

| WIRE | | Ultra-Fast FASTON* Series 110/125 Receptacle | | CRIMP DOT CODE |
|------------|--------------------|--|--------|----------------|
| SIZE (AWG) | INSUL DIA (Max) | PN | COLOR | |
| 26-22 | 2.54 mm [.100 in.] | 7-520366-2 (Loose Piece) | Violet | 3 |
| | | 7-520365-2 (Strip Form) | | |

Figure 1

1. INTRODUCTION

AMP* Platform Crimping Die Assembly 58052-3 is used in Hand Crimping Tool 58078-3 to crimp Ultra-Fast FASTON Series 110/125 fully-insulated receptacles (listed in Figure 1) onto solid, fused, or stranded wire.

For information on using the hand tool, refer to instruction sheet 408-6976. Read these instructions carefully before crimping any receptacles.

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

Reasons for reissue of this instruction sheet are provided in Section 7, REVISION SUMMARY.

2. DESCRIPTION

The die assembly consists of an upper die (crimper) and a lower die (anvil). The dies are held in the tool by a single screw. A hex wrench is included for securing the lower die to the hand tool. When mated, the dies form two crimping chambers.

The die assembly, identified by the stamped part number and wire range designation (26-22 AWG), has a violet color dot code that must correspond with the color of the receptacle translucent insulation.

The crimp dot code (3 dots) will be embossed on the receptacle after the crimping procedure. Observe the crimp dot code on the finished crimp to make sure that the correct die assembly was used.

3. DIE INSTALLATION (Figure 2)

1. Squeeze tool handles together until they bottom, then allow the handles to fully open.
2. Hold the hand tool so that the BACK of the tool is facing you (note the setscrew in the lower die platform).
3. Slide the lower die onto the tool lower die platform, ensuring that the large drilled hole in the side of the lower die aligns with the setscrew in the lower die platform.
4. Using the hex wrench, turn the setscrew *CLOCKWISE* until the screw is secure. Do NOT over-tighten the screw.

NOTE If lower die will not seat on lower die platform with drilled hole aligned with the setscrew, use the hex wrench to turn the screw either in or out until lower die is correctly positioned.

Installing Die Assembly

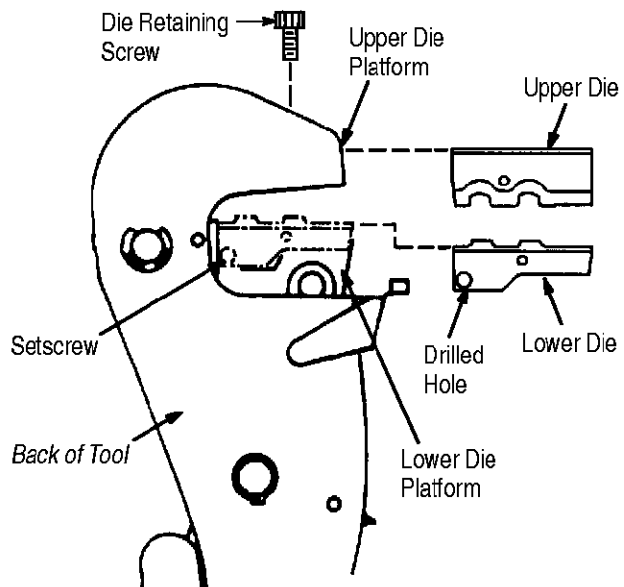


Figure 2

5. Remove die retaining screw from upper die retaining screw.
6. Position upper die in the tool upper die platform, and thread die retaining screw through mounting hole into top of tool and into the upper die until it is secure, but NOT tight.
7. While guiding upper die into alignment with lower die, slowly close tool handles until dies bottom. Tighten upper die retaining screw.
8. Squeeze tool handles together until ratchet releases. Allow tool handles to open FULLY.

4. CRIMPING PROCEDURE

Strip the wire to the length indicated in Figure 3.

NOTE

Do not cut or nick wire strands.

Typical Ultra-Fast FASTON Fully-Insulated In-Line Receptacle

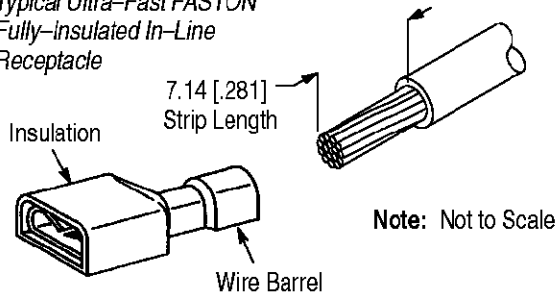


Figure 3

Proceed as follows:

1. Hold the tool so that the FRONT of the tool faces you.
2. Squeezing tool handles together and allow handles to open FULLY.
3. Insert receptacle into the appropriate crimping chamber with the flat side of the receptacle seated on the locator.
4. Squeeze tool handles sufficiently to hold the receptacle firmly in place without deforming it.
5. Insert a properly stripped wire into the receptacle wire barrel.
6. Holding wire in place, squeeze the tool handles together until ratchet releases. Allow handles to open FULLY.
7. Remove the crimped receptacle from the tool. Inspect the crimp to ensure that the three embossed dots appear on the receptacle.

