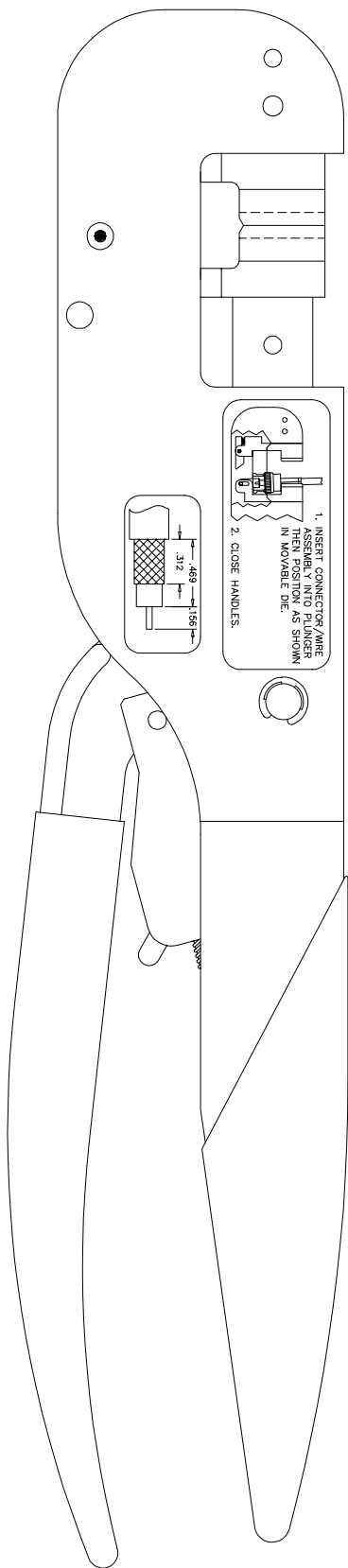


050-000-0030120/150

LOCK/GRIMP ASSEMBLY TOOL

FOR DETAILS ON EMERGENCY
RATCHET RELEASE SEE
FIGURE 1.



RECOMMENDED FOR R&D, PROTOTYPING, MAINTENANCE & REPAIR

PRECISION CONSTRUCTION OF DURABLE HIGH CARBON STEEL

EXTRA STRENGTH PIVOT PINS FOR GREATER DURABILITY

RATCHET CONTROL ASSURES A COMPLETE CRIMPING CYCLE

EMERGENCY RATCHET RELEASE

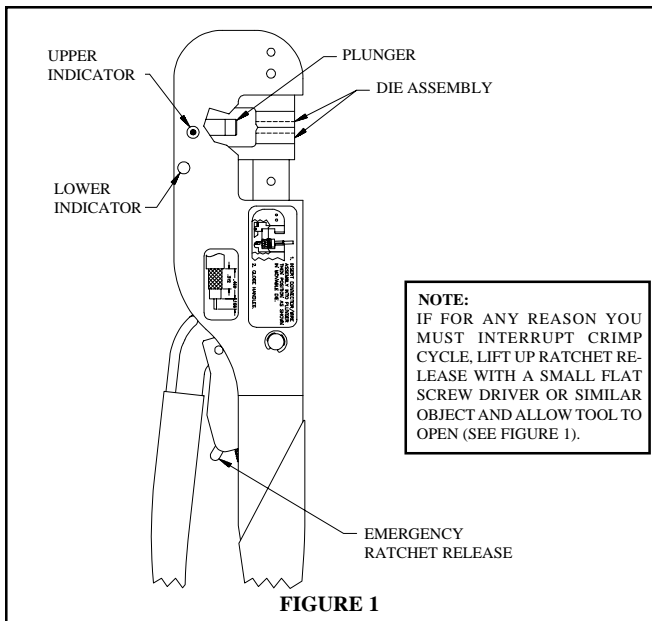
INTERCHANGEABLE DIES ARE AVAILABLE

ITT Industries Inc., 100 Sebeth Drive, Cromwell, CT 06416 USA
PHONE: (860) 635-1500 • FAX (860) 860-2010

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INTRODUCTION:

The 050-000-0030120 Hand Crimping tool is designed to lock/crimp 75 OHM Q.T. BNC plugs onto 735 cable. The tool has a replaceable die assembly 050-000-0030-122 specifically designed to lock the center pin, then crimp the outer ferrule of the Q.T. BNC plug onto the cable in a single cycle of the tool. The 050-000-0030150 Hand Crimping tool is designed to lock/crimp 75 OHM Q.T. BNC plugs onto 734 & RG59 cable. The tool has a replaceable die assembly 050-000-0030152 specifically designed to lock the center pin, then crimp the outer ferrule of the Q.T. BNC plug onto the cable in a single cycle of the tool.

