

**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.

CABLE	PLUG	JACK	BULKHEAD JACK	RIGHT-ANGLE PLUG	CRIMPING TOOL	CRIMPING DIES†
RG 304	331109 331109-1† 331109-2†	331133 331133-1†	226484-1† 226484-2	1-332292-7 1-332292-8† 1-332292-9†	69811	220006-1

†For use in Hand Tool 69710 or Pneumatic Tool 69365. †Engineering controlled.

Figure 1

**1. INTRODUCTION**

The Series TNC Connectors listed in Figure 1 are used with Hand Tool 69811, with Dies 220006-1 in Hand Tool 69710, or Pneumatic Tool 69365.

**2. CRIMP END ASSEMBLY**

1. Slip the ferrule on the cable, then strip the cable and flair braid as shown in Figure 2.
2. Insert stripped conductor into the wire barrel on the crimp end. Twist crimp end slightly to ease entry of wire.

3. Push crimp end back under braid so that the braid passes over and around the support sleeve. Apply sufficient pressure to cause the cable dielectric to bottom against the dielectric of the crimp end. See Figure 2. Twist the crimp end slightly to ensure bottoming.
4. Slide the ferrule forward and over the braid on the crimp end as far as it will go. Crimp end is now ready to be crimped. See Figure 2.

**3. CRIMPING PROCEDURE**

**3.1. Hand Tool 69811**

1. Open crimping dies by closing the tool handles until the CERTI-CRIMP\* hand crimping tool ratchet control releases. Note that once the ratchet is engaged, the handles cannot be opened until they are fully closed.
2. The crimping tools have double sets of dies, see Figure 3, to crimp the braid ferrule and wire barrel of the jack or plug crimp end. Ferrule and wire barrel are crimped at the same time.
3. Place the crimp end in the crimping dies as shown in Figure 3.

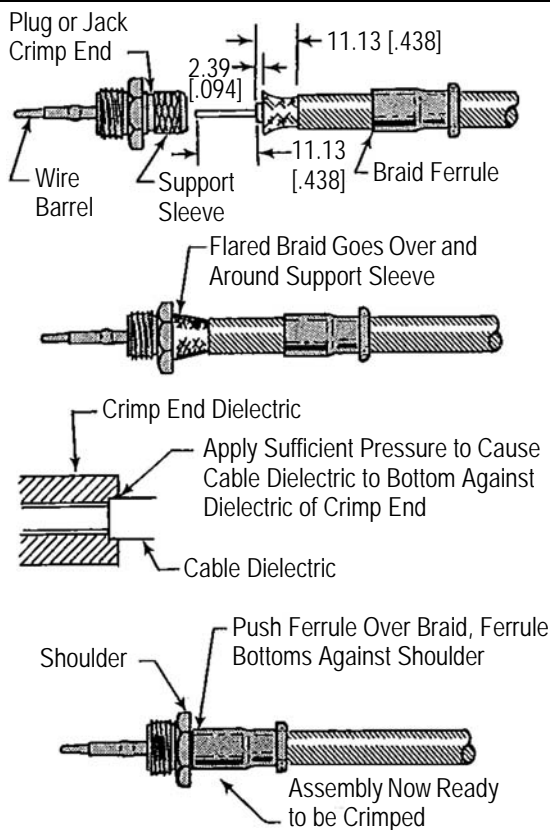


Figure 2

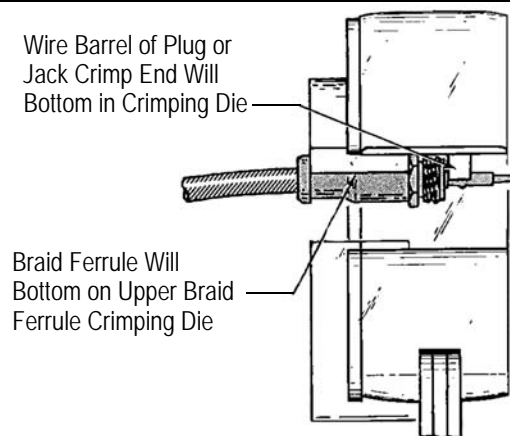


Figure 3

4. Make certain that the wire barrel and braid ferrule of the crimp end are resting firmly on the crimping dies. See Figure 3.

5. Hold the assembly in place and close the handles until the CERTI-CRIMP hand crimping tool ratchet control releases to complete the crimp.

