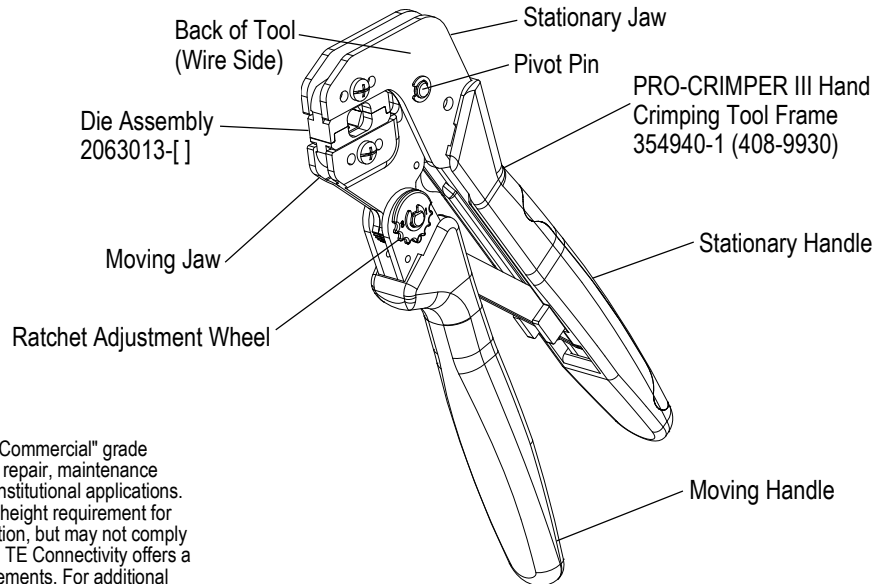


PROPER USE GUIDELINES

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.

NOTE: SDE-SA Tool Frame 9-1478240-0 Can Also be Used (408-8851)



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 114 series specification, 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.

DIE PART NUMBER	NEST SIZE "A" (mm)	CONNECTOR NAME
2063013-1	9.80	HVA280 MULTI-CORE
2063013-2	9.40	HVA280
2063013-3	6.80	HVA280-2phi
2063013-4	6.20	HVA280-2phi
2063013-5	10.75	HVA280 MULTI-CORE
2063013-6	7.40	HVA280-2phi

Figure 1

1. INTRODUCTION

The SDE die assembly 2063013-[] is used to crimp various HVA280 connectors. Refer to Figure 1 for specific connector types.



NOTE

Dimensions on this sheet are in millimeters. Figures and illustrations are for identification only and are not drawn to scale.

For additional information on the hand tool frame, refer to Instruction Sheet 408-9930. For the selection of Series F coaxial connectors, contact TE Connectivity Product Engineering for connector recommendations at the number at the bottom of this page.

Reasons for reissue of this instruction sheet are provided in Section 8, REVISION SUMMARY.

2. DESCRIPTION

The tool features a tool frame with a stationary jaw and handle, a moving jaw, a moving handle, and an adjustable ratchet that ensures full connector crimping. The tool frame holds the die assembly.

The die assembly features an anvil and a nest containing a hex crimping cavity. Each die is held in the hand tool by a single screw.

3. INSTALLATION AND REMOVAL OF THE DIE ASSEMBLY (Figure 2)

1. Open the tool handles and remove the two die retaining screws from the tool jaws.
2. Slide the die assembly into the partially opened tool jaws.
3. Insert the die retaining screws and tighten the screws just enough to hold the dies in place. Do not tighten the screws completely at this time.
4. Carefully close the tool handles, making sure the dies align properly. Continue closing the tool handles until the ratchet in the tool frame has engaged sufficiently to hold the die in place, then tighten both die retaining screws.
5. To disassemble, close the tool handles until the ratchet releases, remove the two die retaining screws, and slide the dies out of the tool jaws.

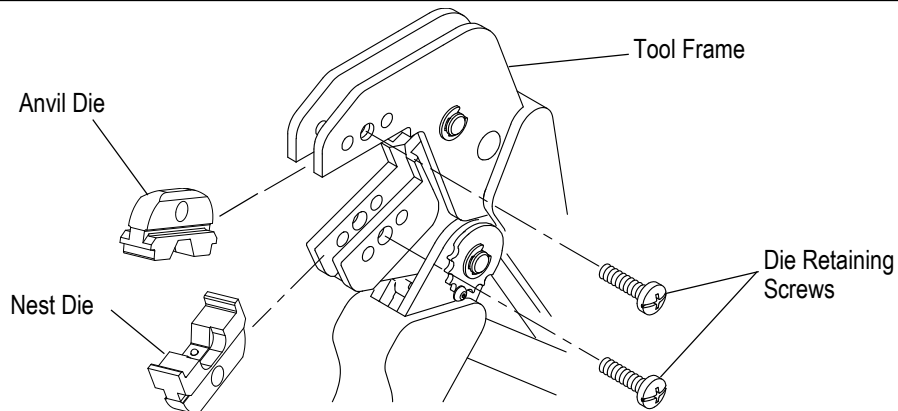


Figure 2

4. CRIMPING PROCEDURE



NOTE

Before using the tool, the crimping chamber and tool ratchet should be inspected as specified in Paragraph 5.2, Measuring Die Opening, and Paragraph 5.3, Ratchet Adjustment.