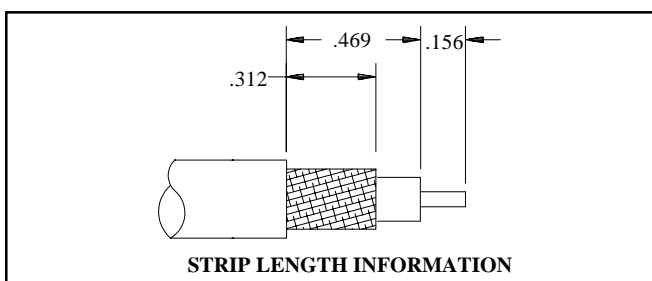


PROPER USAGE GUIDELINES:

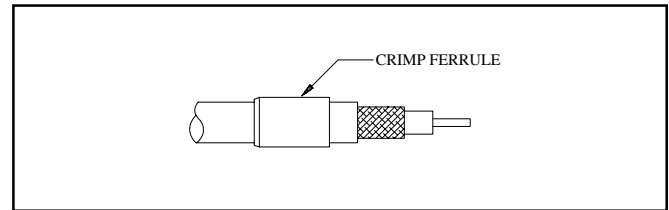
Cumulative Trauma Disorders can result from the prolonged use of manually powered hand tools. Hand tools are intended for occasional use and low volume applications. Powered application equipment should be considered for extended-use, and production operations.

CRIMPING PROCEDURE:

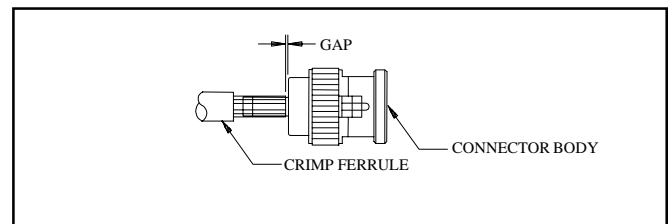
1. Strip cable to dimensions shown. Do not nick outer or inner conductors.



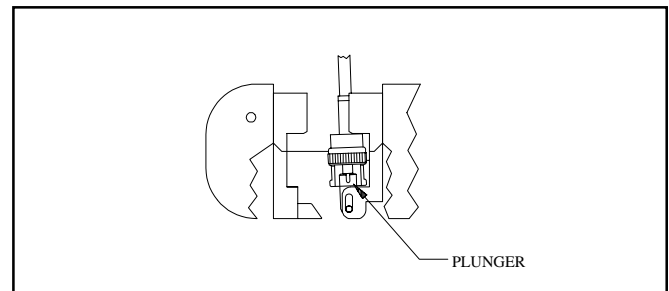
2. Slide crimp ferrule over the cable.



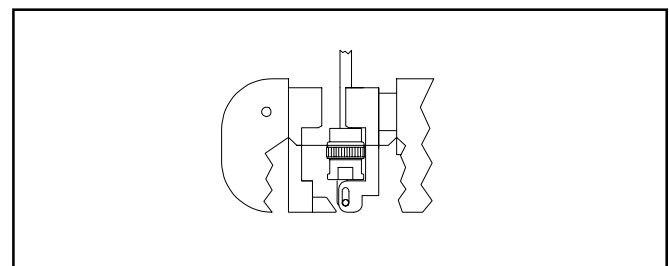
3. Slide the connector body over the cable so that the rear body locates between the dielectric and the braid. Make sure the center conductor is straight and free of any nicks and burrs. Care must be taken to ensure that no strands of braid are trapped under the body. A small gap should be evident between braid and face of body.



4. Slide crimp ferrule over braid and load the connector assembly into the crimp tool as shown, making sure the center pin is aligned with the hole in the plunger. Notice the white dot in the lower indicator.



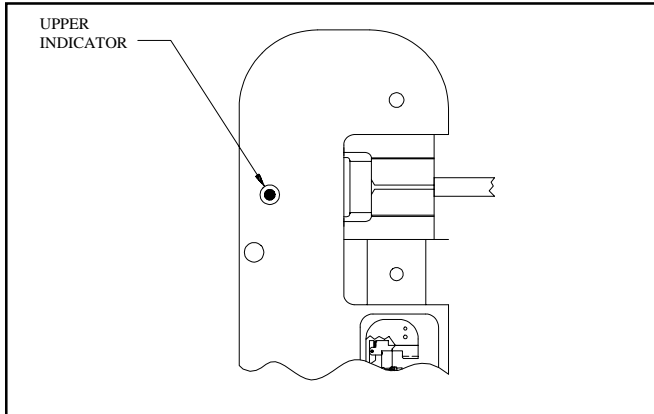
5. Begin closing the tool handles, making sure the connector assembly remains in the locked position. Notice the white dot begin to move to the upper indicator.



