



Crimping Tool

SML-200R

Crimping · Cutting



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This manual covers SML-200R part identification, safe preparation, crimping, cutting, holding and release, and care. Read it fully before first use. Keep clear of the blades, dies and handle pinch points during operation. Retain this manual for reference.

Chapter 1 Product and part identification

SML-200R is used to crimp modular plugs for network and telephone cables, and to cut compatible communication cable to length or trim its ends. Check that the cable, plug and die match before use. Do not force a plug into a die merely because its shape looks similar.

The tool has a force-saving holding mechanism. If cutting or crimping is unfinished, it holds the position reached when you pause squeezing. The side release control disengages the hold so the tool can spring open partway through an operation. See Chapter 5 for the release procedure.

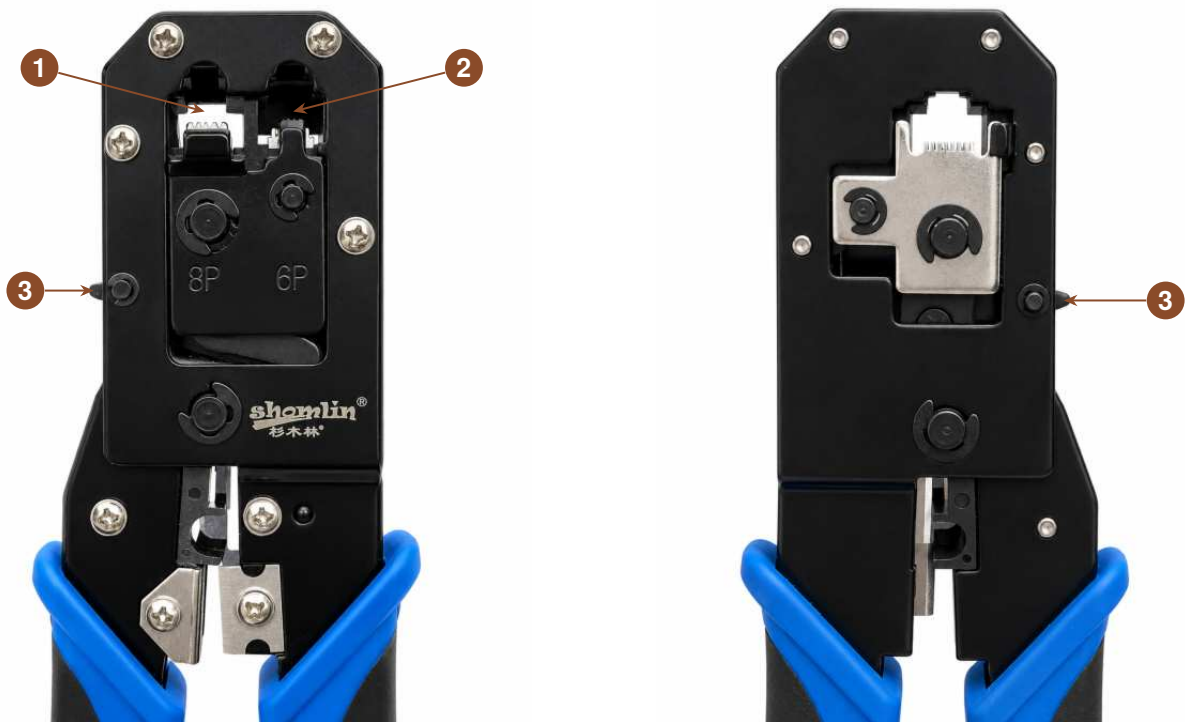


Figure 1-1 Jaw front (left) and back (right). 1: 8P die; 2: 6P die; 3: release control.

Part	Identification and use
1 / 8P die	Marked 8P on the tool; accepts a plug matched to the cable and this die for crimping.
2 / 6P die	Marked 6P; select the corresponding die and check that the plug matches.
3 / Release control	The projection on the side of the head; disengages the hold so the tool can open mid-operation.
Handles	The blue and black grips; squeeze to apply pressure, keeping fingers clear of pinch points.

Chapter 2 Safety and preparation

DANGER Disconnect the cable from all equipment and power sources before work. Verify that an unknown circuit is de-energized; do not judge by appearance.

2.1 Work safely

- Work in a stable, dry and well-lit area. Keep the tool and workpiece from slipping.
- Keep fingers clear of blades, dies, handle pinch points and the opening path during release. Never touch a cutting edge to test its sharpness.
- Do not adjust a plug or cable while the handles are closed and the workpiece is still gripped. Use the release control when you need to open the tool.
- Do not use the tool on steel wire, steel cable, nails or other hard materials. Do not force an incompatible plug into a die.

2.2 Check the tool and materials

1. Check the blades, dies, joints and fasteners for chips, deformation, looseness or damage. Stop using the tool if any are found.
2. Remove jacket scraps, copper fragments and other debris from the dies and around the blades. If a workpiece is still gripped, release and remove it as described in Chapter 5. If release fails, stop cleaning.
3. Select a matching cable and plug. Confirm the wiring requirements, conductor order and jacket retention arrangement. If the plug cannot sit squarely in the die, find the cause first.

2.3 Prepare the cable end

The following are general jacket-preparation guidelines for a suitable stripping tool. Choose the strip length to suit conductor insertion and plug retention, leaving enough outer jacket for the plug to grip. Control the force to avoid cutting into the inner conductors. Try a short scrap of the same cable first to inspect the jacket and conductor condition. Do not keep increasing pressure to handle an incompatible cable.

