

**Crimping Tool for 1mm Polymer Optical Fiber (POF)  
 with continuously adjustable Crimp Depth**

**1 General**

This four-indent crimping tool for polymer optical fiber connectors and contacts is a manually operated tool. The crimping tool should only be used in a perfect condition and solely for turned fiber optic contacts. Any damage caused by not intended modification or usage of the tool exclude the manufacturers liability.



Pic. 1 Crimping tool with continuously adjustable crimp depth

**2 Ordering information**

Specification	Part number
Crimping tool	910CZ00100004

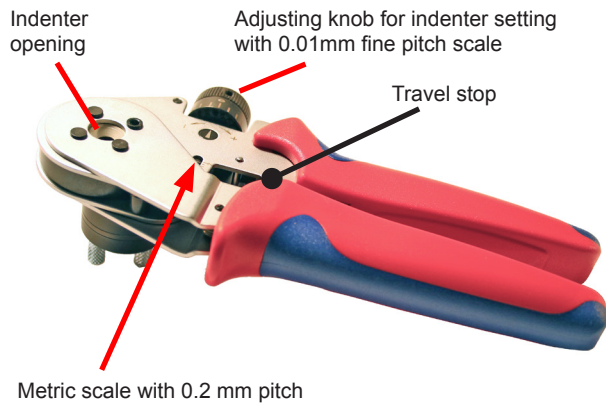
**3 Connector table**

Style	Part No.	Locator position	Crimp depth
F-SMA connector based on IEC 61754-22	902SS001SM001 902SS001SM002 902SS001SM003 902SS001SM006 902SS001SM011 902SS001SM012 902SS001SM014 902SS001SM017 902SS001SM021 902SS001SM022	3	2.0 mm
F-ST connector acc. IEC 61754-2	902SS001ST001	3	2.0 mm
POF ferrule	902SS001FE001	3	1.8 mm
FO-female contact CECC 78 001-801	902DI001BU001	3	2.0 mm
FO-male contact CECC 78 001-801	902DI001ST001	3	2.0 mm
FO-female contact for rectangular connectors series HD	902SSR15BU005	2	1.45 mm
FO-male contact for rectangular connectors series HD	902SSR15ST009	1	1.45 mm

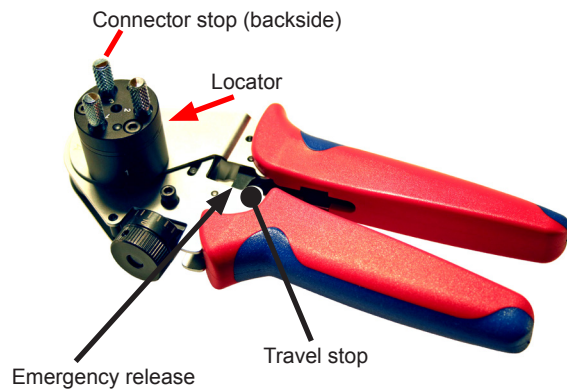
Pic. 2 Connector table

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#### 4 Mode of operation \_\_\_\_\_



Pic. 3 Crimping tool front side



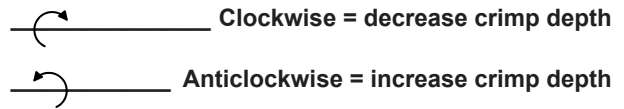
Pic. 4 Crimping tool back side

- Refer to connector table (Pic. 2) for crimp depth and locator position.
- Adjust crimp depth (indenter setting) with the adjusting knob.
- Lift the locator to position it according to table (Pic. 2). **Attn.: The indenters und connector stops must be unclosed and unlocked.**
- Push connector stop into the locator and lock it with a 90° turn.
- Insert fiber optic connector into indenter opening until connector stop and close tool carefully to the first snap-in point.
- Insert the prepared optical cable into the connector hold by the tool until travel stop. Simultaneously push connector and cable against travel stop and close handles until the tool releases.
- Remove the crimped connector from tool.
- Before a new locator position is made, always make sure that the connector stop is unlocked and in free position.

#### 5 Crimp depth adjustment \_\_\_\_\_

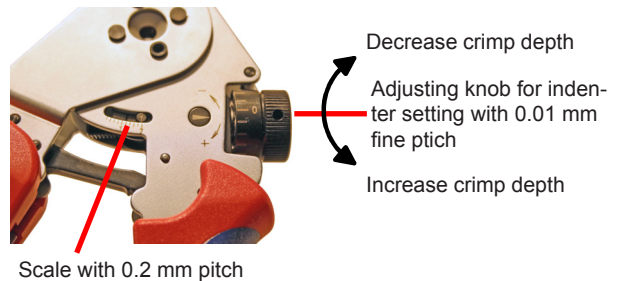
Crimp depth adjust (indenter setting) is carried out by the adjusting knob using the following instructions:

**Adjusting knob travel:**



Adjustment accuracy:

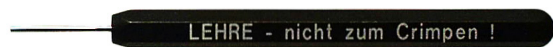
- 1x pitch line = 0.01 mm travel
- 1x 360° turn = 0.2 mm travel indicated on adjusting knob
- 5x 360° turns = 1 mm travel indicated on scale



Pic. 5 Crimping tool adjusting knob

#### 6 Adjustment control \_\_\_\_\_

The crimping tool comes factory preadjusted. However, it is recommended to control crimp depth accuracy from time to time. This could be done using the  $\varnothing 1.0$  mm gauge pin shipped with the tool following the instructions below:



Pic. 6 Gauge

Set tool to 1.0 mm (indicated on scale opening) crimp depth with the adjusting knob. Set the knob to zero (indicated on knob) and close the handles (see Pic. 5). At this setting the  $\varnothing 1.0$  mm gauge pin should slide easily between the indenters nearly without clearance.

If this test fails, the adjustment error can be controlled with the fine pitch scale of the adjustment knob (useable like a micrometer screw). The tool has to be readjusted by factory if the deadjustment is greater than the  $\pm 0.06$  mm tool accuracy.



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**7 Technical data**\_\_\_\_\_

Parameter	Condition	Value	Unit
Suitable Connectors	see Connector Table Point 3		
Suitable Contact-Ø	turned Male and Female Pins	≤ 5.0	mm
Profile	4-Ident-Crimping		
Weight		0.390	kg
Dimensions	Length	175	mm
Material	2-K Handles Plier	Plastic Stainless Steel, chrome-plated	

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