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6. Close handles until the white dot moves into the upper indicator. This indicates a positive termination of the center conductor to the center contact. A light pull test may be conducted.

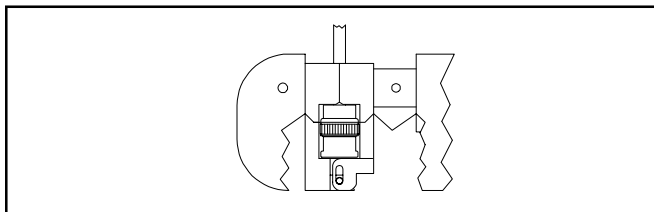


3. All pins, pivot points, and bearing surfaces should be protected with a thin coat of any good SAE No. 20 motor oil. Do not oil excessively.
4. When the tool is not in use, keep the handles closed to prevent objects from becoming lodged in the crimping jaw. Store the tool in a clean, dry area.

Periodic Inspection:

Regular inspections of the tool should be performed by quality control personnel. A record of scheduled inspections should remain with the tool or be supplied to supervisory personnel responsible for the tool. Inspection frequency should be based upon the amount of use, working conditions, operator training and skill, and established company standards.

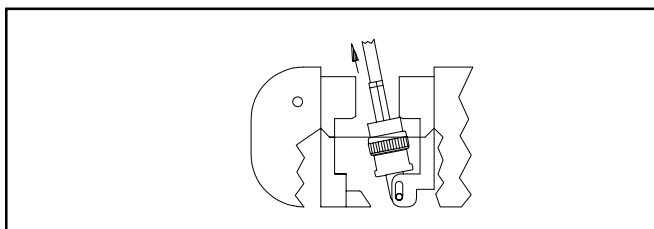
7. Continue closing the tool handles until the ratchet releases. The ferrule is now crimped.



Visual Inspection:

1. Make certain that all retaining pins are in place and secured with retaining rings.
2. Close tool handles until ratchet releases and then allow them to open freely. If they do not open quickly and fully, the spring is defective and must be replaced.
3. Inspect the tool frame for wear or damage, paying particular attention to the tool jaws and pivot points. If tool is acceptable, lubricate and return to service.
4. Check the crimping dies occasionally to make sure dies are not broken or chipped.

8. Allow the tool handles to return to the open position. Lift cable end of connector and remove assembly from crimp tool. Tool is now ready for the next crimp.



DIE INSTALLATION:

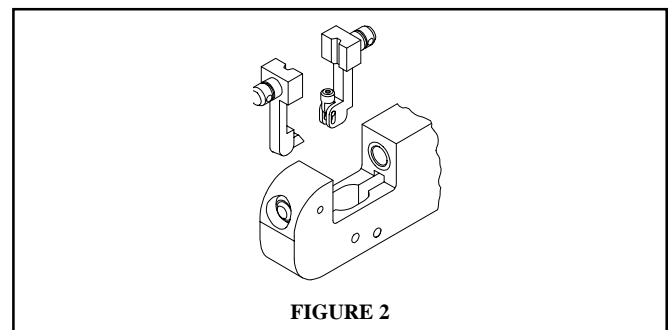
1. Install die set into tool frame as shown in figure 2. Dies will snap into place.
2. Close handle to make sure dies are properly seated. The tool is now ready for use.

MAINTENANCE AND INSPECTION:

Daily Maintenance:

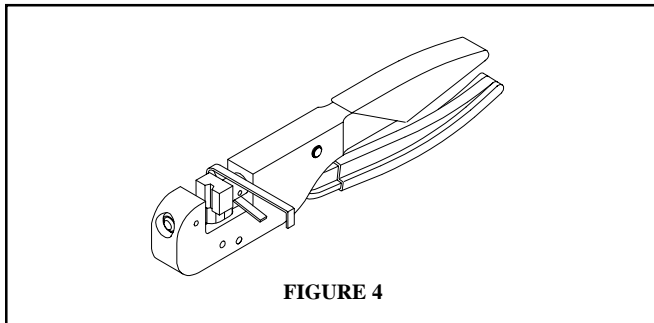
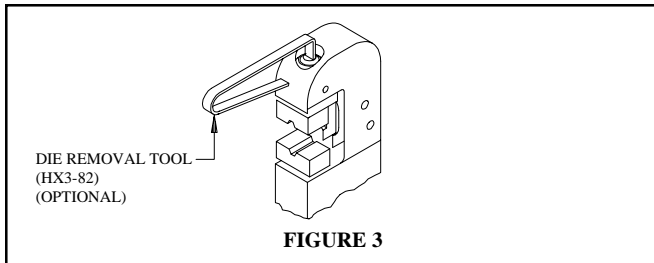
It is recommended that operators of the tool be made aware of, and be responsible for the following steps of daily maintenance:

