

PROPER USE GUIDELINES

Cumulative Trauma Disorders can result from the prolonged use of manually powered hand tools. AMP hand tools are intended for occasional use and low volume applications. AMP offers a wide selection of powered application equipment for extended-use, production operations.

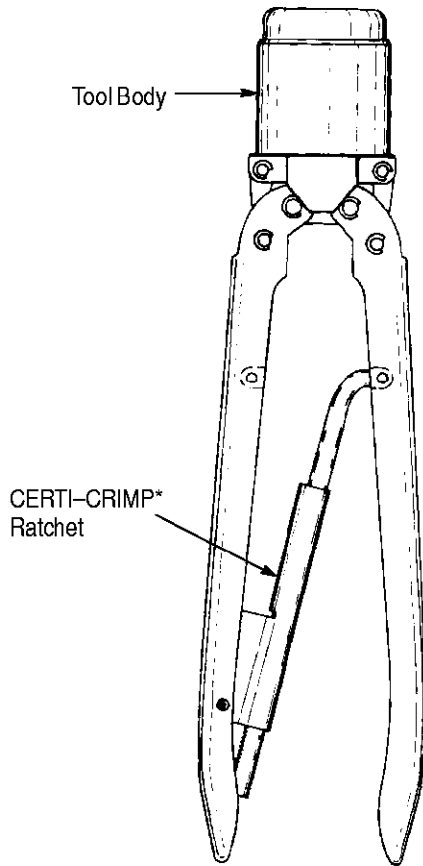


Figure 1

1. INTRODUCTION

AMP* Hand Crimping Tool 69480 (shown in Figure 1) crimps UHF (ultra high frequency) Plug Connector 2-330830-4 onto coaxial cable types RG 58, RG 58A, RG 58B, or RG 58C.

NOTE

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

The crimping procedure for the connector requires careful attention to detail. It is important that these instructions be read and understood before crimping any of the connectors.

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

2. DESCRIPTION

The tool features a cylinder-shaped body, four collets, crimp tube, and CERTI-CRIMP ratchet. The body is mounted on a ram assembly which is actuated by the pivoted handles. When closed, the collets form one crimping chamber.

The CERTI-CRIMP ratchet ensures full crimping of the connector. Once engaged, the ratchet will not release until the tool handles have been FULLY closed.

CAUTION

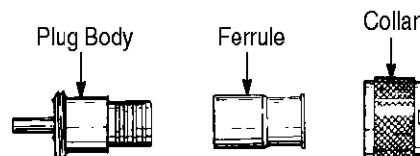
The collets bottom before the ratchet releases. This feature ensures maximum electrical and tensile performance of the crimp. Do NOT re-adjust the ratchet.

3. CRIMPING PROCEDURE

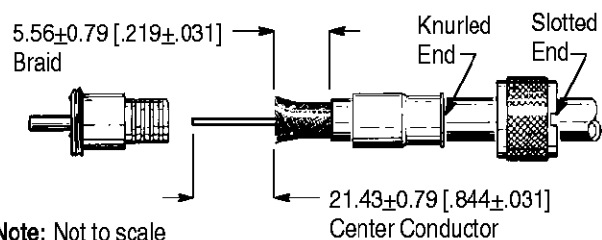
Refer to Figure 2, and strip the cable to the length shown. Do NOT cut or nick the center conductor or braid. Then assemble the connector as follows:

1. Slide the collar, slotted end first, and the ferrule, knurled end first, over the stripped cable.

Connector Components



Cable Stripping Dimensions



Note: Not to scale

Figure 2

2. Insert the cable center conductor into the plug body. Make sure that the braid passes over the plug support sleeve. See Figure 3, Detail A.

3. Slide the ferrule over the cable braid until the ferrule butts against the plug body. See Figure 3, Detail B.

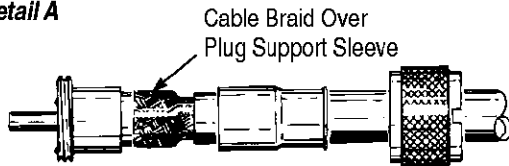
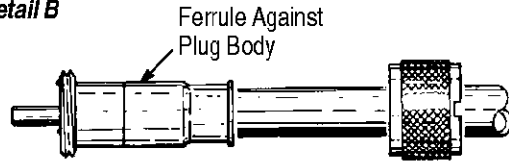
Detail A**Detail B**

Figure 3

4. Close the tool handles until the ratchet releases and the handles open FULLY.
5. Insert the plug and ferrule, as assembled on the cable, into the crimping chamber. Make sure that the plug is inserted straight, with the center contact entering the crimp tube at the bottom of the crimping chamber. Refer to Figure 4.

NOTE

When the plug bottoms inside the crimping chamber, no portion of the ferrule should be visible outside of the crimping chamber.

6. Close the tool handles FULLY until the ratchet releases.
7. Withdraw the crimped connector from the tool. Thread the plug collar onto the plug body.

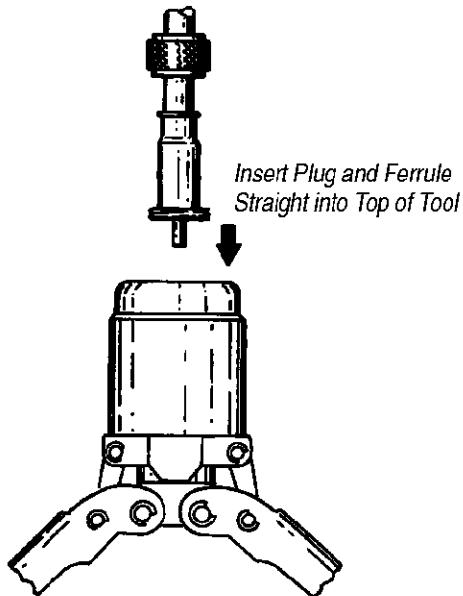


Figure 4

4. MAINTENANCE AND INSPECTION

The tool is inspected before shipment. It is recommended that the tool be inspected immediately upon arrival at your facility to ensure that the tool conforms to the dimensions provided in Section 5 and that the tool has not been damaged during transit.