### 3.2. Interchangeable Dies

Series TNC COAXICON crimping dies are used in tools 69710 and 69365. Read the instructions shipped with the tools for information concerning die insertion and general tool performance, then proceed as follows:

1. Place the crimping dies in tool.
2. The die assemblies have double sets of crimping dies similar to those in hand tools. See Figure 4.

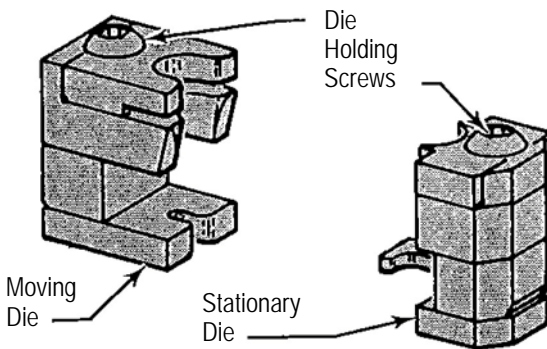


Figure 4

3. Place the jack or plug crimp end in the crimping dies as shown in Figure 5.

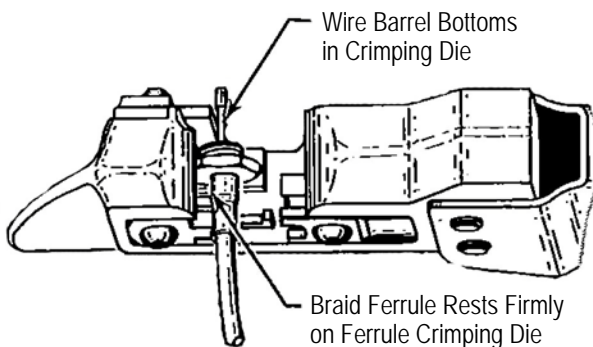


Figure 5

4. Make certain the wire barrel and braid ferrule of the crimp end are resting firmly on the crimping dies. See Figure 5. Hold the assembly in place and complete the crimp.

### 4. JACK AND PLUG ASSEMBLY

1. Assemble the jack crimp end and jack body as shown in Figure 6.

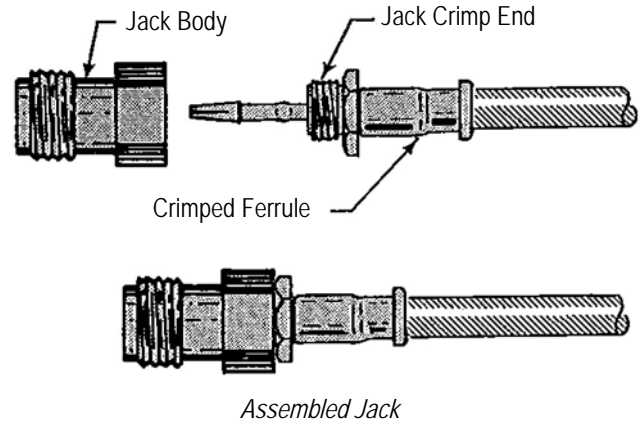


Figure 6

2. Assemble the plug crimp end and plug body in the same manner as shown for the jack assembly. See Figure 7.

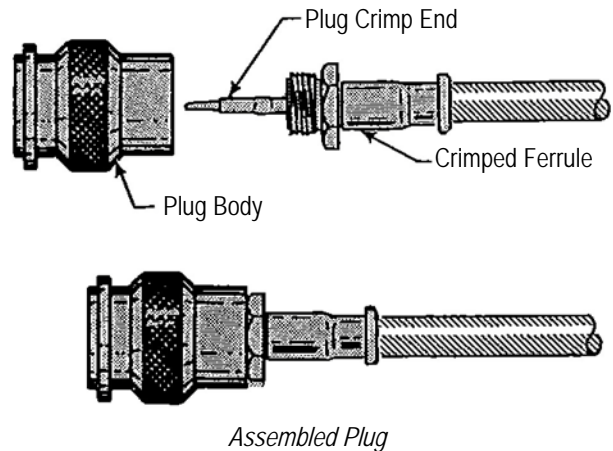


Figure 7

3. Use a wrench on flats to tighten. A torque of 1.70 to 2.26 N•m [15 to 20 in.-lbs] is suggested.

### 5. REVISION SUMMARY

- Updated document to corporate requirements
- Reactivated document