Strip cable according to the proper dimensions and assemble the connector to the cable according to the instructions in the appropriate connector instruction sheet. Then proceed as follows:

1. Place connector in the nest die so that the edge of the connector is flush with the edge of the die. See Figure 3.
2. Holding the assembly in place, close the tool handles until the ratchet releases.
3. Remove the crimped assembly from the crimping die.

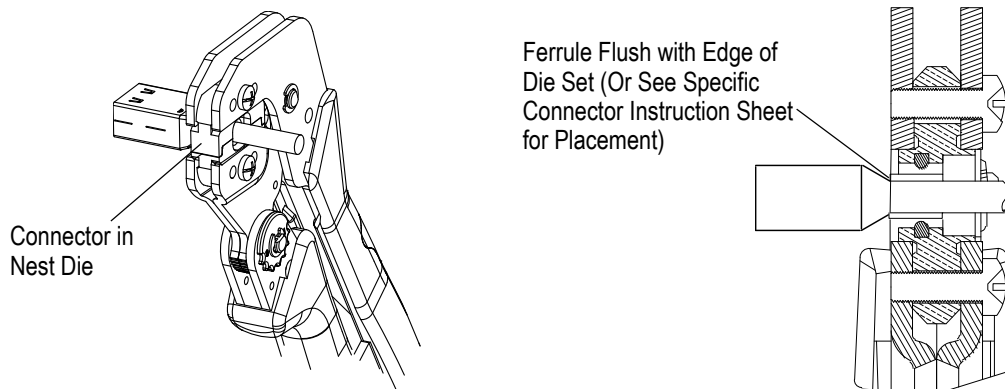


Figure 3

5. INSPECTION

5.1. Visual Inspection

Inspection of the crimping dies should be made on a regular basis to ensure that they have not become worn or damaged. Inspect the crimp sections for flattened, chipped, worn, or broken areas. If damage or abnormal wear is evident, the dies must be replaced. Refer to Section 7, REPLACEMENT.

5.2. 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 opening is correct, and (4) the tool has been adjusted correctly. Refer to Figure 4 for die nest information.

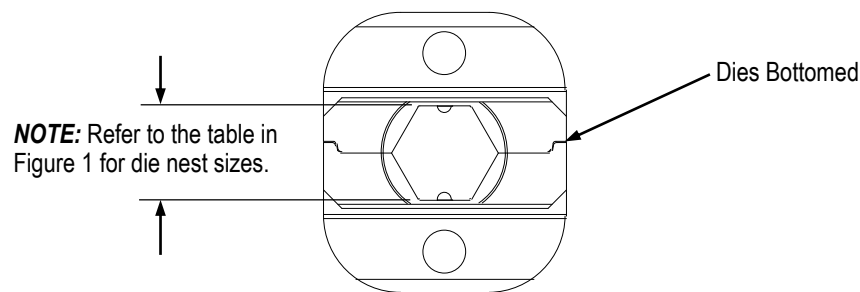


Figure 4

5.3. Ratchet Adjustment (Figure 5)

The ratchet mechanism features an adjustment wheel with eight settings. The adjustment wheel controls the amount of handle pressure exerted on the tool jaws and crimping dies during crimping. If the crimp is not acceptable, adjust the ratchet as follows:

1. Sufficiently loosen the screw at the ratchet adjustment wheel so that the wheel can be rotated above the post that engages the teeth in the wheel.
2. If the crimp is too loose, turn the wheel to a higher notch (for example, if the wheel is set at notch 5, move the wheel to notch 6). If the crimp is too tight, move the wheel to a lower notch.
3. Tighten the screw at the ratchet adjustment wheel.

If the crimp cannot be made to conform to the dimensions provided in the appropriate product application specification, the tool and/or dies are defective and must be replaced.

i **NOTE** Other dies for PRO-CRIMPER III hand tool frames may be used in this tool; however, the ratchet adjustment wheel may require adjustment to achieve acceptable crimp height.

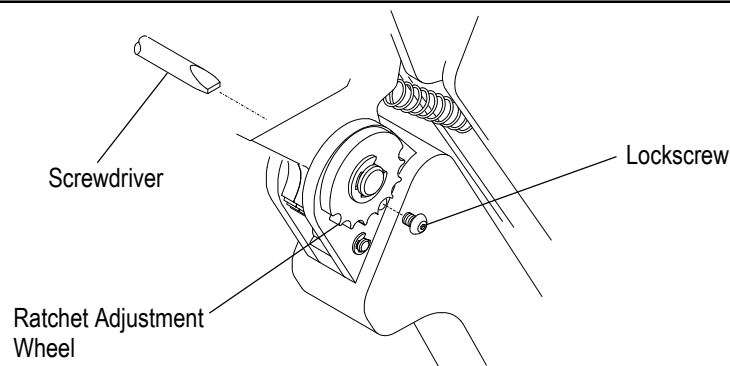


Figure 5

6. MAINTENANCE

Ensure that the tool and dies are clean by wiping them with a clean, soft cloth. Remove any debris with a clean, soft brush. Do not use objects that could damage the tool. When not in use, keep handles closed to prevent objects from becoming lodged in the dies, and store in a clean, dry area.