NOTE

For detailed crimp inspection requirements, refer to Application Specification 114-2123.

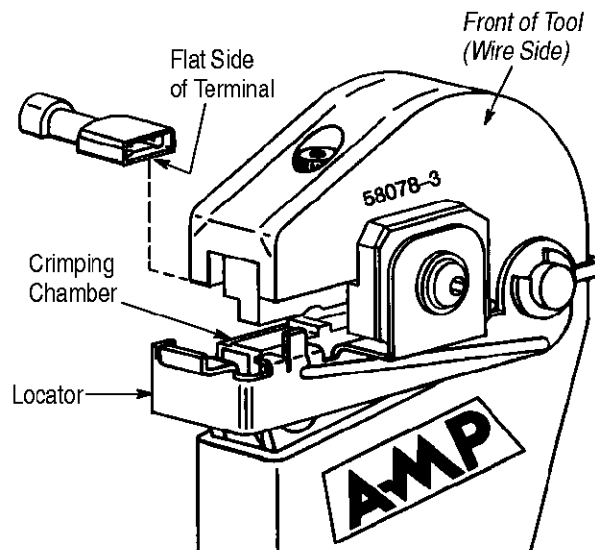


Figure 4

5. MAINTENANCE AND INSPECTION

5.1. Daily Maintenance

It is recommended each operator of the dies be made aware of—and responsible for—the following steps of daily maintenance:

1. Remove dust, moisture, and other contaminants with a clean brush, or a soft, lint-free cloth. Do NOT use objects that could damage the dies.
2. Make sure the proper die retaining screws and die components are in place and secured. Refer to Section 6 if replacements are needed.
3. Make certain all surfaces are protected with a THIN coat of any good SAE 20 motor oil. Do NOT oil excessively.
4. When the dies are not in use, mate and store them in a clean, dry area.

5.2. Periodic Inspection

Regular inspections should be performed by quality control personnel. A record of scheduled inspections should remain with the dies and/or be supplied to supervisory personnel responsible for the dies. Though recommendations call for at least one inspection a month, the inspection frequency should be based on the amount of use, ambient working conditions, operator training and skill, and established company standards. These inspections should be performed in the following sequence:

A. Visual Inspection

1. Remove all lubrication and accumulated film by immersing the dies in a suitable commercial degreaser that will not affect paint or plastic material.

2. Check all bearing surfaces for wear. Remove and replace worn components.
3. Inspect the crimping area for flattened, chipped, cracked, worn, or broken areas. If damage is evident, the dies must be repaired before returning them to service. See Section 6.

B. Gaging the Crimping Chamber

This inspection requires the use of plug gages conforming to the dimensions provided in Figure 5. AMP does not manufacture or market these gages. To gage the crimping chamber, proceed as follows:

1. Remove traces of oil or dirt from the crimping chamber and plug gage.
2. Mate the dies until the crimping surfaces have bottomed; then hold in this position. Do NOT force beyond initial contact.
3. Insert GO element into the crimping chamber; but do not force it. The GO element must pass through the length of the crimping chamber. See Figure 5.
4. In the same manner, try to insert the NO-GO element into the crimping chamber. The NO-GO element may enter partially, but must not pass completely through the length of the crimping chamber. See Figure 5.

If the crimping chamber conforms to the gage inspection, the dies may be considered dimensionally correct and should be lubricated with a THIN coat of any good SAE 20 motor oil. If the crimping chamber does NOT conform to the gage inspection, the dies must be returned to AMP for further evaluation and repair. Refer to Section 6.

For additional information regarding the use of a plug gage, refer to 408-7424.

6. REPLACEMENT AND REPAIR

Customer-replaceable parts are listed in Figure 6. A complete inventory should be stocked and controlled to prevent lost time when replacement of parts is necessary. Parts other than those listed should be replaced by AMP to ensure quality and reliability. Order replacement parts through your AMP representative, or call 1-800-526-5142, or send a facsimile of your purchase order to 717-986-7605, or write to:

CUSTOMER SERVICE (038-035)
 AMP INCORPORATED
 PO BOX 3608
 HARRISBURG PA 17105-3608

For customer repair service, please contact an AMP representative at 1-800-526-5136.