1. Remove dust, moisture, and any other contaminants from the tool with a clean, soft brush, or a clean, soft, lint-free cloth. **DO NOT** use hand or abrasive objects that could damage the tool.
2. Make certain the tool retaining pins are in place and that they are secured with retaining rings.



DIE REMOVAL:

1. With crimping tool handle open, place die removal tool against end of knock-out pin and tap gently (see figure 3). The die will be released from the front die holder. It can now be removed by hand.
2. Close the crimping tool handle and slide the die removal tool between the die and tool body (see figure 4). Pull handle open with a snap action. The die will be released and can then be removed by hand.

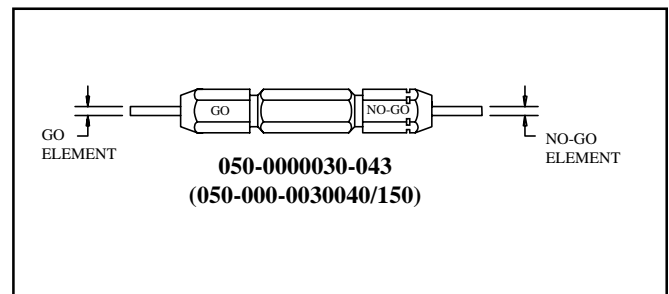
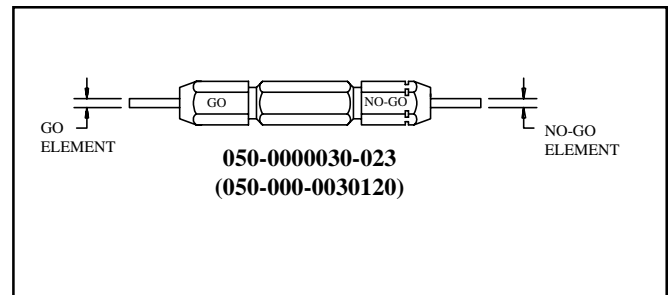


GAGING:

This inspection requires the use of a plug gage as shown below.

Procedure:

1. Close dies and hold together by squeezing tool handles with moderate pressure.
2. Insert "Go" end of gage into hex cavity. The gage must pass completely thru the cavity.
3. Attempt to insert the "No-Go" end of the gage into the hex cavity. The gage may start but must not pass completely thru the cavity.
4. If the dies do not pass this procedure, the dies must be replaced or repaired before use.



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The QT-BNC dual action hand tool frame with crimp die comes precalibrated from Daniels Manufacturing Corporation. The tools design criteria was based on specification M22520/5-01 for military hand tools. The hand tool is extremely rugged and the dies are made of hardened steel. The hand force required to cycle the tool is factory preset at 20-35 pounds. ITT Industries offers a go/no-go gage to check the hex die (part number varies according to the hex size in the die).

It is recommended that the hex dies be periodically inspected and checked with a go/no-go gage. The inspection frequency should be based upon the amount of use, working conditions, operator training, skill and established company standards. A recommended practice would be to check the hex die with a gage prior to each days usage.

The hand tool frame should also be periodically inspected and checked with a device that measures hand forces of crimp tools. A recommended practice is to check the hand force of the tool frame annually.

Should you require your QT-BNC hand tool be inspected annually, Daniels Manufacturing has offered to inspect and check the calibration of their hand tools for \$50.00* per tool. A \$75.00* fee will be charged for normal repairs. If major repairs are necessary, Daniels will contact the customer before making said repairs. Customer should include a return address, a description of the malfunction and the name and phone number of someone familiar with the problem. The hand tool would be returned with a calibration sticker certifying the day it was calibrated and inspected. The service center address is:

Daniels Manufacturing Corp.
526 Thorpe Road
Orlando, FL 32824
Phone: (407) 855-6161
Fax: (407) 855-6884
e-mail: dmc@dmctools.com

* Pricing subject to change.