

AMP

of Great Britain Ltd.

APPLICATION AND MAINTENANCE INSTRUCTION FOR STRAIGHT ACTION HANDTOOLS LISTED

INSTRUCTION SHEET

IS 1151 GB

RELEASED

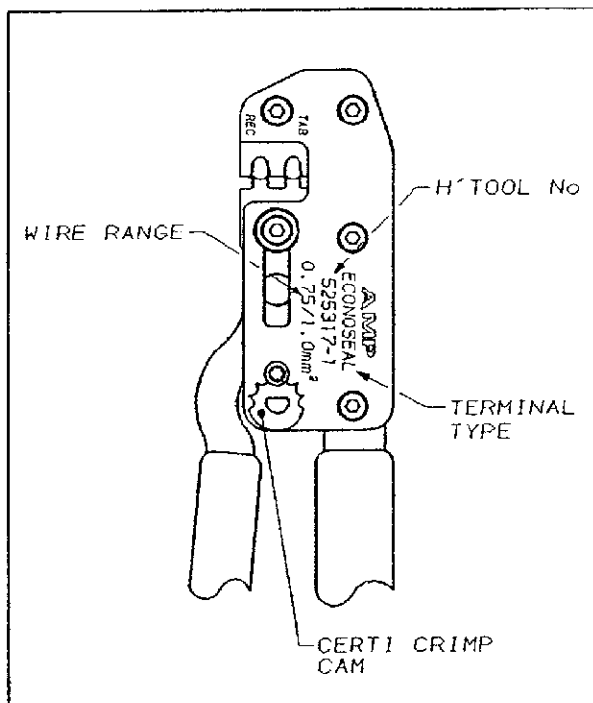
2-91

REVISED

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SECTION 1 of this instruction sheet provides application procedures for AMP hand crimping tools

SECTION 2 provides maintenance and inspection procedures for AMP hand crimping tools



TOOL No.	APP SPEC No.
525317-1	114-3040
525317-2	114-3040
525317-3	114-3040
525317-4	114-3040
525317-5	114-3040
525317-6	114-3040

Fig. 1-2

SECTION 1

APPLICATION

1-1 INTRODUCTION

This instruction sheet is to be used for general information on use and maintenance of tools listed Fig. 1-2. Read these instructions thoroughly before crimping any terminals.

1-2 DESCRIPTION

This tool comprises of fixed crimpers and moveable anvils, a terminal support, a locator/wire stop and a CERTI-CRIMP ratchet.

The terminal support prevents the terminal from bending during the crimping procedure.

The locator/wire stop has two functions. It is used to position the wire within the terminal and the terminal within the tool.

The tool ratchet assures that a full crimp is applied to the terminal.

Once engaged, the ratchet will not release until the tool handles have been fully closed.

