



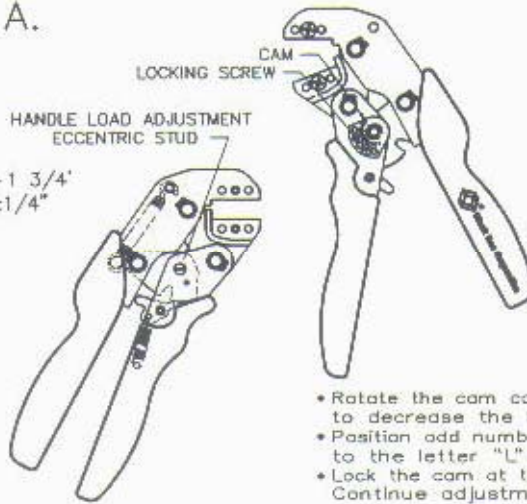
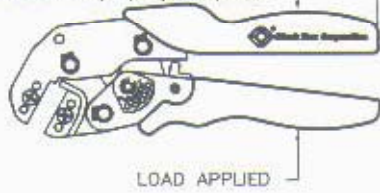
Black Box Corporation

MADE IN U.S.A.

CRIMP TOOL OPERATING PROCEDURE

Apply force as shown until ratchet releases. The force at a point approx. 1 3/4" from handle ends should vary between 5-35 lbs. depending on the style/type and size of contact and/or wire size.

In general, the style or type of contact crimped determines the level of handle pre-load, with larger contacts requiring higher pre-loads for properly completed crimps.



TOOL MAINTENANCE

Maintenance and inspection should be performed regularly. Tool should be wiped clean with special emphasis on the crimping cavities. Tool may be cleaned by immersing in a suitable commercial solvent or cleaner which does not attack points or plastic material. The tool should be re-lubricated after cleaning using a light film of a medium weight oil on bearing surfaces and pivot pins. When not in use, keep handles closed to prevent objects from becoming lodged in the crimping dies and store in a clean dry area.

ECCENTRIC ADJUSTMENT

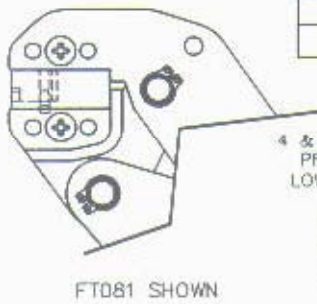
- To adjust the tool to obtain the proper force values, open the handles and remove the cam locking screw with a 1/16" hex wrench.
- Rotate the cam counterclockwise to increase handle load or clockwise to decrease the handle load.
- Position odd numbers on the cam in the locking screw hole adjacent to the letter "L" and even numbers adjacent to the letter "T".
- Lock the cam at the desired handle load setting and remeasure force. Continue adjustment if necessary.

PART No. FT08DA
(TOOL FRAME)

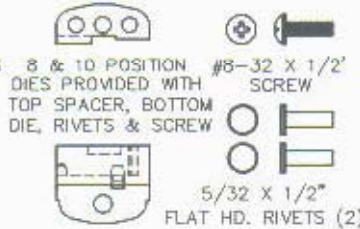


CAT No.	NUMBER POSITIONS	MOD. PLUGS ACCOMMODATED
FT081	4/6 POSITION	RJ-11
FT082	6 POSITION	RJ-11 LONGBODY
FT083	8 POSITION	RJ-45
FT084	10 POSITION	10 POSITION

Strip cable according to manufacturer's specifications. Insert cable fully into connector. Place connector in die, end of modular plug butting against back of die cavity, and close tool completing crimp cycle. Grasp cable near connector and lift and pull to remove cable/plug assembly. Inspect crimp to assure all contacts are crimped and strain relief portion is latched. Test by holding plug and pulling firmly on cable.



