Spectrum Component Sales, Inc.
105 Hill Street, Suite 2D ● Norcross, GA 30071
PH: 678-990-1754 ● Fax: 678-990-1758
Toll Free: 888-977-3287
Website: www.scsiglobal.com
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RF Coaxial Plug TMP-K01X-A1

Recommended Procedure for Cable Assembly

Applicable Cable:

Wire type	Ohm
1.5D	50
RG-174/U	50
RG-188/U	50
RG-188-A/U	50
RG-316/U	50
1.5C	75
RG-179-A/U	75
RG-179-B/U	75
RG-187/U	75
RG-187-A/U	75

Procedure:

1. Strip away 10mm of the cable jacket.
2. Gather braided shielding to one side and twist into a strand.
3. Strip away the plastic insulation while leaving about 2.5mm of plastic insulation.
4. Insert the cable into the plug while making sure that the center conductor wire goes out the plug tip, the braided shielding fits into the plug side flange and the plastic insulation is seated in the plug.
5. Insert the plug into the crimping tool and crimp at the base and flange areas.
6. Trim away excess shield wire protruding from the plug to within 0.1-1.5mm.
7. Solder center cable conductor wire to plug tip.
8. Trim any protrusion to within 0.5mm or less of the plug tip end to complete assembly.

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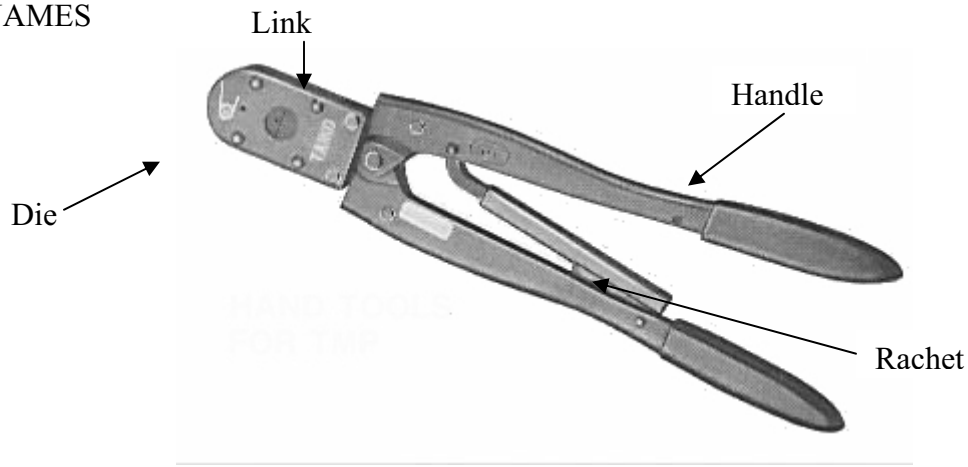
TMP MANUAL CRIMPING TOOL INSTRUCTION SHEET – ADDENDUM

The information provided is the RECOMMENDED PROCEDURE FOR CABLE ASSEMBLY that has proven extremely reliable in insuring a good connection. Since we have had many requests for additional details, the following instructions are from the original Taiko Denki Instruction Sheets and are retyped and made available here strictly as additional reference.

1. This tool has been designed and produced specifically to carry out crimping on Taiko Denki Co., Ltd's TMP-K connector. In order to maintain normal functioning of the tool and to correctly carry out crimping operation, always use the tool as described per this addendum.

2. PARTS NAMES



3. Range of wires and crimp heights:

   Crimp conditions (crimp height measuring method)

   After crimping, place sample between the anvil and the spindle and measure by turning the vernire. However when measuring the core wire side use a micrometer with a cone shaped spindle (spindle tip should have a 30 ~ 40 deg taper) and when measuring the earth side use a micrometer with a flat tipped spindle.

Wire Type		Crimp Height			Corresponding Part Number
		c	d	e	
Small Guage	1.5CCA-EXBV 1.5CCAS-EXBV	0.7 ± 0.05	0.7 ± 0.05	(3.4)	CH-204-2A
	1.7C-2V	0.7 ± 0.05	0.7 ± 0.05	(3.4)	CH-204-2A

Note 1: Cp wire is unsuitable (copper shield, steel signal wire)
Note 2: Before using wires not listed above please inquire with our sales department.