7. REPLACEMENT

Customer-replaceable parts are shown in Figure 1.

Available separately, PRO-CRIMPER III Hand Tool Repair Kit 679221-1 includes a replacement nut and a variety of pins, rings, screws, and springs.

If the dies are damaged or worn excessively, they must be replaced.

Order the repair kit and replaceable parts through your TE Representative, or call 1-800-526-5142, or send a facsimile of your purchase order to 717-986-7605, or write to:

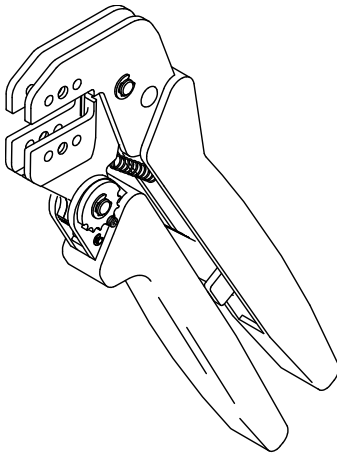
CUSTOMER SERVICE (038-035)
TYCO ELECTRONICS CORPORATION
PO BOX 3608
HARRISBURG PA 17105-3608

8. REVISION SUMMARY

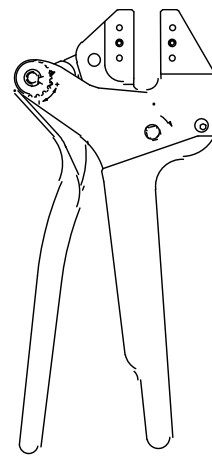
- Initial release of document

Die Assembly 2062013-[] Can be Used in the Following Tooling

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



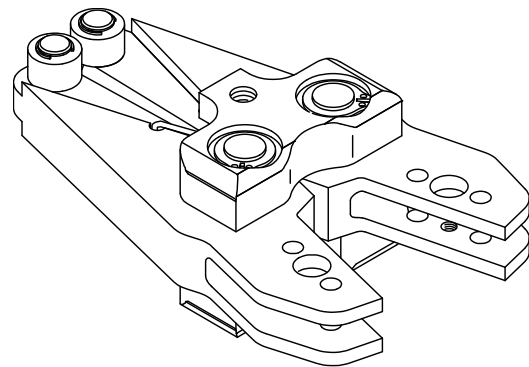
SDE-SA Hand Tool 9-1478240-0
(Instruction Sheet 408-8851)



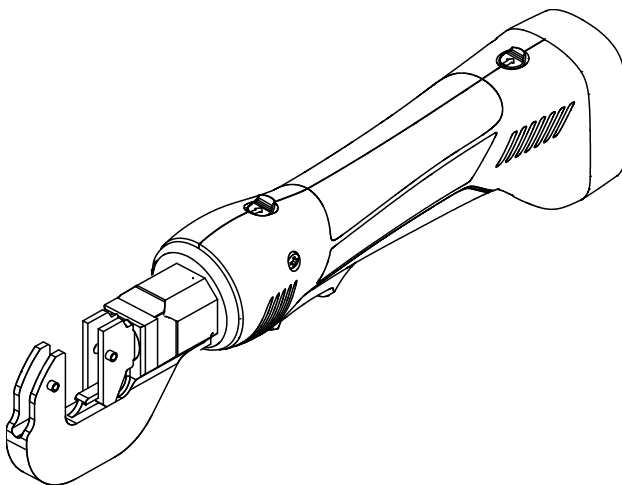
SDE Bench Terminator 1490076-2
(Customer Manual 409-10052)



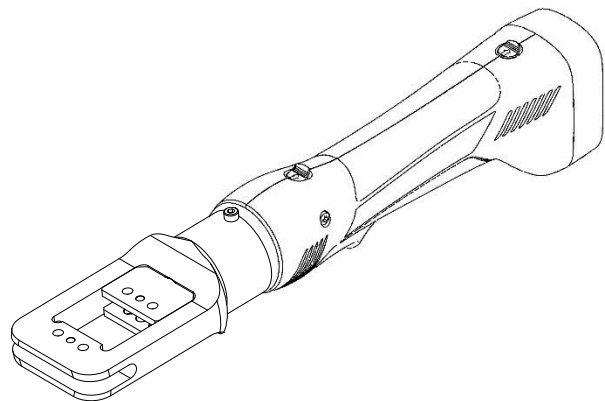
626 Adapter 679304-1
(Instruction Sheet 408-4070)



Battery Tool (Shouldered Die) 1725837-1, -2
(Customer Manual 409-10053)



Battery Tool (Pin/Shouldered Die) 1213890-1, -2
(Customer Manual 409-10065)



NOTE: Since crimped splices cannot be removed from this tool, **DO NOT** crimp splices in this battery tool.

Figure 6