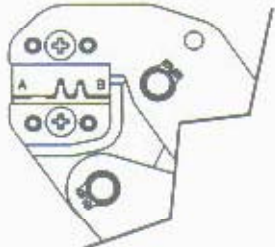
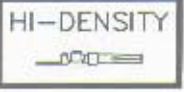
4 & 6 POSITION DIES PROVIDED WITH LOWER DIE ONLY



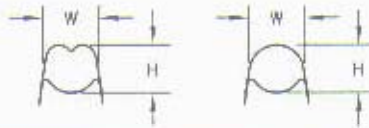
8 & 10 POSITION DIES PROVIDED WITH TOP SPACER, BOTTOM DIE, RIVETS & SCREW

5/32 X 1/2" FLAT HD. RIVETS (2)

THE TOOL IS EQUIPPED WITH A RATCHET MECHANISM TO ASSURE RELIABLE CRIMP TERMINATIONS. A RATCHET RELEASE LEVER IS PROVIDED TO ALLOW FOR REMOVAL OF AN INCORRECTLY PLACED OR OVERSIZE CONNECTOR. ADJUST RATCHET RELEASE HANDLE FORCE TO 5-15 LBS. FOR MODULAR PLUGS AS INSTRUCTED ABOVE IN ECCENTRIC ADJUSTMENT SECTION.



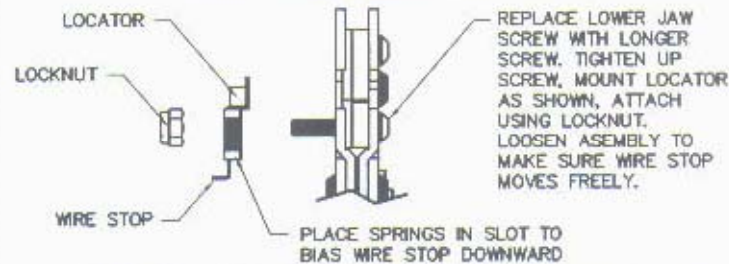
PART No. FT093



NEST	CONDUCTOR		INSULATION	
	HEIGHT	WIDTH	HEIGHT	WIDTH
A	.032 NOM.	.056 REF.	.057 NOM.	.057 REF.
B	.028 NOM.	.054 REF.	.044 NOM.	.054 REF.

GAGING WITH WIRE SOLDER

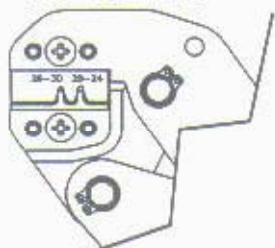
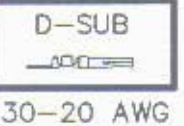
LOCATOR ASSEMBLY PROCEDURE



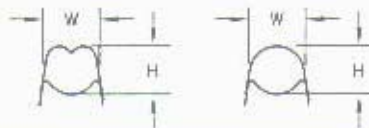
REPLACE LOWER JAW SCREW WITH LONGER SCREW. TIGHTEN UP SCREW, MOUNT LOCATOR AS SHOWN, ATTACH USING LOCKNUT. LOOSEN ASSEMBLY TO MAKE SURE WIRE STOP MOVES FREELY.

PLACE SPRINGS IN SLOT TO BIAS WIRE STOP DOWNWARD

NOTE: SHOULD OVERCRIMPING OF CONTACT RESULT- ADJUST RATCHET RELEASE FORCE TO 15-30 LBS. FOR D-SUB. AND HI-DENSITY STYLE CONTACTS. GAGE CRIMPS WITHIN SPECIFICATIONS- ADJUST HANDLE PRE-LOADS ACCORDINGLY. REFER TO ECCENTRIC ADJUSTMENT PROCEDURE ABOVE.



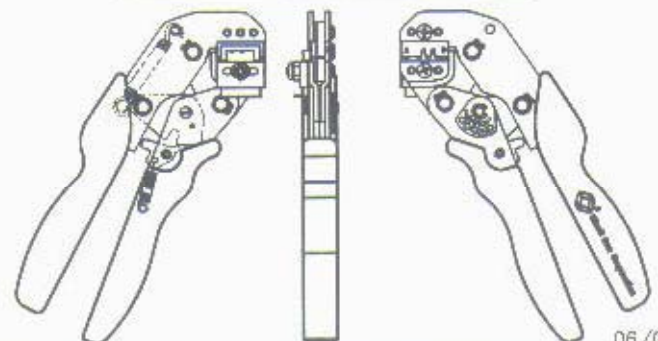
PART No. FT094

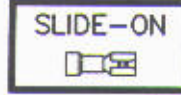


NEST	CONDUCTOR		INSULATION	
	HEIGHT	WIDTH	HEIGHT	WIDTH
28-30	.024 NOM.	.044 REF.	.042 NOM.	.053 REF.
20-24	.024 NOM.	.055 REF.	.060 NOM.	.057 REF.

