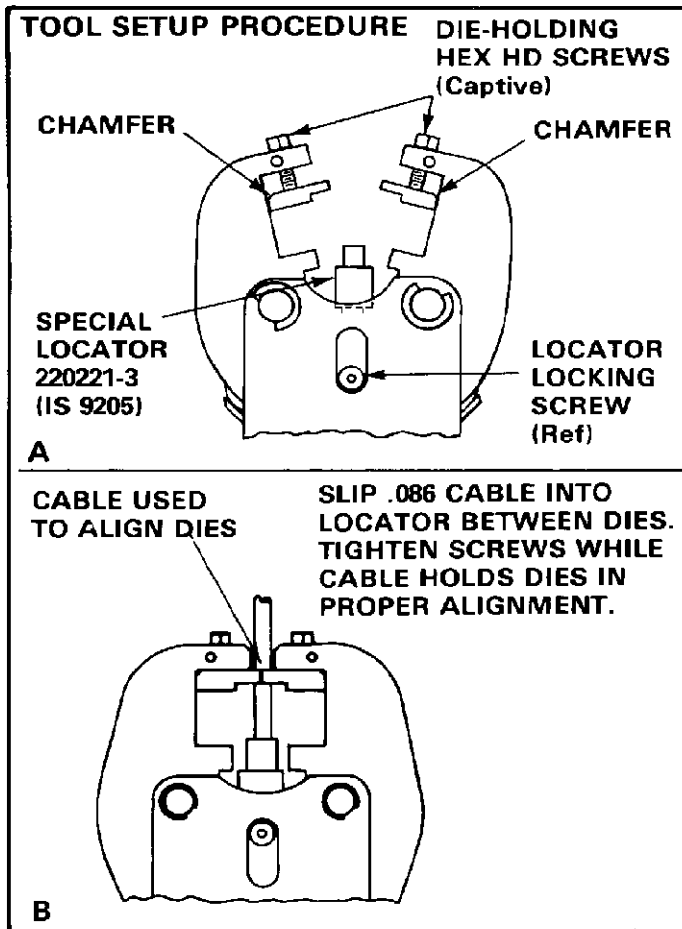


Fig. 3

1. Loosen locator locking screw and insert *jack* end of special Locator 220221-3 (which is *not* provided with the tool and which must be ordered separately) into cavity of tool head. Re-tighten locking screw.
2. Position each half of special Die Set 313113-1 (or standard Die Set 312253-2) on tool jaw, making sure that chamfers are oriented as shown in Figure 3.

CAUTION *An unacceptable crimp will result if die chamfers are not positioned as shown.*

3. Fasten dies to jaws with captive screws, but do NOT tighten screws until dies are aligned.
4. To align dies, place RG-405 (.086) cable into locator and squeeze handles to close tools. Check for even alignment of dies, as shown, and tighten screws to secure dies.

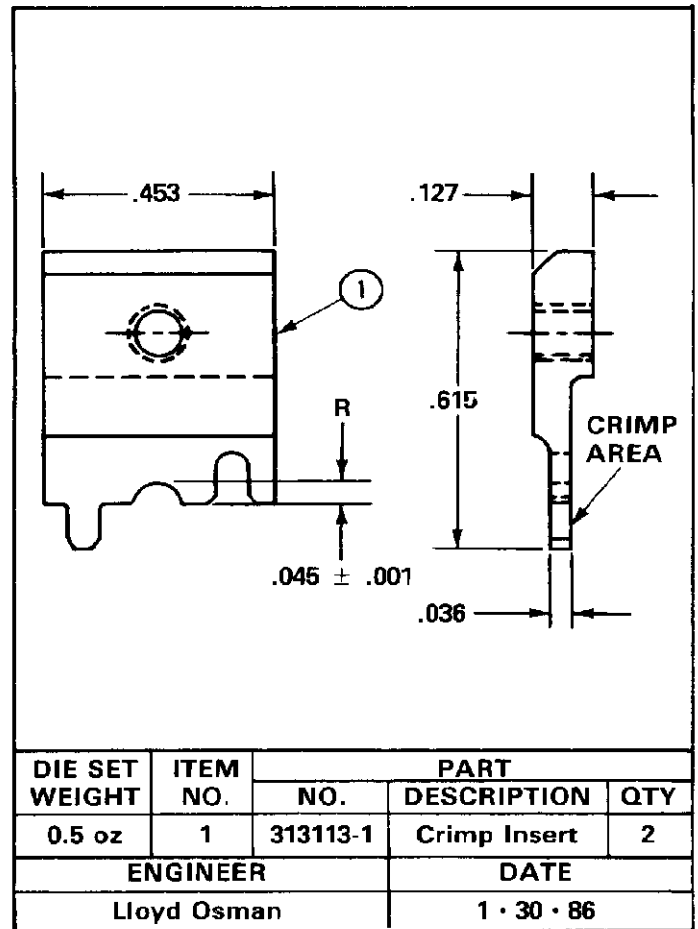


Fig. 4

DIE SET WEIGHT	ITEM NO.	PART		
		NO.	DESCRIPTION	QTY
0.5 oz	1	313113-1	Crimp Insert	2
ENGINEER			DATE	
Lloyd Osman			1 · 30 · 86	

Follow crimping procedures, as given in IS 6788, for connectors with fixed collars.

4. TOOLING CERTIFICATION

The tool crimping chamber should be checked regularly by following the inspection and maintenance procedures provided in IS 6788. Crimping Die Set 313113-1 should be certified with the information provided in Figure 4. AMP recommends that the die set be inspected immediately upon its arrival at your location, and at regularly scheduled intervals, to ensure that the dies have not become worn or damaged. Dies should be mated and stored in a dry, clean place when not in use. Should replacement be necessary, die sets can be replaced by sending a purchase order with the die set number to:

AMP Incorporated
 Customer Repair
 1523 North 4th Street
 Harrisburg, PA 17102-1604

or a wholly-owned subsidiary of AMP Incorporated.