Hand Tools

AMP CERTI-CRIMP Hand Tools are our top-of-the-line crimping tools featuring the original ratcheted crimp control. All tools are designed to exacting specifications, and manufactured using high quality materials to provide long service life. Recommended for low production runs, repairs and prototype work, and applications requiring consistent, highly-reliable terminations.
See Catalog 65780 for further information.

Typical CERTI-CRIMP Hand Tools with Integral (Non-Interchangeable) Dies

Part Number 58537-1 (used with PRO-CRIMPER Tool Frame 354940-1)
for 50 Ohm BNC Dual Crimp MIL Type Connectors

Part Number 220015-1
for 50 Ohm N Connectors

CERTI-CRIMP Hand Tool with Interchangeable Dies

Part Number 69710

Hand Tool Kit for SMA and Blindmate Connectors

Part Number 59981-1

Item Description	Part Numbers	
	AMP	Military (M22520/)
Hand Tool	59980-1	36-01
Plug Locator (without Center Contact)	220220-2	36-06
Plug Locator (with Center Contact)	220221-2	36-04
Jack Locator	220222-2	36-05
Die Set for RG-402/U Cable (.141 [3.58] O.D.)	312253-1	36-03
Die Set for RG-405/U Cable (.086 [2.18] O.D.)	312253-2	36-02
Cutoff Fixture	311395-1	36-09
Cable Dressing Fixture	311396-1	36-07
Trimmer Tool	312317-1	36-08
Cable Bend Fixture Assembly Includes following 6 items:	220224-1	36-10
Bend Segment, RG-402/U (.125 [3.18] Radius)	311386-1	36-11
Bend Segment, RG-402/U (.250 [6.35] Radius)	311386-2	36-12
Bend Segment, RG-405/U	311386-3	36-13
Tool Holder	311392-1	—
Limiting Pin	307581-1	—
Conforming Block	312067-1	—
Hex Wrench	21027-6	—
Carrying Case	13126-1	—
Insert, Case	13127-1	—

Catalog 1308940
Revised 5-03

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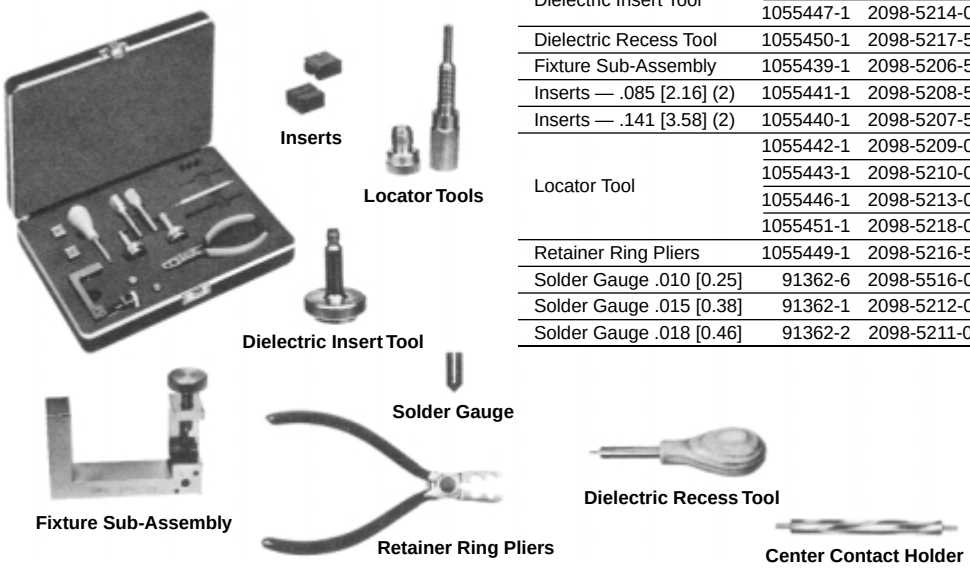
Application Tooling (Continued)

