

SCTE | **STANDARDS**

Interface Practices Subcommittee

AMERICAN NATIONAL STANDARD

ANSI/SCTE 14 2016 (R2022)

**Test Method for
Hex Crimp Tool Verification/Calibration**

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Document Types and Tags

Document Type: Specification

Document Tags:

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| <input checked="" type="checkbox"/> Test or Measurement | <input type="checkbox"/> Checklist | <input type="checkbox"/> Facility |
| <input type="checkbox"/> Architecture or Framework | <input type="checkbox"/> Metric | <input checked="" type="checkbox"/> Access Network |
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Document Release History

Release	Date
SCTE 14 2001	<i>5/31/2001</i>
SCTE 14 2007	<i>12/15/2006</i>
SCTE 14 2011	<i>7/25/2011</i>
SCTE 14 2016	<i>12/19/2016</i>
SCTE 14 2016 (R2022)	<i>Feburary 2022</i>

Note: This document is a reaffirmation of SCTE 14 2016. No substantive changes have been made to this document. Information components may have been updated such as the title page, NOTICE text, headers, and footers.

Table of Contents

Title	Page Number
NOTICE	2
Document Types and Tags	3
Document Release History	3
Table of Contents	4
1. Introduction	5
1.1. Executive Summary	5
1.2. Scope	5
1.3. Benefits	5
1.4. Intended Audience	5
2. Normative References	5
2.1. SCTE References	5
2.2. Standards from Other Organizations	5
2.3. Published Materials	5
3. Informative References	5
3.1. SCTE References	6
3.2. Standards from Other Organizations	6
3.3. Published Materials	6
4. Compliance Notation	6
5. Equipment	6
6. Verification Of Hex Crimp Size	6
7. Crimp Tool Adjustment Method	7
8. Documentation	7

1. Introduction

1.1. Executive Summary

This document details a procedure to evaluate crimp tool operation and adjust tools if required.

1.2. Scope

To determine and verify the actual crimp dimension of hex crimp tools. Provide a calibration technique for adjusting hex crimp tools.

1.3. Benefits

Crimp tools can go out of adjustment with use, potentially resulting in performance impairments such as low cable retention, shielding degradation, poor grounding and generation of unwanted intermodulation signals.

Properly adjusted tools will ensure connector/cable junction performance in accordance with connector manufacturer's published specifications.

1.4. Intended Audience

Installers, maintenance technicians and field supervisors

2. Normative References

The following documents contain provisions, which, through reference in this text, constitute provisions of this document. At the time of Subcommittee approval, the editions indicated were valid. All documents are subject to revision; and while parties to any agreement based on this document are encouraged to investigate the possibility of applying the most recent editions of the documents listed below, they are reminded that newer editions of those documents might not be compatible with the referenced version.

2.1. SCTE References

- No normative references are applicable.

2.2. Standards from Other Organizations

- No normative references are applicable.

2.3. Published Materials

- No normative references are applicable.

3. Informative References

The following documents might provide valuable information to the reader but are not required when complying with this document.

3.1. SCTE References

- No informative references are applicable.

3.2. Standards from Other Organizations

- No informative references are applicable.

3.3. Published Materials

- No informative references are applicable.

4. Compliance Notation

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5. Equipment

Machinist’s outside micrometer having a flat anvil and flat spindle, calibrated to read directly to at least 0.005 inch (0.127 mm), with each division of a width that facilitates estimation of each measurement to 0.0005 inch (0.0127 mm). As an alternate use digital calipers calibrated to read directly to at least 0.0005 inch (0.0127 mm).

6. Verification Of Hex Crimp Size

1. Crimp an empty F-fitting (no cable) of the appropriate size in the front-most hex cavity.
2. Using a micrometer or digital caliper, measure and record the dimensions across each of the three sets of hex flats.

No single measurement across hex flats should deviate more than ± 0.005 inch (± 0.127 mm) of the published hex size.

3. Average the three measurements recorded in the above step.

The average hex crimp measurement should be within ± 0.003 inch (0.076 mm) of the published hex size.

Repeat procedures above for each hex cavity.

If discrepant measurements are obtained, proceed to section 7, Adjustment Method.

7. Crimp Tool Adjustment Method

If crimp tool is adjustable, adjust the tool cam adjustment mechanism per the tool manufacturer’s instructions. Adjustments should be made one notch at a time so that the tool is not over-adjusted or damaged.

Secure the cam keeper, crimp an F-fitting (no cable) and measure the flats as described in section 6.

Continue the adjusting process until the correct hex specification is measured.

If correct hex measurements cannot be obtained by adjustment, the crimp tool must be rebuilt or replaced.

8. Documentation

Crimp Tool Manufacturer -			
Crimp Tool Part Number -			
F-Fitting Manufacturer -			
F-Fitting Part Number -			
Hex Crimp Dimensions			
	Hex Number 1	Hex Number 2	Hex Number 3
	a)	a)	a)
	b)	b)	b)
	c)	c)	c)

Average -			
Published Hex Dimensions			
Maximum Difference			
Average Difference			