AMP

A-MP★ HAND TOOL 574867
FOR CRIMPING
FASTON★ TERMINALS

IS 1018GB	
RELEASED	4.12.78
REVISED	

1. INTRODUCTION

These tools crimp both straight and flag FASTON terminals. The terminals must be pre-formed. Each tool has four crimping sections:

20-18 - for straight terminals within this wire range
16-14 - for straight terminals within this wire range
FLAG - for flag terminals
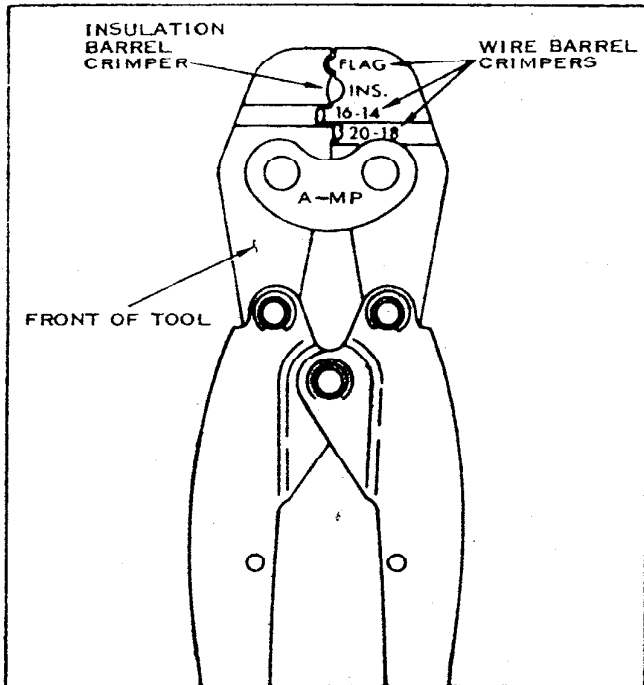INS - (insulation) for straight and flag terminals

FIGURE 1

2. STRIPPING WIRE

Strip your wire 1/32 inch longer than the length of your terminal's wire barrel. Remember, strip length equals wire barrel plus 1/32 inch.

3. CRIMPING A STRAIGHT TERMINAL

Select a straight terminal, and crimp it as follows:

1. Open the Tool Handles, and center your terminal's wire barrel in the proper Crimping Section. Figure 2 shows you how.

2. Hold the terminal in place, and squeeze the Tool Handles until the Crimping Jaws close on the terminal. You should close them just enough to hold the terminal in place. DO NOT DEFORM THE WIRE BARREL.

3. Insert your stripped wire into the terminal. Be sure the insulation does not enter the wire barrel.
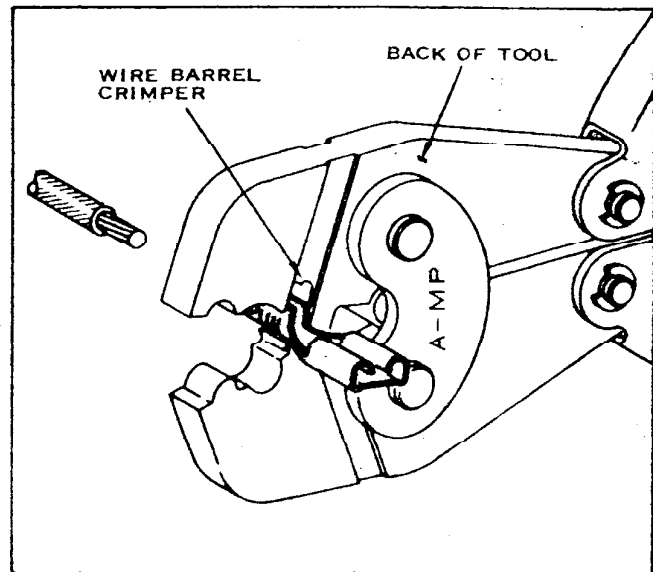

FIGURE 2

4. While you hold the wire in place, squeeze the Tool Handles all the way closed.

5. The wire crimp is finished. Remove the terminal from the tool.

6. Place the terminal's insulation barrel in the Insulation Crimping Section. Figure 3 shows you how.

7. Close the Tool Handles all the way.

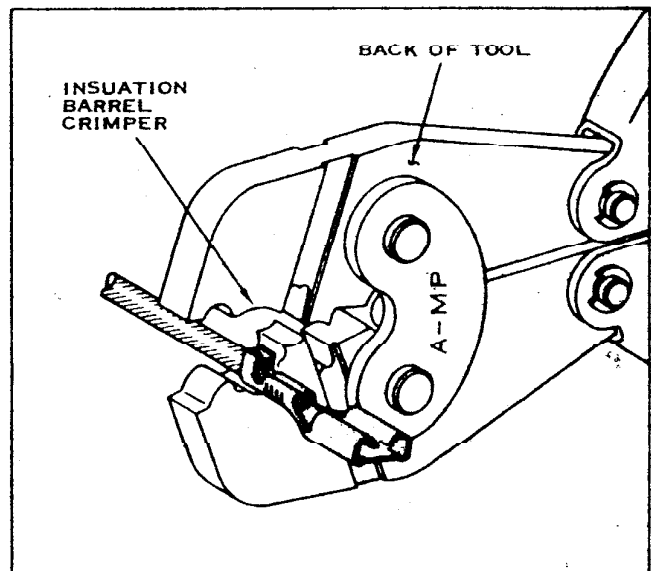8. Open the Handles, and remove the crimped terminal.

