Hand Crimp Tool (TC-1)

Product Image

Product Name
Hand Crimp Tool
Model Number
TC-1

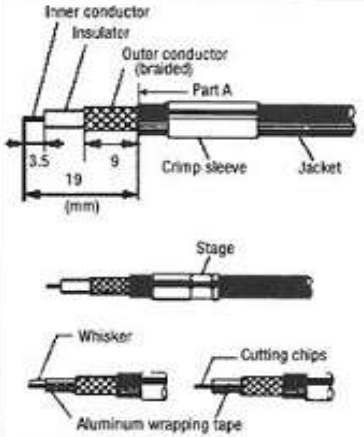
Canare Crimp Plugs, BNC, DIN 1.0/2.3, F, RCA and More!

- Interchangeable die sets.
- Scissor ratchet action.
- Emergency release lever.
- Adjustable crimp force via drag washer.
- Hardened Swedish Steel construction.
- Rated at 50,000 dura-cycle lifespan.
- Hand Crimp Tool.
- Hardened Swedish Steel.
- Ratchet Release.
- Pack Qty: 1 pc.

Crimp Tools (Cables to Connectors Cross-Reference.
BNC, F, RCA, etc... DIN 1.0/2.3

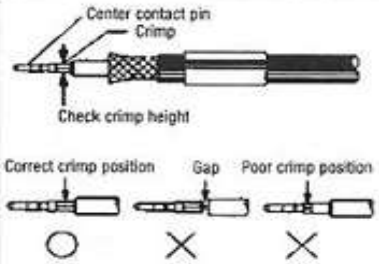
Note: All of Canare crimp plugs, BCP-A,-B,-C, RCAP-C and FP-C, are the same procedure.

Crimp Connector Assembly Instructions



Confirm compatibility of the connector and cable prior to assembly.

1. Slide the crimp sleeve over the cable and strip the jacket, braided shield, and insulation of the coaxial cable as shown at left.
   - For cables with stranded inner conductor, twist the strands in the same direction as plied after removing the insulation.
   - For a crimp sleeve with steps, slip it over the cable from the stepped end, as in the diagram.
   - If any aluminum foil shield is left on the cable, it may get stuck in the mouth of connector, making insertion impossible.
   - Remove all stray strands and offcuts of the aluminum foil shield to avoid possible short circuiting.
   - Make sure the inner conductor is free of all insulation debris and offcuts to ensure complete crimping.



2. Place the center contact pin of the connector on the inner conductor of the cable and crimp the center contact pin at the correct position (without remaining a gap) as shown at left, using the specified crimp tool and die set.
   - To confirm the crimping properly, measure the crimp height after removing burrs with a knife. If it is not within the ideal value range, adjust the crimp tool.
   - Do not crimp the center contact pin at the stepped root end.
   - Confirm the center contact pin is crimped straight to the inner conductor. If the center contact pin is slanted, align it gently.

3. Hold the cable and push it into the connector body until the center contact is locked in place. You may feel a click sound when the center contact pin is locked.
   - Pull the cable gently (less than 4.5lbs or 19.6N) to confirm that is locked.

4. Slide crimp sleeve up against connector body over the braided shield until it butts against the connector body. Center the die over the crimp sleeve and crimp in place, using the specified crimp tool and die set.
   - Do not pull the cable while crimping is executed.

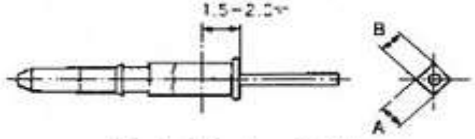
Adjusting Crimp Tool

1. Measuring Crimping height

Crimp height is measured after the crimp is made. As shown in the figure, the sum of the measured values for both directions is divided by two to arrive at the crimp height. The ideal value range for the BCP-A3 connector, for example, is 1.4mm to 1.5mm. When this value is lower (overcrimping occurs) than the recommended crimp height, the crimp becomes very hard. A value higher (undercrimping occurs) than the recommended value can result in increased electrical resistance and a physically weaker crimp. Either digital calipers or a micrometer should be used for measuring crimp height.

2. Measuring Frequency

Crimp height is measured prior to commencing use of the crimp tool and always when changing the crimping die. After this, the crimp height is regularly measured after about each 1,000 crimps.

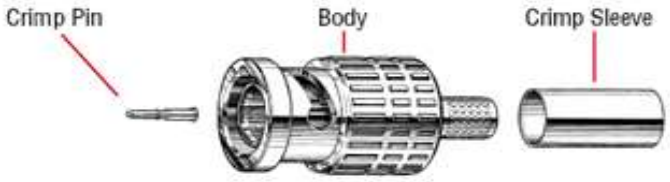


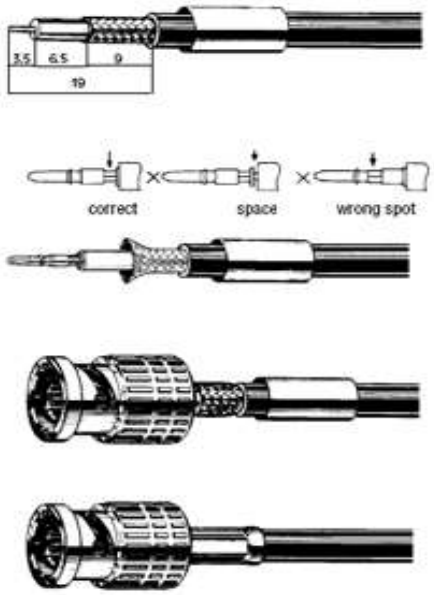
Crimp height value= (A+B) /2

Refer to the separately included manual for the appropriate crimp height values for individual connectors.

3. Tool Measuring Procedures

Crimp force increases and crimp height decreases when the tool's adjuster dial is turned in the direction of the 9. The dial is adjusted by first releasing it using a screw driver.





1. Slide crimp sleeve over cable.
2. Strip cable jacket using Canare TS-Series Coax Strippers (see mm dimensions)
3. Place contact pin on center conductor. Using the TC-1 hand tool and appropriate die set, crimp center pin as shown in diagram. (Do not leave a gap between rear of the pin and cable insulation end.)
4. Flair braided shield to aid insertion of connector body.
5. Push cable with crimped pin into body housing until you detect an audible "snap". (Jamming the pin may bend center conductor and damage connector dielectric.)
6. Lightly tug cable (@ 4.5 lbs/2.0 kgs) to verify that pin is properly seated in body housing.
7. Slide crimp sleeve up against the body and place in tool die.
8. Complete assembly by crimping down on sleeve to form hex.

Note: *Flair gap at sleeve end is normal and allows cable jacket extra flexing room.*

Phone: 973-837-0070 Fax: 973-837-0080