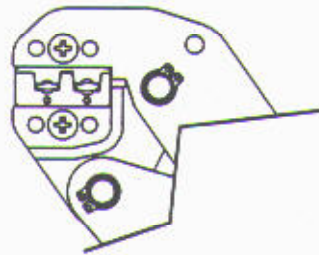
GAGING WITH WIRE SOLDER

LOCATOR/CRIMP TOOL ASSEMBLY

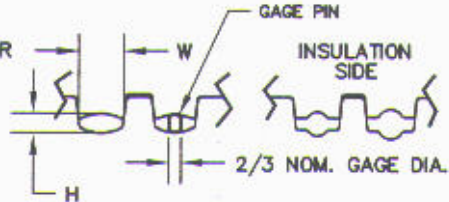




RED 18-22 BLUE 14-16



PART No. FT085

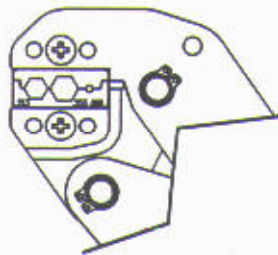


GAGING INFORMATION

NEST	CONDUCTOR		INSULATION	
	H	W	H	W
22-18 RED	.100 NOM.	.220 REF.	.135 NOM.	.240 REF.
16-14 BLUE	.108 NOM.	.240 REF.	.165 NOM.	.280 REF.

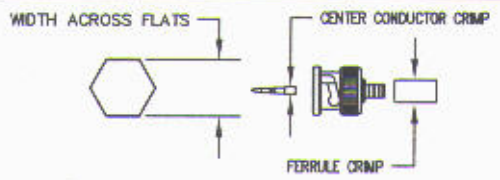
* GAGING USING FLATTED GO/NO GO PINS WITH TOOL CLOSED TO LAST TOOTH OF RATCHET

SELECT THE APPROPRIATE NEST FOR THE TERMINAL BEING CRIMPED.
 POSITION THE TERMINAL WITH INSULATION SIDE TOWARDS THE FRONT OF THE TOOL.
 CLOSE THE TOOL CAREFULLY UNTIL THE JAWS GRIP THE TERMINAL WITHOUT DISTORTION.
 INSERT THE PROPERLY STRIPPED WIRE INTO THE TERMINAL. HOLDING THE WIRE IN PLACE, CLOSE THE TOOL PAST THE RATCHET RELEASE POSITION AND ALLOW THE JAWS TO OPEN.
 REMOVE AND INSPECT THE CRIMP.
 ADJUST RATCHET RELEASE HANDLE FORCE TO 5-15 LBS. FOR SLIDE-ON TERMINALS AS INSTRUCTED IN THE ECCENTRIC ADJUSTMENT SECTION.



PART No. FT086 SHOWN

CAT No.	CAVITY	CABLES ACCOMODATED
	HEX (EXCEPT WHERE NOTED)	
FT086	.068, .213 & .255	RG58/59/62(PVC)
FT087	.068, .178 & .324	RG174/8281
FT088	.042(SQ), .213 & .255	RG58/59
FT089	.042(HEX), .068, .190 & .213	RG58/59 PLENUM
FT090	.042(SQ), .068, .100, .128 & .178	RG174/FIBER OPTIC
FT091	.151, .178 & .213	FIBER OPTIC



Strip cable according to manufacturer's specifications. Select proper hex cavity for size of cable being used. Crimp center conductor in area shown. Assemble connector and crimp outer ferrule.
 THE TOOL IS EQUIPPED WITH A RATCHET MECHANISM TO ASSURE RELIABLE CRIMP TERMINATIONS. A RATCHET RELEASE LEVER IS PROVIDED TO ALLOW FOR REMOVAL OF AN INCORRECTLY PLACED OR OVERSIZE CONNECTOR.
 ADJUST RATCHET RELEASE HANDLE FORCE TO 25-35 LBS. FOR COAXIAL AS INSTRUCTED ABOVE IN THE ECCENTRIC ADJUSTMENT SECTION.
 PROPER HANDLE FORCE IS BEING UTILIZED WHEN CRIMPS ARE GAGED AND FOUND TO BE WITHIN SPECIFIED TOLERANCE.

OPTIONAL CARRYING CASE
 (10 1/4 X 6 X 1 1/4")
 PROTECTS AND STORES TOOL
 FRAME AND DIES