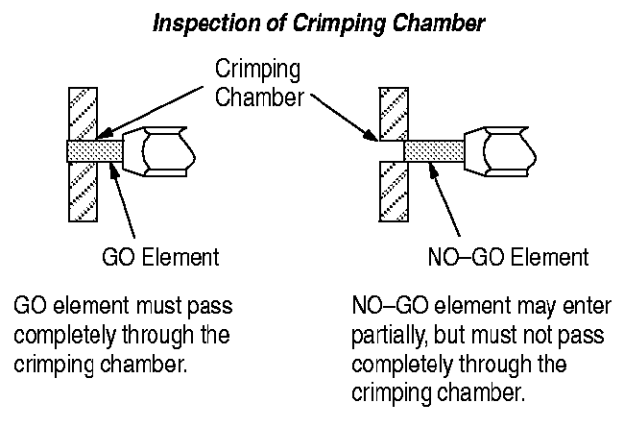
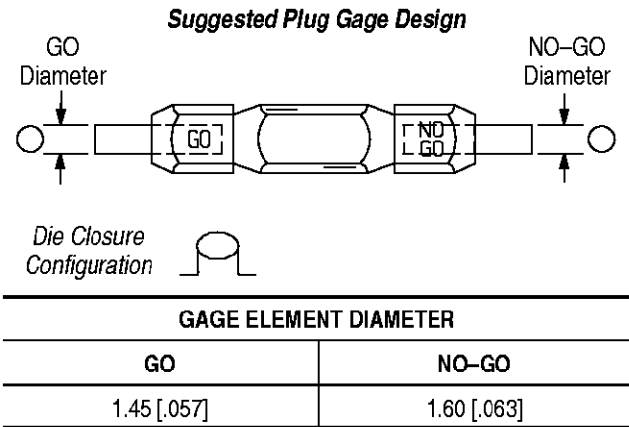
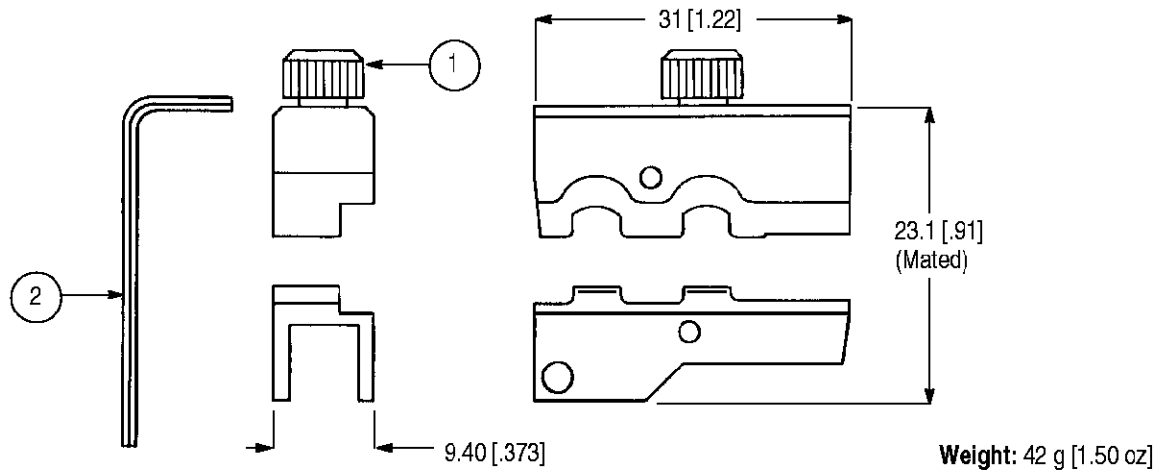


Figure 5

7. REVISION SUMMARY

Revisions to this instruction sheet per EC 0990-1195-99 include:

- Updated document to corporate requirements
- Changed title of document
- Changed 'socket head screw' to 'setscrew' in Section 3
- Added 114-2123 as reference to Section 4, Step 7
- Added die closure configuration to Figure 5
- Added customer service information and replaced customer repair address with phone number in Section 6



REPLACEMENT PARTS

| ITEM | PART NUMBER | DESCRIPTION | QTY PER ASSEMBLY |
|------|-------------|---|------------------|
| 1 | 3-21000-4 | SCREW, Die Retaining, 10-32 x 9.52 [.375] L | 1 |
| 2 | 21027-3 | WRENCH, Hex | 1 |

Figure 6