Solder Assembly Kit Brass SMA Connectors

AMP Kit Part Number 1055420-1
M/A-COM Kit Part Number 2098-5066-54
For installation of SMA connectors to .035 [0.89] and .141 [3.58] diameter semi-rigid cable



Item Description	AMP Part No.	M/A-COM Part No. (Ref. Only)
Center Contact Holder	1055454-1	2098-5221-10
Dielectric Insert Tool	1055448-1	2098-5215-02
	1055447-1	2098-5214-02
Dielectric Recess Tool	1055450-1	2098-5217-54
Fixture Sub-Assembly	1055439-1	2098-5206-54
Inserts — .085 [2.16] (2)	1055441-1	2098-5208-54
Inserts — .141 [3.58] (2)	1055440-1	2098-5207-54
Locator Tool	1055442-1	2098-5209-02
	1055443-1	2098-5210-02
	1055446-1	2098-5213-02
	1055451-1	2098-5218-02
Retainer Ring Pliers	1055449-1	2098-5216-54
Solder Gauge .010 [0.25]	91362-6	2098-5516-02
Solder Gauge .015 [0.38]	91362-1	2098-5212-02
Solder Gauge .018 [0.46]	91362-2	2098-5211-02

Universal Compression Crimp Tool

AMP Kit Part Number 1055835-1
M/A-COM Kit Part Number 2598-5200-54

AMP Universal Compression Crimp Tool offers the ability to rapidly produce cable assemblies using solderless compression crimp connectors with semi-rigid cables. This universal assembly tool kit will attach SMA, OSP, N and TNC series connectors to .141 [3.58], .085 [2.16] and .250 [6.35] cable quickly and consistently with excellent mechanical and electrical results.

The tool kit permits single hand assembly. Anvils and cable supports can be quickly changed. Crimp lengths can be adjusted from .001 [.025] to 1.000 [25.4] in increments of .001 [.025]. Sharp radius bends in cables are easily accommodated. The kit contains:

Description	AMP Part No.	M/A-COM Part No. (Ref. Only)
Crimp Frame	1055831-1	2598-5196-54
Calibration Gauge	1055832-1	2598-5197-54
.141 [3.58] Cable Support	1055833-1	2598-5198-54
.085 [2.16] Cable Support	1055834-1	2598-5199-54
SMA Plug Anvil	1055836-1	2598-5201-54
SMA Jack Anvil	1055837-1	2598-5202-54
Type N Plug Anvil	1055838-1	2598-5203-54
Type N Jack Anvil	1055839-1	2598-5204-54
TNC Plug Anvil	1055840-1	2598-5205-54
TNC Jack Anvil	1055841-1	2598-5206-54
OSP Plug Anvil	1055842-1	2598-5207-54
OSP Jack Anvil	1055843-1	2598-5208-54

All tools may be purchased separately.

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Application Tooling (Continued)

MIL-C-22520/10-01 Equivalent Hex Crimp Kit

AMP Kit Part Number 1055236-1

M/A-COM Kit Part Number 2098-0105-54

For military specified applications requiring quick and efficient cable to connector attachment. Five popular hex die sizes are available to crimp the outer cable conductor to connector housings.

The kit contains:

Description	AMP Part Number	M/A-COM Part Number (Ref. Only)
Crimp Tool	1060713-1	9098-5105-54
Die Change Tool	1060716-1	5698-5014-54
Hex Die — A, B, C	1060714-1	5698-5015-54
Hex Die — D, E	1060715-1	5698-5016-54

All tools may be purchased separately.
For the assembly of SMA connectors,
Accessory Kit Part Number 1055421-1 is required.

