

COLOR CODE	DESIGNATION
YELLOW	WITHOUT SEALANT
NATURAL/TRANSLUCENT	WITH SEALANT
BLUE	HALF-TAP
GREEN	CLEAR AND CAP
CLEAR	FLAME RETARDANT

CONNECTOR (WITH AND WITHOUT SEALANT)								
FORM	2-WIRE (Half-Tap)		2-WIRE (Butt and Through)		2-WIRE (Clear and Cap)		3-WIRE	
	WITH	WITHOUT	WITH	WITHOUT	WITH	WITHOUT	WITH	WITHOUT
LOOSE PIECE	553017-2	553017-4	552795-2	552795-4	5-554374-3	5-554374-4	552678-2	552678-4
		553397-1■		1-553395-1■				1-553759-1■
CARTRIDGE	553744-2	553744-4	552966-2	552966-4	554897-1	554897-2	552965-2	552965-4
		553744-5■		552966-5■				406908-1■

■ Flame retardant material

Figure 1

1. INTRODUCTION

This instruction sheet provides splicing procedures for the AMP* Tel-Splice connectors shown in Figure 1. The connectors are designed to terminate solid copper conductors in any combination of 19 through 26 AWG with an insulation diameter range of 2.03 through 0.51 mm [.080 through .020 in.]

NOTE

Dimensions on this sheet are in millimeters [with inches in brackets]. Figures are not drawn to scale.

Reasons for reissue of this sheet are provided in Section 5, REVISION SUMMARY.

2. DESCRIPTION

The connectors are available with two or three wire slots, with or without sealant, and in loose-piece or cartridge form. The two-wire, half-tap connector joins an uncut through wire with a wire end. The two-wire, butt, and through splice connector joins two wire ends. The two-wire, clear, and cap connector keeps two wires together, but not electrically connected. The three-wire connector joins three wire ends. The connectors are color coded to designate the application (see Figure 1).

3. CONNECTOR TERMINATION

3.1. Loose-Piece Connectors

The AMP PRO-CRIMPER® II Hand Tool Assembly 58610-1, AMP Hand Tool 231839-1, or industry standard pliers with parallel action jaws may be used. Refer to Instruction Sheet 408-4235 (packaged with Hand Tool 58610-1) or 408-3183 (Hand Tool 231839-1) for more specific procedures.

1. For two- or three-wire connectors, trim wire ends flush. Insert wires into holes until bottomed in wire entry housing. See Figure 2.

NOTE

For half-tap connectors, place through wire into slot of connector at desired tap location. Make sure through wire is fully contained in slot. Insert tap wire into wire hole until bottomed in wire entry housing.

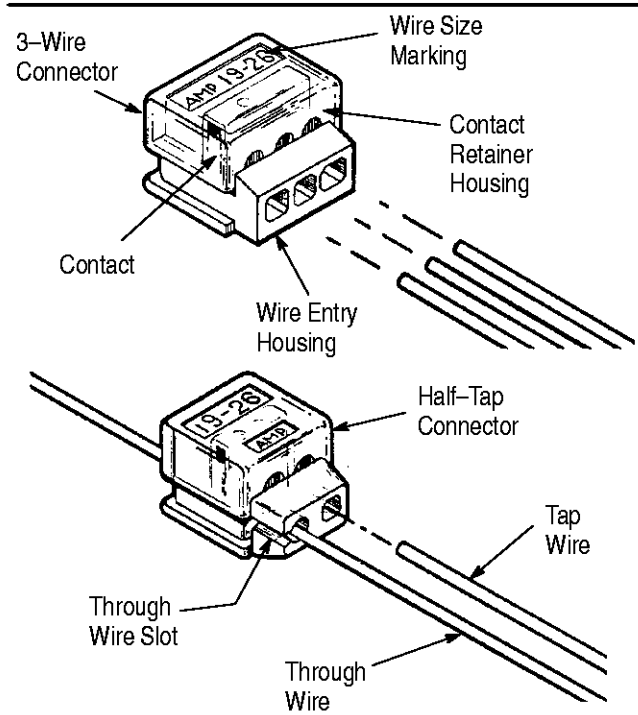
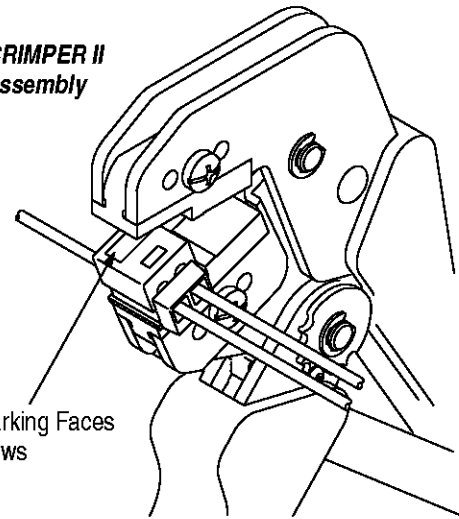