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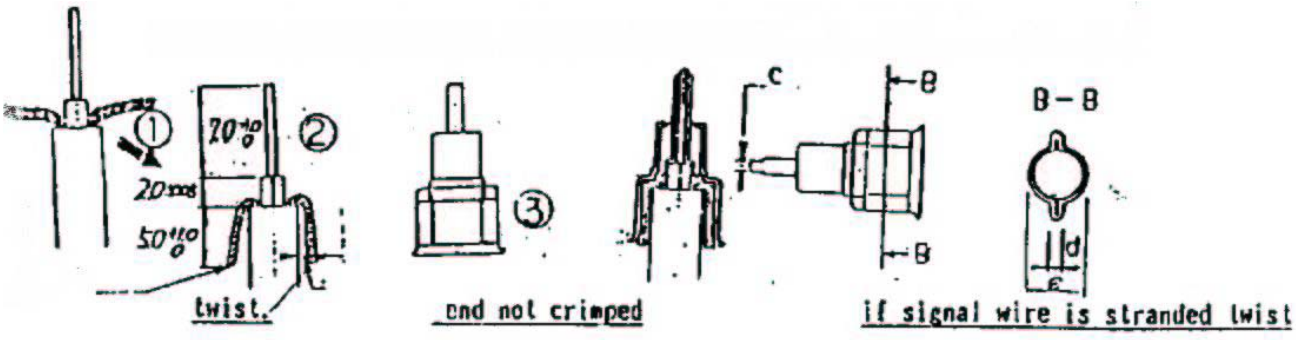


4. Crimping Operation

4.1. Wire Insertion

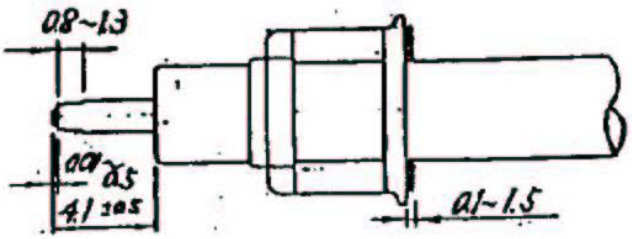
- Take care that the wire is not frayed.
- When inserting wire into plug push firmly home.
- After insertion ensure signal wire protrudes beyond the tip of plug.

4.2. Crimping

- Ensure no deformation of pin during crimping.
- During crimping ensure the plug is pushed well into the locator.

CRIMP DIMENSIONS

Check signal wire is protruding



5. Tool Handling and Maintenance

5.1. It is not advised to use this tool with other connectors or unspecified wire.Wire Insertion

5.2. The tools pressure regulating system (ratchet) is designed of hand power therefore do not use mechanical power devices, forcefully pry open the handles or increase the leverage by connecting pipes to the handles, etc. Using the too incorrectly will damage the crimp pressure regulation system, the link, plates and pins. Furthermore the machine function, efficiency and lifespan will not be maintained.

5.3. Do not drop this tool or use it as a hammer and exercise care no foreign matter is caught between the upper and lower dies.

5.4. After using this tool without fail apply machine oil or some other anti-rust oil to the crimp dies, the links and ratchet.

5.5. This tool is suitable for crimping the TMP-P plug.

5.6. For modifications and repairs please contact our sales department field service.

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TMP MANUAL CRIMPING TOOL INSTRUCTION SHEET

1) This tool has been designed and produced specifically to carry out crimping on Taiko Denki Co Ltd's TMY-k connector. In order to maintain normal functioning of this tool and to correctly carry out crimping operation, please use tool as is described on this sheet.

2) PARTS NAMES

3) Range of suitable wires and crimp heights:

Crimp conditions (crimp height measuring method)

After crimping, place sample between the anvil and the spindle and measure by turning the vernier. However when measuring the core wire side use a micrometer with a cone shaped spindle (spindle tip should have a 30~40 deg taper) and when measuring the earth side use a micrometer with a flat tipped spindle.

Wire Type		Crimp height			corresponding part number
		c	d	e	
small guage	1.5CCA-EXBV 1.5CCAS-EXBV	0.7 ±.05	0.7 ±.05	(3.4)	CH-204-2A
	1.5D-XYS 1.5D-QEV	0.9 ±.05	0.7 ±.05	(3.4)	~~CH-204-1A~~ *
	1.7C-2V	0.7 ±.05	0.7 ±.05	(3.4)	CH-204-2A
large guage	1.5D-XW	0.9 ±.05	0.8 ±.05	(4.1)	~~CH-204-4A~~ *

NOTE: 1: Cp wire is unsuitable (copper sheild, steelsignal wire) *** Crimpers Obsoleted and no longer available ***

2: Before using wires not listed above please inquire with our sales dept

check signal wire is protruding.