After removing the jacket, check the inner insulation and conductors. If they are scratched, flattened or have unintended exposed copper, cut off the damaged section and prepare the end again before arranging the conductors. If damage recurs, stop using that method and check the force applied and the match between the tool and cable.

NOTE Use a stripping tool suitable for the cable when removing the outer jacket.

Chapter 3 Crimping

Complete the disconnection and tool checks in Chapter 2 before crimping. Select the corresponding die using the 8P and 6P markings.

3.1 Load the plug and position it

1. Arrange the conductors in the required order, straighten them and trim the ends evenly. Avoid crossed or misplaced conductors.
2. Insert the conductors into the modular plug. Check that each reaches its intended position and that the outer jacket enters the plug's retention area. Avoid securing only individual conductors.
3. For a transparent plug, check the conductor order, insertion depth and position through the housing. Once these are correct, place the plug squarely into the corresponding die.
4. Check that the plug faces the correct way and is fully seated, without tilting or being left partially inserted. Do not force a plug that will not fit.

3.2 Apply pressure and remove the plug

1. Hold the tool and plug steady. Keep fingers clear of the die and pinch points, then squeeze the handles to apply pressure to the plug.
2. While crimping is unfinished, the tool holds the position reached if you pause squeezing. Use the side release control to open it mid-operation. Do not pull the plug free or force the handles apart.
3. Remove the plug only after the tool has opened and no longer grips it. Release only disengages the hold; an unfinished plug removed mid-operation is not an acceptable finished termination.

3.3 Inspect the crimp

Check the contacts, conductor order and seating, and outer jacket retention. If conductors are not fully inserted, the plug is misaligned or retention is abnormal, check plug compatibility, orientation and debris in the die. Replace the plug and terminate again if needed. Do not try to correct a mistake by repeatedly applying excessive pressure.

Visual inspection shows only the visible assembly condition; it does not prove electrical quality. Use separately provided test equipment matched to the cable for continuity and wire-order checks. This is a separate follow-up procedure.

Chapter 4 Cutting

Use cutting to bring compatible communication cable to length or trim its ends. First verify disconnection, check the blades for chips, deformation or looseness, and remove nearby debris. If you cannot identify the cutting blades, do not insert a cable and apply pressure.

4.1 Position and cut the cable

1. Choose the required cut position. Place the cable between the cutting blades, keeping it as nearly perpendicular to the blades as possible.
2. Keep fingers clear of the blades and handle pinch points. Hold the cable and tool steady, then squeeze the handles to bring the blades together through the cable.
3. While cutting is unfinished, the tool holds the position reached if you pause. Use the side release control if you need to open it. Wait until the tool is open and the cable is no longer gripped before removing or adjusting it.

4.2 Inspect the cut

Check that the cable is fully severed and that the end is even, without obvious slanting or splaying. An incomplete cut is not a finished result. If you release and remove a partly cut workpiece, inspect it for damage first.

For a poor cut, check the cable angle, debris and blade condition. Trim and inspect the end before proceeding with termination. Stop using the tool if a blade is damaged or loose, or if resistance is abnormal. Do not keep increasing force or repeatedly force the cut.

WARNING Do not cut steel wire, steel cable, nails or other hard materials. Do not test the cutting edge with your fingers or adjust the cable while the blades are closed.

Chapter 5 Holding, release and care

5.1 Normal holding and mid-operation release

When cutting or crimping is unfinished, the force-saving holding mechanism retains the position reached. The tool does not spring open when you pause squeezing. This is normal holding and should not be treated as a jam by itself.

To open the tool partway through an operation:

1. Stop applying pressure and steady the tool and workpiece. Keep fingers clear of the blades, dies, pinch points and opening path.
2. Operate the side release control to disengage the hold and let the tool spring open. The release control is marked 3 in Figure 1-1.
3. Wait until the tool is open and no longer grips the workpiece before removing or adjusting the plug or cable. Check whether the operation is complete and inspect the workpiece before deciding what to do next.

CAUTION Release does not mean cutting or crimping is complete, or that the workpiece meets quality requirements. Being able to remove it is not a substitute for inspection.

5.2 Respond to problems

Condition	Action
Tool holds position when squeezing pauses during unfinished cutting or crimping	Normal holding; use the release control when opening is needed.
Release fails; workpiece remains gripped	Stop using and cleaning the tool. Do not pull the workpiece free, force the handles apart or apply more pressure.
Abnormal resistance or damaged parts	Stop using the tool and check visible issues. Have damage, looseness or deformation attended to by repair personnel.
Poor crimp or cut	Follow Chapter 3 or 4, as applicable. Do not use repeated excessive pressure to compensate for an error.

5.3 Clean and store

Remove cables and plugs before cleaning. If a workpiece remains gripped, use the release control to open the tool before removing it. If release fails, stop cleaning; do not force the workpiece free.

Use a dry soft brush or lint-free cloth to remove jacket scraps, copper fragments and dust from the blades, grooves and dies. Avoid direct contact with cutting edges and do not use corrosive liquids. Check the blades, dies, joints and fasteners. Stop using the tool if they are chipped, deformed, loose or damaged. Keep the tool dry and protect it from corrosion, drops and heavy loads during storage.