4.1. Daily Maintenance

It is recommended that each operator of the tool be made aware of—and responsible for—the following steps of daily maintenance:

1. Remove dust, moisture, and other contaminants with a clean brush, or a soft, lint-free cloth. Do NOT use objects that could damage the tool.
2. Make certain all pins, pivot points, and bearing surfaces are protected with a THIN coat of any good SAE 20 motor oil. Do NOT oil excessively.
3. When the tool is not in use, keep the handles closed to prevent objects from becoming lodged in the crimping area and store the tool in a clean, dry area.

4.2. Visual Inspection

Though recommendations call for at least one inspection a month, the inspection frequency should be based on the amount of use, ambient working conditions, operator training and skill, and established company standards.

1. Make sure that the proper retaining pins are in place and secured with the proper retaining rings.
2. Inspect the body, with special emphasis on checking for worn, cracked, or broken collets. If damage to any part of the body is evident, refer to Section 5 for information on obtaining further evaluation and repair.

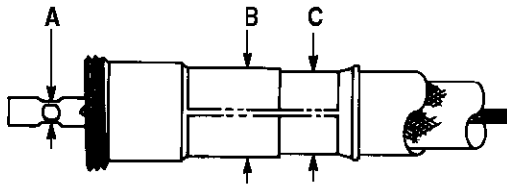
4.3. Crimp Height Inspection

This inspection requires the use of a micrometer with a modified anvil as shown in Figure 5. The modified micrometer (Crimp Height Comparator RS-1019-5L) is recommended and can be purchased from:

Shearer Industrial Supply Co.	or	VALCO
20 North Penn Street		1410 Stonewood Drive
York, PA 17401-1014		Bethlehem, PA 18017-3527

Proceed as follows:

1. Select a connector and appropriate cable for the connector.
2. Refer to Section 3, CRIMPING PROCEDURE, and crimp the connector accordingly.
3. Using a crimp height comparator, measure center contact and ferrule crimp heights as shown in Figure 5. If the crimp height conforms to that



CABLE TYPE	CRIMP HEIGHT DIMENSION (Max)		
	A	B	C
RG 58, RG 58A, RG 58B, or RG 58C	2.87 [.113]	7.44 [.293]	5.61 [.221]

Figure 5

shown, the tool is considered dimensionally correct. If not, refer to Section 5 for information on obtaining evaluation and repair.

For additional information concerning the use of the crimp height comparator, refer to 408-7424.

5. REPLACEMENT AND REPAIR

Customer-replaceable parts are listed in Figure 6. A complete inventory should be stocked and controlled to prevent lost time when replacement of

parts is necessary. Parts other than those listed should be replaced to ensure quality and reliability. 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:

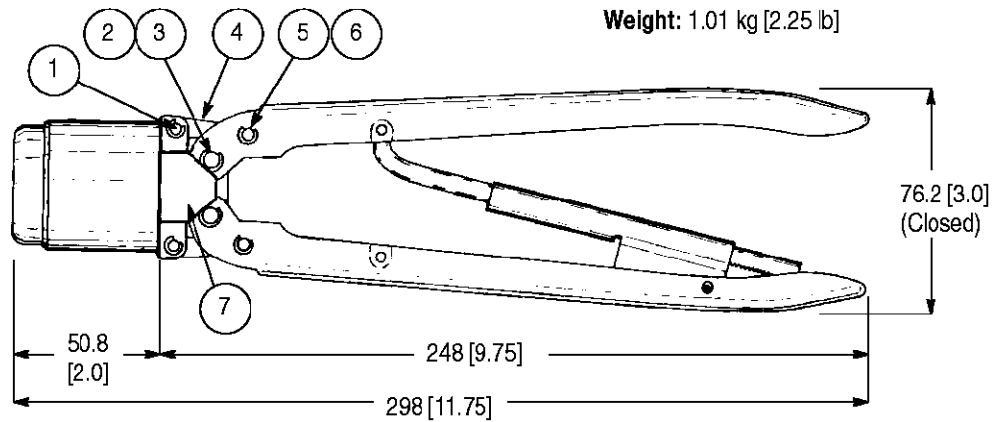
CUSTOMER SERVICE (038-035)
AMP INCORPORATED
PO BOX 3608
HARRISBURG PA 17105-3608

For customer repair service, please contact a representative at 1-800-526-5136.

6. REVISION SUMMARY

Revisions to this instruction sheet per EC 0990-0735-99 include:

- Updated document to corporate requirements
- Changed title of document
- Changed York Machinery to Shearer Industrial in Paragraph 4.2, C
- Replaced customer repair address with phone number
- Added information for ordering replacement parts to Section 5



REPLACEMENT PARTS

ITEM	PART NUMBER	DESCRIPTION	QTY PER TOOL
1	302487	PIN, Retaining	2
2	38807	PIN, Retaining	2
3	21045-6	RING, Retaining	4
4	303104	LINK	6
5	300388	PIN, Retaining	2
6	21045-3	RING, Retaining	8
7	306249	GUIDE	2

Figure 6