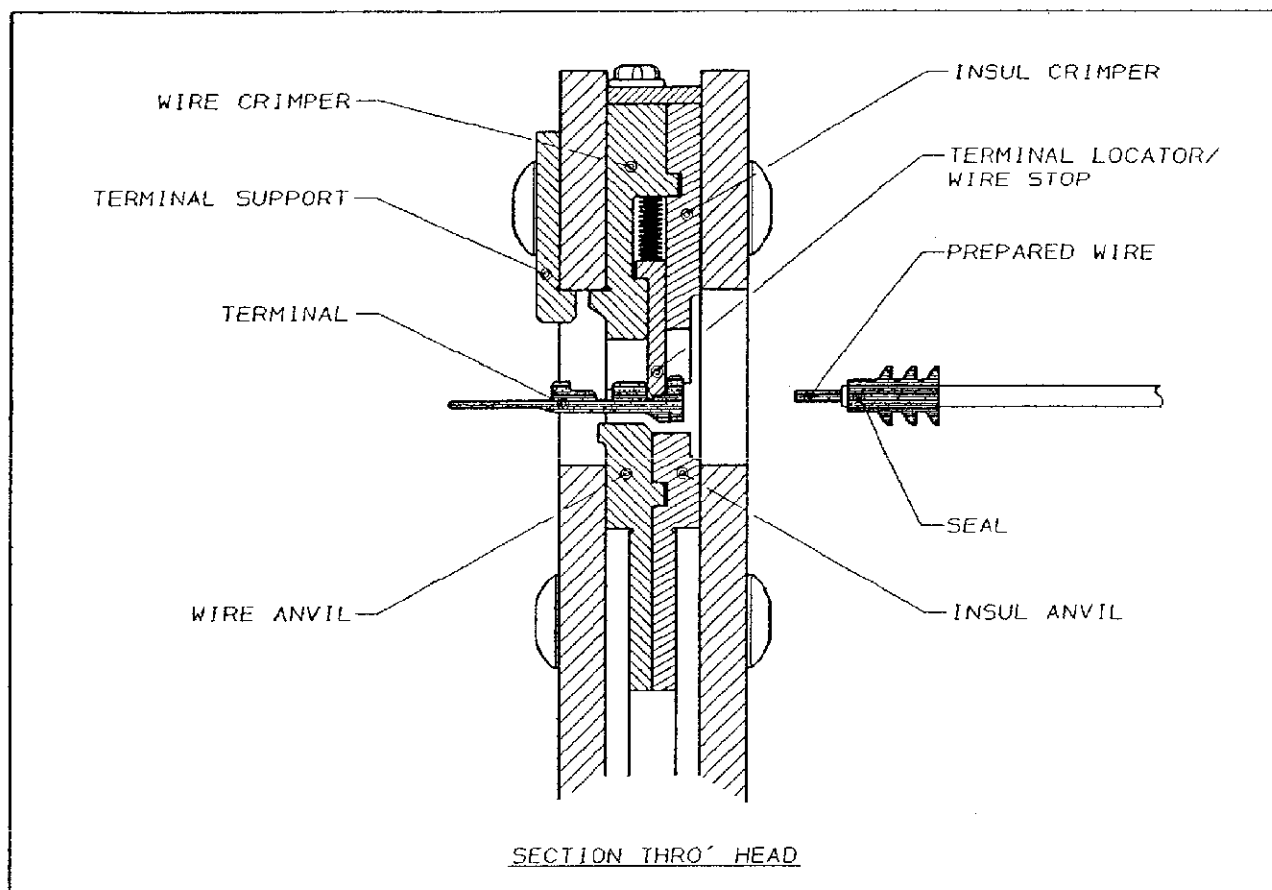


Fig. 1-3

1-3 CRIMPING PROCEDURE

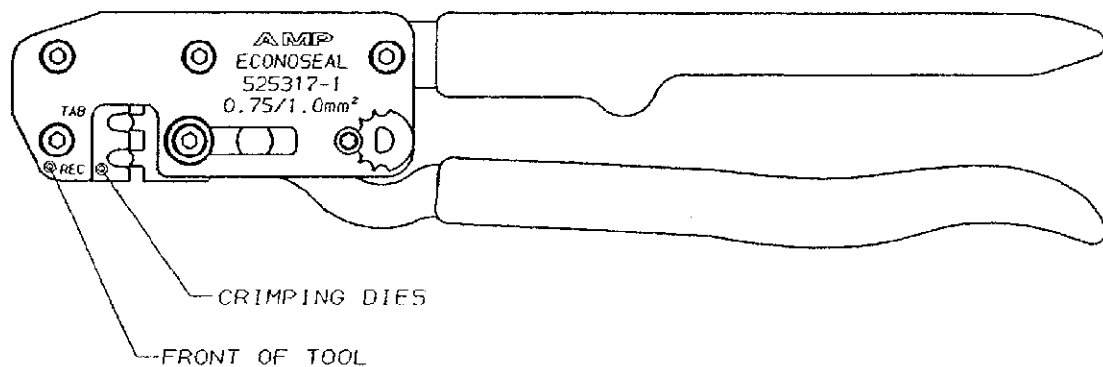
Using the appropriate APPLICATION SPEC (see Fig.1-2) select a wire/wire and seal within the specified wire range and strip to length shown, taking care not to cut or nick the strands.

Notice that each crimp station of the tool has the applicable terminal type marked above it. Use these markings and the wire size used to determine the proper crimp station to use. Select a terminal and proceed as follows:

1. Hold the tool so that its FRONT is facing you.
2. Make certain that the ratchet is released by squeezing the tool handles and allowing them to open fully.
3. Looking straight into the insulation dies from the FRONT of the tool, insert a terminal (wire barrel first) into the FRONT of the tool.
4. Position the terminal in the crimper so that the locator enters the locator slot of the terminal.
5. While holding the terminal in this position, squeeze the tool handles until the dies close just enough to hold the terminal in position. Do NOT deform the wire barrel.
6. Insert a properly stripped wire/wire and seal into the terminal until the wire/wire and seal butts against the terminal locator.
7. Hold the wire/wire and seal in place and squeeze the tool until the ratchet releases.
8. Allow the tool handles to open fully and remove the crimped terminal.