A basic instruction sheet, included with the kit, aids in proper die selection

AMP Hex Die Part Number	M/A-COM Hex Die Part Number (Ref. Only)	Die	Hex Size ±.003 [0.08]	For Use With RG/U Cable
1060714-1	5698-5015-54	A	**.105** 2.67	178B & 196A
		B	**.213** 5.41	55B, 58C, 141A, 142B, 223, 303, & 400
		C	**.128** 3.25	174, 174B, 179, 187A, 188A, & 316
1060715-1	5698-5016-54	D	**.178** 4.52	180B, 195A, & 122
		E	**.255** 6.48	59, 62A, 71B, 210, & 302

Additional Dies Available

AMP Hex Die Part Number	M/A-COM Hex Die Part Number (Ref. Only)	Hex Size ±.003 [0.08]	For Use With RG/U Cable
1055270-1	2098-0323-54	**.151** 3.84	RD316 Double Braid

SMA Crimp Tool Accessory Kit

AMP Kit Part Number 1055421-1

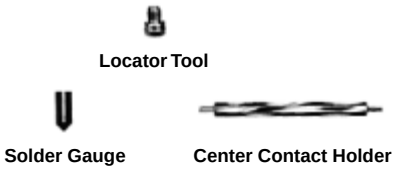
M/A-COM Kit Part Number 2098-5067-54

For installation of SMA connectors to flexible braided cable. Crimp type SMA connectors require Hex Crimp Kit Part Number 1055236-1.

The kit contains:

Description	AMP Part Number	M/A-COM Part Number (Ref. Only)
Center Contact Holder	1055454-1	2098-5221-10
Locator Tool	1055446-1	2098-5213-02
Locator Tool	1055451-1	2098-5218-02
Solder Gauge .015 [0.38]	91362-1	2098-5212-02

All tools may be purchased separately.



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Application Tooling (Continued)

Stripping Tools

The hand-operated AMP Coaxial Cable Stripper features interchangeable, color-coded blade cassettes and V-blocks to accommodate 2- or 3-step stripping for cable diameters ranging from 2.54 [.10] through 7.62 [.30]. You strip cable by simply clamping and rotating the tool around the cable. See Instruction Sheet IS 2766 for further information.

For Use With Connector Type	Tool No.
BNC Single Crimp	603995-1
BNC Commercial and UHF Miniature	603995-2
UHF Standard	603995-3
BNC MIL Type Dual Crimp	603995-5
BNC Commercial Dual Crimp	603995-6

Semi-Rigid Cable Tooling

The tools listed here are designed specifically to strip and terminate semi-rigid cable. These tools operate basically the same as the flexible cable tools, in that they produce uniform terminations time after time, without heat damage from soldering.

Hand Tool for BNC and TNC Semi-Rigid Cable Connectors

Part Number 59980-1
Frame only — does not include dies and locator

Manual Trim and Point Tool

Tyco Electronics offers a manual tool that performs both trimming and pointing operations. Tools are available for .141 [3.58] and .085 [2.16] diameter semi-rigid cable. These hand-operated tools are ideally suited for engineering, small production runs or field use. They feature tungsten carbide cutters for durability up to 30 times longer than the life of a high speed steel cutter. Replacement cutters are interchangeable and may be purchased separately.

AMP Tool Part Number	M/A-COM Tool Part Number (Ref. Only)	Cable	Trim Length
1055811-1	2598-5116-54	RG-402/U (.141 [3.58])	**.085** 2.16 Fixed
1055815-1	2598-5120-54	RG-405/U (.085 [2.16])	**.070** 1.78 Fixed
1055823-1	2598-5137-54	RG-402/U (.141 [3.58])	Adjustable*
1055824-1	2598-5138-54	RG-405/U (.085 [2.16])	Adjustable*

*Adjustable trim length from .050 [1.27] to .140 [3.56].