Figure 2

2. Press connector sections together with fingers in order to pre-crimp and hold wires in place until final termination.
3. Place the connector between tool jaws so that the connector wire size marking faces the surface of the jaws. See Figure 3.
4. Check to be sure wires have not shifted. Hold wires in place and squeeze tool handles together.
5. Open tool handles and remove terminated connector.

AMP PRO-CRIMPER II Hand Tool Assembly 58610-1

Wire Size Marking Faces
Surface of Jaws



AMP Hand Tool 231839-1

Wire Size Marking Faces
Surface of Jaws

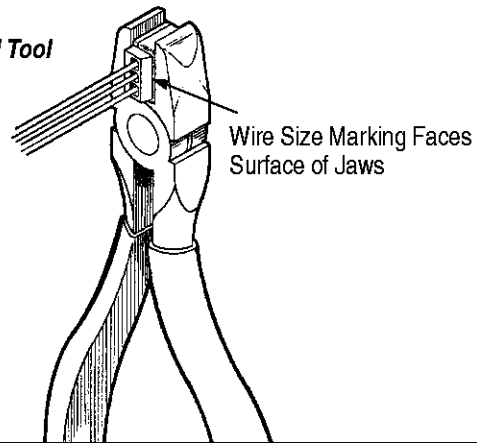


Figure 3

3.2. Cartridge Connectors

The AMP Cartridge Tool 230722-1 terminates this style of connector. Refer to Instruction Sheet 408-6506, packaged with the tooling, for more specific procedures.

1. Position tool selector knob for wire positions in the connector (upper detent position for 2-wire connector and lower detent position for 3-wire connector).
2. The connector stop must be located on the side of the tool opposite the selected wire insertion side, with boss facing inward.

NOTE

For half-tap connectors, Half-Tap Stop 1214523-1 must be installed on the side of the tool opposite the cartridge latch button. Refer to Instruction Sheet 408-4493, packaged with the stop, for specific procedures.

3. Move pusher to back of tool and seat it in the pusher retainer. Depress the cartridge latch button. Insert cartridge into tool until bottomed. Release latch button. Release the pusher and slide it forward until the first connector is positioned between the jaws for termination.

4. For two- or three-wire connectors, trim wire ends flush. Insert wires into holes until bottomed in wire entry housing. See Figure 4.

NOTE For half-tap connectors, place through wire into slot of connector at desired tap location. Make sure through wire is fully contained in slot. Insert tap wire into wire hole until bottomed in wire entry housing.

5. Close handle until bottomed, then release it. The tool will automatically eject the terminated connector and position a new connector for termination.

3. Check each connector by placing connector in the gage – with contact aligned with gage member, or in the cartridge tool gage slot.

4. Slide connector from gage – it should slide out easily with little or no drag. Improperly terminated connectors will stick or have very noticeable drag.

If the sample connectors conform to inspection procedure, the tool can be left in service. If NOT, the tool must be repaired before returning to service. The tool should be checked by gaging terminated connectors at the beginning and ending of each work period.