5. Tool Handling and Maintenance

5-1.*It is not advised to use this tool with other conectors or unspecified wires.
5-2 *The tool's pressure regulating system (ratchet) is designed for hand power therefore do not use mechanical power devices, forcefully prise open the handles or increase the leverage bi connecting pipes to the handles etc. Using the tool incorrectly will damage the crimp pressure regulation system, the link, plates and pins. Futhermore the machines function, efficiency and lifespan will not be maintained.
5-3 *Do not drop this tool or use it as a hammer and exercise care no foreign matter is caught between the upper and lower dies.
5-4 *After using this tool without fail apply machine oil or some other anti-rust oil to the crimp dies the link and rachet.
5-5 *This tool is suitable for crimping the (TMP-P plug).
5-6 *For modifications and repairs please contact our sales department feild service.

TAIKO DENKI CO. LTD.

Head Office 3-7-3 Yaguchi Ohta-Ku Tokyo 146 Japan.

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16 JUN 1994

WORKING STANDARD

TMP－K

MN－204－E01－0

Taiko Denki

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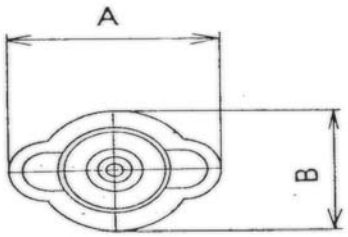
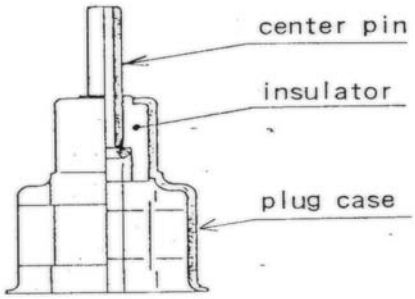
TMP－K WORK I NG STANDARD

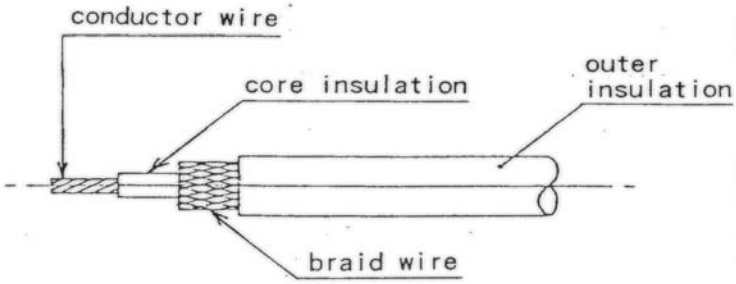
This standard specifies crimping and assembly requirements for TMP-K

1. Parts & Applicable Wire

Parts Name	PLUG NO.	Dimensions(mm)		Just Fit Wire
		A	B	
PLUG	TMP－K 0 1 X－A 1 (Thin)	7. 0 ±0. 2	5. 0 ±0. 2	1. 5CCA-EXBV (SUMITOMO) 1. 5CCAS-EXBV (SUMITOMO) 1. 5CS-SXBV (SUMITOMO) 1. 5D-XVS (SUMITOMO) 1. 5D-QEV (FUJIKURA)
	~~TMP－K 0 1 X－B 1~~ (Thick)	~~7. 5 ±0. 2~~	~~5. 5 ±0. 2~~	~~1. 5D-XW (SUMITOMO)~~ *** TMP-K01X-B1 Obsoleted and no longer available ***







2. Crimping Machine

I t e m s	I t e m s No.
A p p l i c a t o r	C A－2 0 4－2 A
P r e s s M a c h i n e	C M－5 0－1 A

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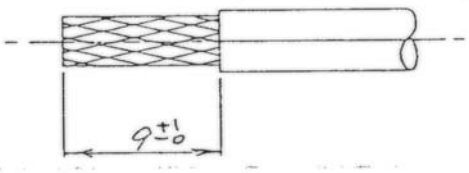
3. Wire Termination

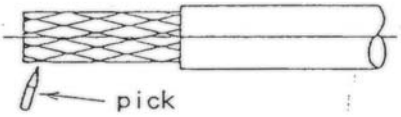
A



Prepare wire terminal as shown. (Fig. A)

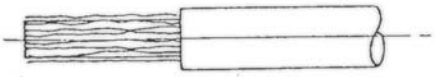
Turn up of braided shield wires.

B

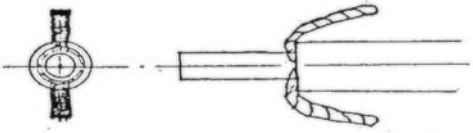


Unbraid shield wire using a pick. (Fig. B, C)

C

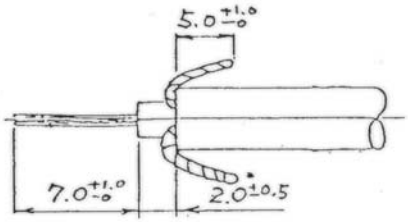


D



Divide unbraided wire to two groups Like as Fig. D.
Twist unbraided wires.

