

## 1. Components:

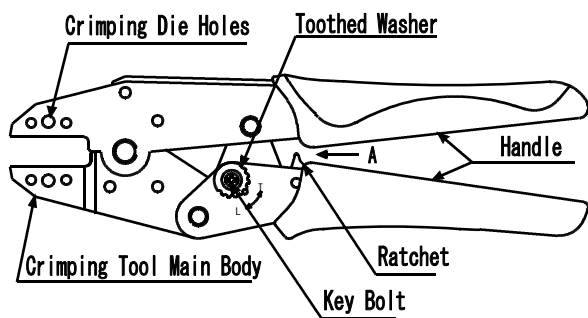


Fig 1: Crimping Tool(TC-1)

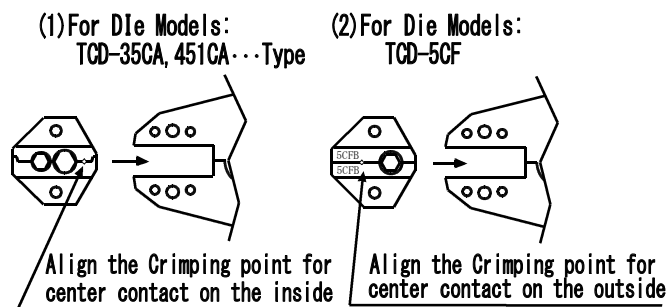


Fig 2: Crimping Die Attachment

## 2. Crimping Die Setup:

- (1) Select the correct die according to **Canare product catalog**.
- (2) Attach the crimping die as shown in **Fig 2** with the crimping point for center contact facing the user.

**Note:** The crimping die is attached properly when the crimping die holes align. Left handed users should flip the die so that it is facing the opposite direction.

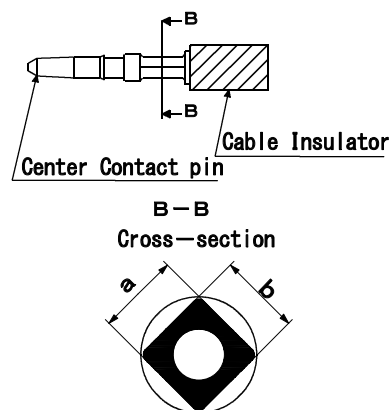
- (3) Insert bolts in the crimping die holes (**Fig 1**) and hand tighten the screws.
- (4) Squeeze the handles so that the crimping die engages. Without releasing the handles, tighten the bolts with a screw driver.
- (5) Squeeze the handles to make sure that the crimping tool is working properly.

## 3. Crimping:

- (1) In order to crimp CANARE connectors, please read the instructions supplied with the connectors.  
During the crimping operation, continue squeezing the handles after triggering the ratchet to insure complete crimping action.
- (2) Perform the following test to determine whether the center contact was crimped correctly.  
First measure, at right angles, the individual crimp height of "a" and "b" at the center of the crimped area (**Fig 3**)  
Be sure to remove splinters and remnants from the center contact before measuring crimp heights. next, calculate the average crimp height and compare it with the values listed in **Canare product catalog**.  
If the average crimp height is greater than the listed value, follow the instructions in **section 4**.
- (3) To open the crimping tool during operation, gently press the handles together and flip the ratchet in the direction of arrow "a".

**Note:** Use the connector assembly procedures manual to find the correct cable.

Fig 3: Crimp Height



$$\text{Average Crimp Height} = (a+b)/2$$

## 4. Maintenance:

- (1) Apply thin coat of oil to shafts and moving parts of the tool.
- (2) It is recommended that the crimp height be measured regularly. Due to normal wear and tear of the crimping die, or loosening of the main shaft, the crimp height may become too large. If this happens, simply adjust the tool according to the following instructions.
  1. Flip the ratchet in the direction of arrow "A" and open the handles as wide as possible.
  2. Loosen the key bolt using a screw driver.
  3. Remove the washer and the toothed washer. Remember which notch the pin is set in.
  4. Turn the shaft (on which the toothed washer is set) counterclockwise so that the toothed washer maybe reset one or two notches from the previous position.
  5. Re-assemble the toothed washer, the washer and the key bolt. Check to make sure that the pin is set in the right position.
  6. Grip the handles and press them together to make sure the unit is working properly. Test the unit to confirm that the crimp height now fall within specifications.