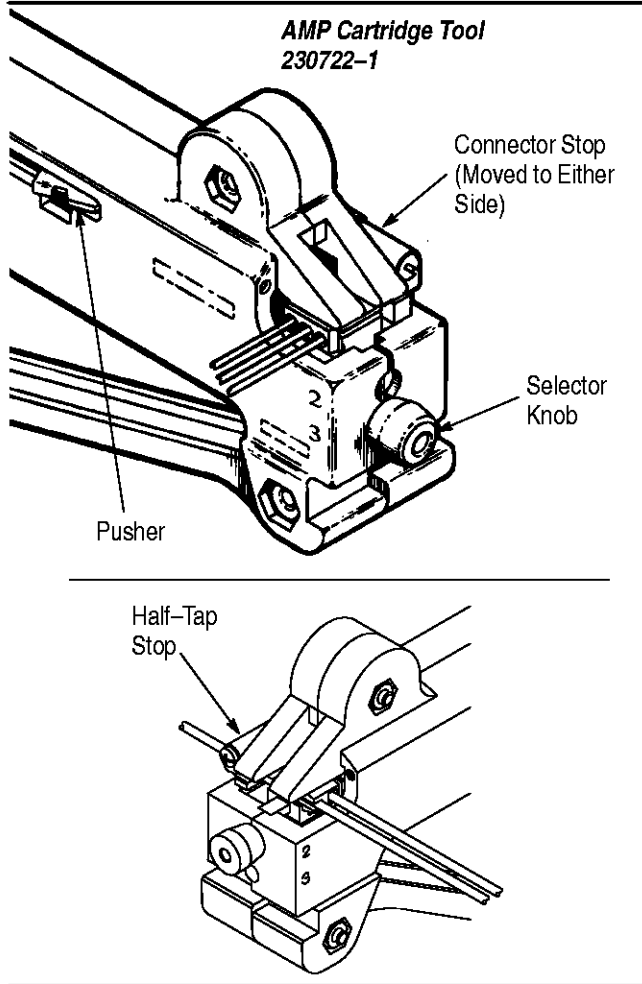


Figure 4

4. GAGING CONNECTOR TERMINATION (Figure 5)

This inspection can be done with AMP Tel-Splice Gage 230495-1 or the gaging slots at the front of the cartridge tool.

1. Terminate several sample connectors with wire used for current application.
2. Select correct gage member (on gage) or gage slot (on cartridge tool) for wire size being evaluated.

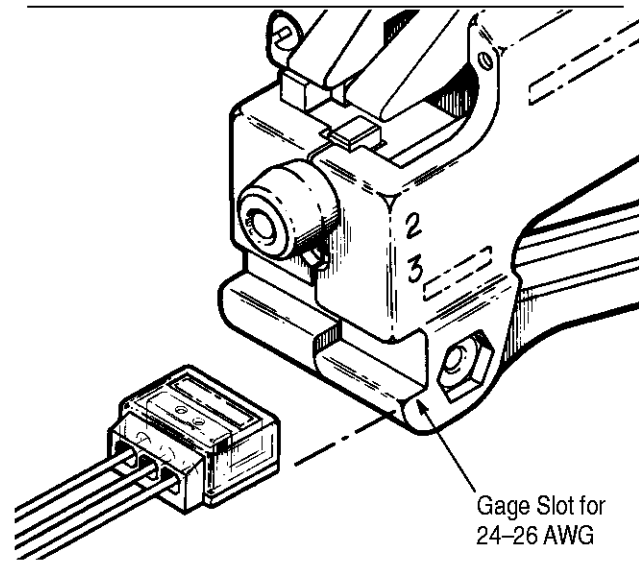
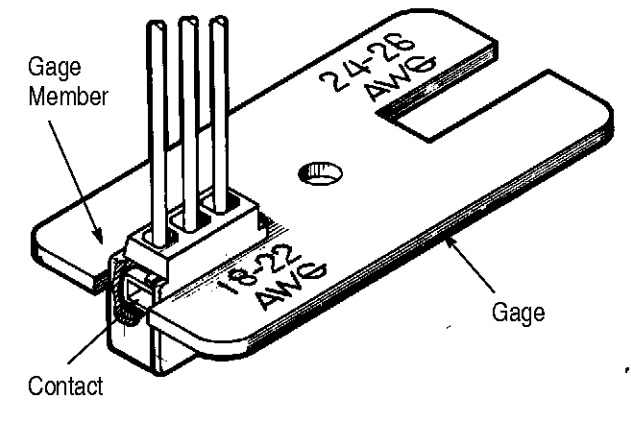


Figure 5

5. REVISION SUMMARY

Per EC 0990-0092-99

- Updated Paragraph 3.2 *Note* stating half-tap stop must be installed on the opposite side of the tool
- Updated Figure 4 to show half-tap stop on opposite side