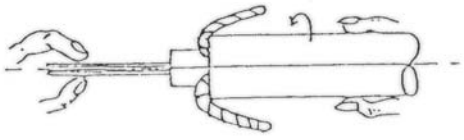
E



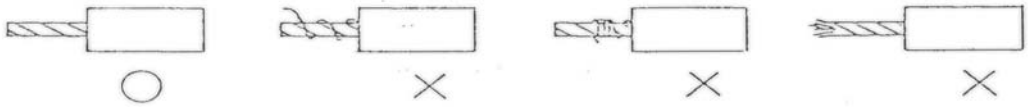
Core insulation strip. (Fig. E)

Twist conductive wires (Fig. F)

F



Acceptable Limits. For twist conductive wires.



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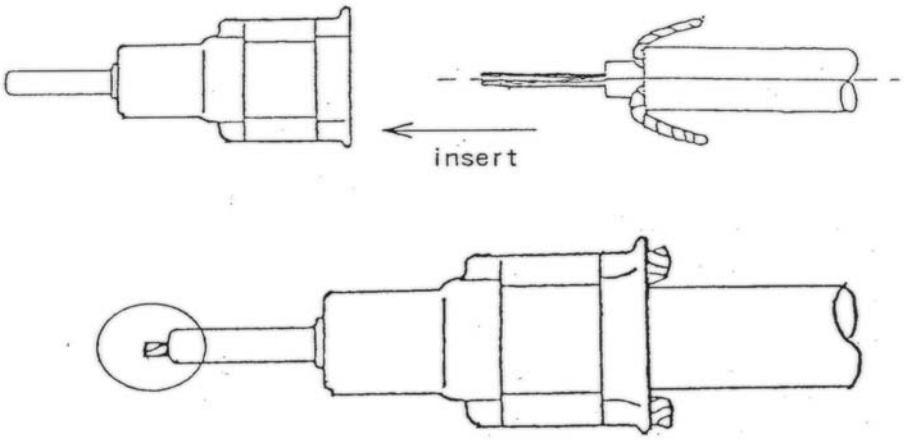
4. Assembly

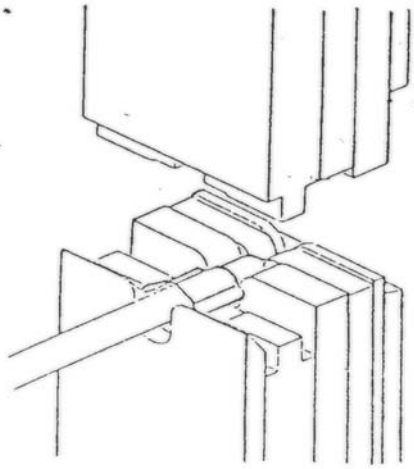
Insert the formed cable into the Plug case.

note: (1) Insert all of conductive wires in to the center pin.
(2) Tip of conductor wires should be through pass out of center pin after insertion. (See socket)



5. Crimping

(1) There should be no deformation on center pin after crimping.
(2) Crimp the plug adding force to it in direction of applicated crimp tool.



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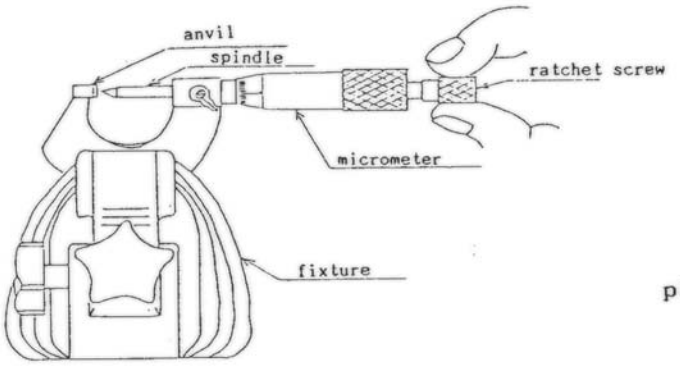
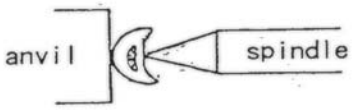
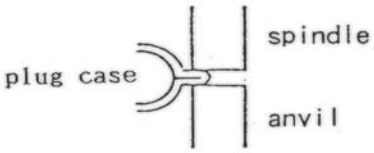
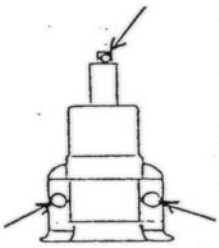
Measuring methode for crimp height

1. Use a micrometer with cone type spindles for crimping hight of center pin.
2. Use a micrometer with flat type spindles for crimping hight of plug case.