FIGURE 3

★ TRADEMARK OF AMP INCORPORATED

FIGURE 4

Labels in Figure 4:
- BACK OF TOOL
- WIRE BARREL AT 45° ANGLE
- A-MP
- ANVIL
- LOCK TAB

FIGURE 5

Labels in Figure 5:
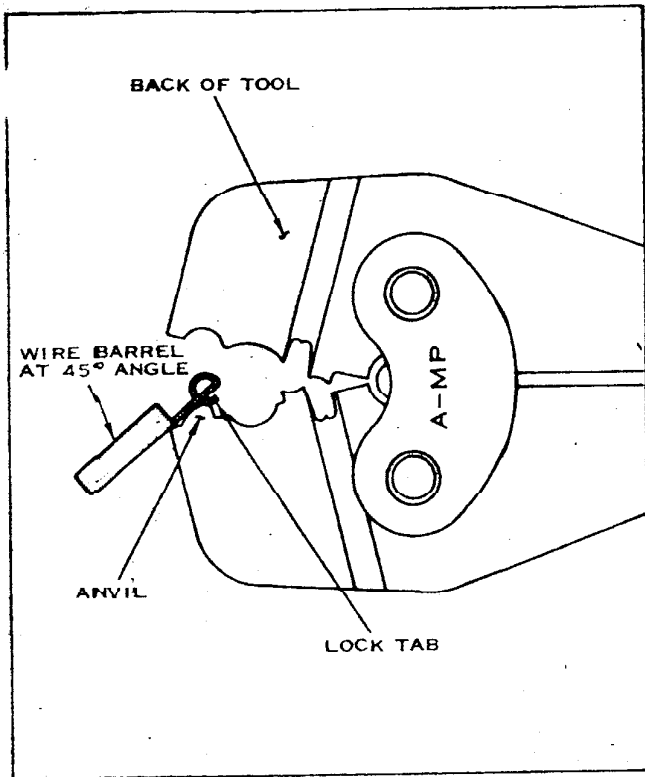- INSULATION BARREL IN INSULATION CRIMPER
- CRIMPED WIRE BARREL
- FRONT OF TOOL

4. CRIMPING A FLAG TERMINAL

Select a Flag terminal, and crimp it as follows:

1. Open the Tool Handles, and center your terminal's wire barrel in the Crimping Section marked "FLAG". Figure 4 shows you how. Make sure the terminal's Lock Tab rests on the Anvil. The wire barrel should be angled at about 45 degrees.

2. Hold the terminal in place, and squeeze the Tool Handles until the Lock Tab touches the bottom of the wire barrel. DO NOT DEFORM THE WIRE BARREL.

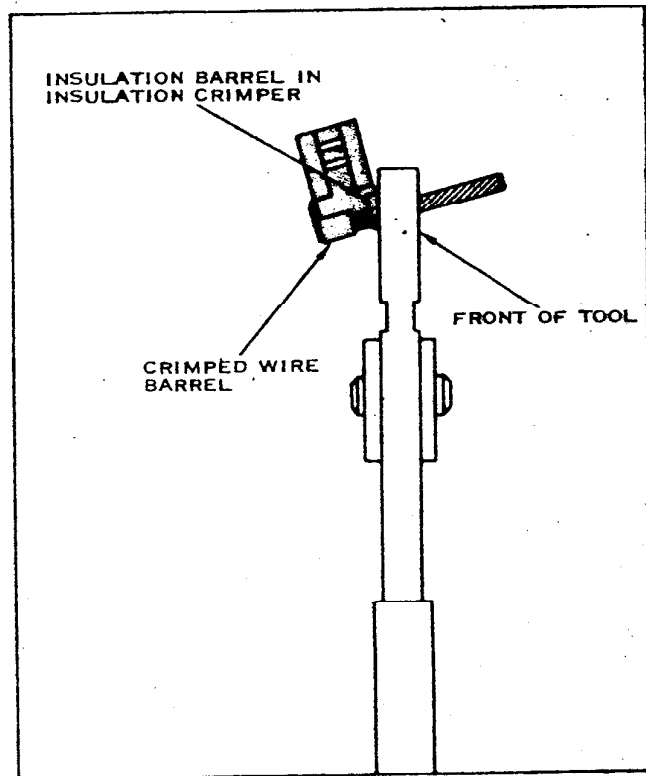3. Insert your stripped wire into the terminal. Be sure the insulation does not enter the wire barrel.

4. While you hold the wire in place, squeeze the Tool Handles all the way closed.

5. The wire crimp is finished. Remove the terminal from the tool.

6. Place the terminal's insulation barrel in the Insulation Crimp Section. Figure 5 shows you how.

7. Close the Handles all the way.

8. Open the Handles, and remove the crimped terminal.

5. MAINTENANCE

Oil all Pins, Pivot Points, and Bearing Surfaces of the tool. You may use any good S.A.E. No. 20 Motor Oil.