Replacement Cutters

Trimmer: Part Number 1055813-1
Pointer: Part Number 1055814-1

Replacement Collets

AMP Part Number	M/A-COM Part Number (Ref. Only)	Cable
1055825-1	2598-5145-54	RG-402/U (.141 [3.58])
1055827-1	2598-5167-54	RG-405/U (.085 [2.16])

Cable Benders for Semi-Rigid Cable

Cable Bender

Description	AMP Part Number	M/A-COM Part Number (Ref. Only)	Bend Radius*
Cable Bender for RG-405/U (.085 [2.16])	1055479-1	2098-5287-54	1/4 [6.4] 3/8 [9.8]
Cable Bender for RG-402/U (.141 [3.58])	1055478-1	2098-5286-54	3/8 [9.8] 1/2 [12.7]

*Radius of the bend is measured from the centerline of the cable.

Trimming Tools for Semi-Rigid Cable

For soldered semi-rigid cable connectors using the cable center conductor as its contact. These tools are optional for most installations but recommended for optimum connector performance.

Trim Tool

Description	AMP Part Number	M/A-COM Part Number (Ref. Only)
Trim Tool for SMA Connectors RG-402/U (.141 [3.58])	1055455-1	2098-5272-02
Trim Tool for SSMA Connectors RG-405/U (.085 [2.16])	1055465-1	2098-5269-02

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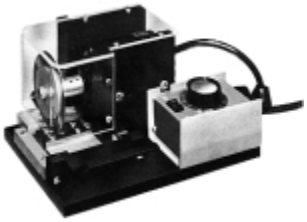
Application Tooling (Continued)

Cable Trimmers for Production

Tyco Electronics cable trimmers are designed for production trimming of RG-402/U (.141 [3.58]) and RG-405/U (.085 [2.16]) coaxial cables in preparation for connector installation. The trimming operation produces an unusually clean, burr-free cut with minimum smear. The length and depth of cut are adjustable. Replacement hardware can be used with either tool.



Cable Trimmers

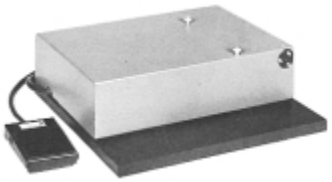
Description	AMP Part Number	M/A-COM Part Number (Ref. Only)
RG-402/U (.141 [3.58])	1055526-1	2098-5676-54
RG-405/U (.085 [2.16])	1055530-1	2098-5686-54

Replacement Hardware

Description	AMP Part Number	M/A-COM Part Number (Ref. Only)
Saw Blade	1055524-1	2098-5674-54
Trim Saw Block (.141 [3.58])	1055527-1	2098-5678-54
Trim Saw Block (.085 [2.16])	1055528-1	2098-5679-54

Cable Pointers for Production

Tyco Electronics cable pointers are designed to point straight and bent cables and are adjustable for desired center conductor length. The cable pointers cut 90° point on copper as well as copper-clad center conductors.



Cable Pointers

Description	AMP Part Number	M/A-COM Part Number (Ref. Only)	Cable	AMP Replacement Cutter Part Number	M/A-COM Replacement Cutter Part Number (Ref. Only)
Single Pointer	1055525-1	2098-5675-54	RG-402/U (.141 [3.58])	1055529-1	2098-5681-54
Single Pointer	1080269-1	2098-5685-54	RG-405/U (.085 [2.16])		

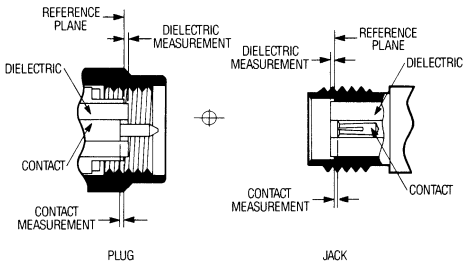
Interface Inspection Gauges

Tyco Electronics offers Connector Interface Gauges. They have shock proof and fully jeweled dial indicators. The rugged construction of the dial mechanism minimizes the need for repair or replacement.

