TROMPETER *An ISO9001 Company*

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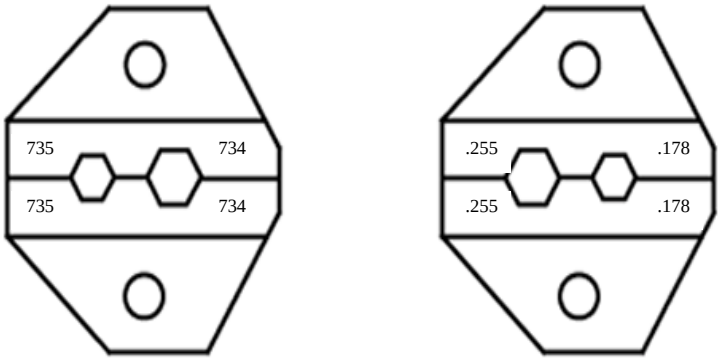
TECHNICAL NOTE
#22

There have been a significant number of inquiries regarding Trompeter's "Flip Flop" dies. Many of the questions are just a lack of understanding as to what can be gained from the use of the die, as well as what dies are available, and what dies they replace.

The "Flip Flop" dies are an **improvement** to our 734/735 series of dies; CD3-11, CD3-15 and CD3-17. The term "Flip Flop" is somewhat of a misnomer. The actual difference is that the smaller 735 hex cavity was moved closer to the fulcrum of the tool, and the larger 734 hex cavity was moved away from the fulcrum, or swapped. If you compared a CD3-11 die and a "Flip Flop" CD3-19, you can easily see difference (figure 1). The advantage is that it increases the amount of closure force applied to the smaller 735 hex cavity, increasing the retention performance, without increasing the tension of the tool. Depending on what cable is used, the proficiency of the assembler, the tension of the tool, etc., the difference can be substantial. If an installer has a tool that has a less than desirable crimp force, this may be the difference between the connector passing a retention test, rather than failing one .

The "Flip Flop" dies come in a couple of different styles and part numbers. The CD3-19 embosses the hex dimensions .178 and .255. You also have the CD3-19 special – 010-0129-XX – that embosses 734 and 735, as well as the company's initials. There is also the CD3-17 special -- 010-0118-XX that embosses the hex dimensions .178 and .255, as well as the company's initials, and the CD3-18 special – 010-0118-XX – that embosses the hex dimensions .178 and .324, as well as the company's initials.



CD3-11 CD3-19

Figure 1

If any customer desires to order, or replace their CD3-11, CD3-15 and CD3-17, please inform them of one of our "Flip Flop" dies. Remember, this is a product improvement, and in no way mean that the old dies are defective, or ineffective. If you need any further amplification, or your customer asks a question which is not addressed, contact Bill Berger in Technical Support at (818) 865-6534, or e-mail at bill.berger@trompeter.com. We look forward to your questions.