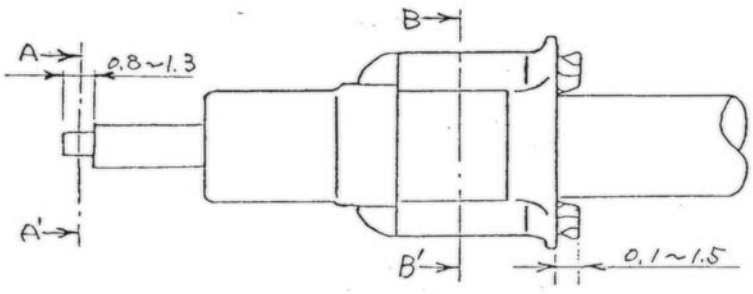


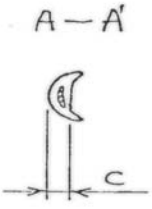


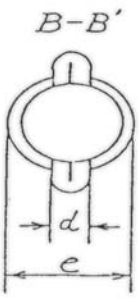

measuring point

Crimp height

Wire		crimp height c	crimp height d	crimp height e	Crimping strength kgf. or more
Thin	1.5CCA-EXBV (SUMITOMO) 1.5CCAS-EXBV (SUMITOMO)	$0.7^{+0.01}_{-0.05}$	0.7±0.05	(3.4)	4.0
	1.5CS-SXBV (SUMITOMO)	$0.75^{+0.01}_{-0.05}$	0.7±0.05	(3.4)	
	1.5D-XVS (SUMITOMO) 1.5D-CEV (FUJIKURA)	$0.9^{+0.01}_{-0.05}$	0.7±0.05	(3.4)	
~~Thick~~	~~1.5D-XW (SUMITOMO)~~	~~$0.9^{+0.01}_{-0.05}$~~	~~0.8±0.05~~	~~(4.1)~~	







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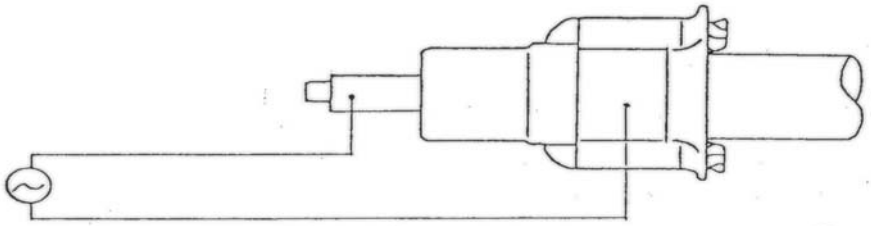
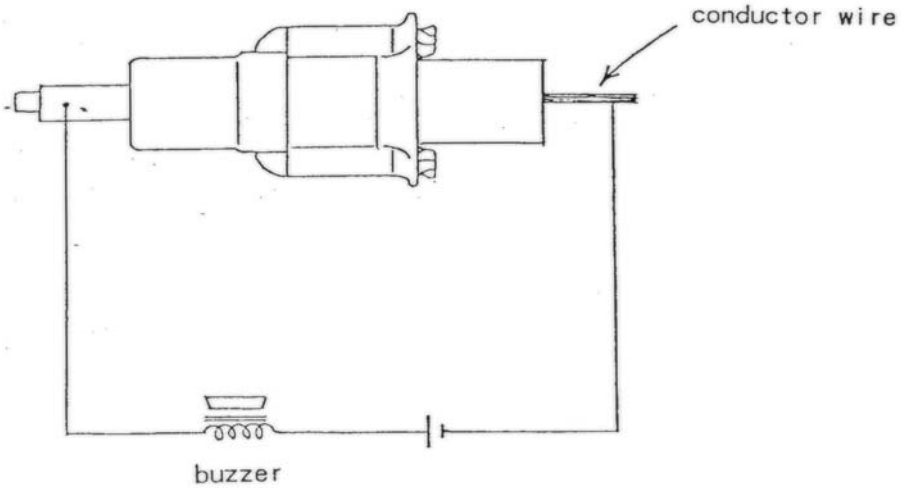
6. Check

(1) Withstanding Voltage

Condition	・４００Ｖ（ＡＣ），６０sec
	・８００Ｖ（ＡＣ），Instant



(2) Electorical check



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