The gauge heads are manufactured from a corrosion resistant, hardening stainless steel which is heat treated for longer life. All critical surfaces are ground and lapped for precision fit and superior surface finish. The heads are securely fastened onto the dial indicator for no movement between the gauge head and the dial indicator spindle allowing for precise measurements.

Like the gauge heads, the plungers are specially designed to provide strength and durability.

Connector	Type	AMP Gauge Kit Part Number	M/A-COM Gauge Kit Part Number (Ref. Only)
SMA	Jack	1055496-1	2098-5455-54
	Plug	1055497-1	2098-5456-54



SMA Interface Example

Catalog 1308940
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Application Tooling (Continued)

SSMA Connectors

AMP Kit Part Number 1055466-1
M/A-COM Kit Part Number 2098-5270-54

For installation of SSMA connectors to .070 [1.78] and .085 [2.16] diameter semi-rigid cable.

Item Description	AMP Part No.	M/A-COM Part No. (Ref. Only)
Center Contact Holder	1055463-1	2098-5237-10
Dielectric Insert Tool	1055458-1	2098-5233-02
	1055459-1	2098-5234-02
Dielectric Recess Tool	1055460-1	2098-5235-54
Fixture Sub-Assembly	1055439-1	2098-5206-54
Inserts — .070 [1.78] (2)	1055547-1	2098-5831-54
Inserts — .085 [2.16] (2)	1055441-1	2098-5208-54
Locator Tool	1055461-1	2098-5236-02
	1055464-1	2098-5238-02
	1055456-1	2098-5231-02
	1055457-1	2098-5232-02
Retainer Ring Pliers	1055449-1	2098-5216-54
Solder Gauge .015 [0.38]	91362-1	2098-5212-02

All tools may be purchased separately.

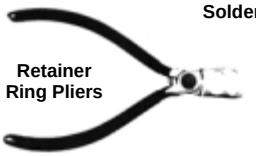
Inserts

Dielectric Insert Tool

Locator Tools

Solder Gauge

Fixture Sub-Assembly



Retainer Ring Pliers

Dielectric Recess Tool

Center Contact Holder

Econo-Crimp Assembly Kit

AMP Kit Part Number 1055779-1
M/A-COM Kit Part Number 2598-5005-54

For quick and efficient cable to connector attachment. Five popular hex die sizes are available to crimp the outer cable conductor to connector housings.

Item Description	AMP Part No.	M/A-COM Part No. (Ref. Only)
Crimp Tool	1055780-1	2598-5006-54
Hex Die — A, B, C	1055781-1	2598-5007-54
Hex Die — D, E	1055782-1	2598-5008-54

All tools may be purchased separately.
For the assembly of SMA connectors, Accessory Kit Part Number 2098-5067-54 is required. For SSMA connectors, Accessory Kit Part Number 2098-5272-54 is required.

Crimp Tool

Hex Die

AMP Hex Die Part Number	M/A-COM Hex Die Part Number (Ref. Only)	Die	Hex Size ±.003 [0.08]	For Use With RG/U Cable
1055781-1	2598-5007-54	A	**.105** 2.67	178B & 196A
		B	**.213** 5.41	55B, 58C, 141A, 142B, 223, 303, & 400
		C	**.128** 3.25	174, 174B, 179, 187A, 188A, & 316
1055782-1	2598-5008-54	D	**.178** 4.52	180B, 195A, & 122
		E	**.255** 6.48	59, 62A, 71B, 210, & 302

SSMA Crimp Tool Accessories

AMP Kit Part Number 1055467-1

M/A-COM Kit Model Number T-550

For installation of SSMA connectors to flexible braided cable. Crimp type SSMA connectors require Hex Crimp Kit Part Number 1055779-1.

Locator Tool

Center Contact Holder

Description	AMP Part Number	M/A-COM Part Number (Ref. Only)
Center Contact Holder	1055463-1	2098-5237-10
Locator Tool	1055461-1	2098-5236-02
	1055464-1	2098-5238-02

All tools may be purchased separately.

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