SECTION 1 of this instruction sheet provides application procedures for AMP hand crimping tools

SECTION 2 provides maintenance and inspection procedures for AMP hand crimping tools



TOOL SPECIFICATION	LENGTH	WIDTH CLOSED	DEPTH MAX	WEIGHT
	265mm	50mm	20mm	0.5Kg

SECTION 2 MAINTENANCE/INSPECTION

2-1 TOOL INSPECTION

These instructions have been approved by AMP Design, Production, and Quality Control Engineers to provide documented maintenance and inspection procedures. The procedures described herein have been established to ensure quality and reliability of AMP hand crimping tools.

2-2 INSPECTION PROCEDURE

A. DAILY MAINTENANCE

It is recommended that each operator of the tool be made aware of-and responsible for-the following four steps of daily maintenance:

1. Remove dust, moisture, and other contaminants with a clean brush, or soft lint-free cloth. Do NOT use objects that could damage the tool.
2. Make sure that the retaining pins are in place and secured with the proper retaining screws and washers.

3. Make certain all pins, pivot points and bearing surfaces are protected with a THIN coat of any good SAE No. 20 motor oil. Do NOT oil excessively.
4. When the tool is not in use, keep the handles closed to prevent objects from becoming lodged in the crimping dies and store the tool in a clean, dry area.

B. PERIODIC INSPECTION

Regular inspections should be performed by quality control personnel. A record of scheduled inspections should remain with the tool and/or be supplied to supervisory personnel responsible for the tool. 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.

B-1 VISUAL INSPECTION

1. Remove all lubrication and accumulated film by immersing the tool (handles partially closed) in a suitable commercial degreaser that will not affect paint or plastic material.
2. Make certain all retaining pins and screws are secured. Replace missing or defective parts if necessary.
3. Close the tool handles until the ratchet releases, then allow handles to open freely. If they do not open quickly and freely, the spring is defective and must be replaced [see Paragraph 2-3 REPAIR]

Inspect the head assembly with special emphasis on checking for worn, cracked, or broken dies. If damage to any part of the head assembly is evident, return to AMP for evaluation and repair [see Paragraph 2-3, REPAIR]

B-2 CRIMP HEIGHT INSPECTION

This inspection requires the use of a micrometer with a modified anvil as shown in Figure 2-2. We recommend the modified micrometer [Crimp height comparator 2-576692-0] from:
AMP [Gt. Britain] Ltd.
Merrion Ave., Stanmore, Middlesex.

Proceed as follows:

1. Refer to the appropriate APPLICATION SPEC. See Fig 1-1, for the required terminal/wire combination.
2. Refer to paragraph 1-3, CRIMPING PROCEDURE and crimp the terminals accordingly.
3. Using a crimp height comparator measure wire barrel crimp height as shown in Figure 2-2. If the crimp height conforms to that shown in the APPLICATION SPEC, the tool is considered dimensionally correct. If not return the tool to AMP for evaluation and repair (see para 2-3 REPAIR)

For additional information concerning the use of the crimp height comparator refer to AMP Instruction Sheet 15 7424

RATCHET INSPECTION

Obtain a 0.025mm. shim that is suitable for checking the clearance between the bottoming surfaces of the crimping dies.

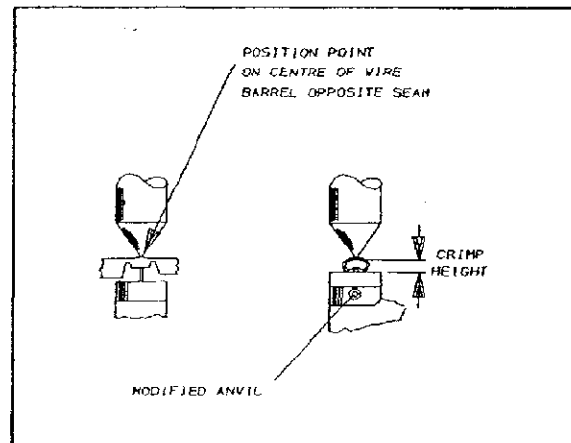


Fig. 2-2

Proceed as follows:

1. Select the MAXIMUM terminal/wire combination, see APPLICATION SPEC.
2. Position the terminal and wire between the crimping dies, according to Paragraph 1-3, CRIMPING PROCEDURE [Steps 1 through 6]. Holding the wire in place, squeeze the tool handles together until the WEZAG-CRIMP ratchet releases. Hold the tool handles in this position, maintaining just enough pressure to keep the dies closed.

3. Check the clearance between the bottoming surfaces of the crimping dies. If the clearance is 0.025mm. or less, the ratchet is satisfactory. If clearance exceeds 0.025mm., the ratchet is out of adjustment and must be repaired [see Paragraph 2-3, REPAIR].

If the tool conforms to these inspection procedures, lubricate with oil provided or with any good SAE NO 20 motor oil and return it to service.

2-3 REPAIR

When repair is necessary, return the tool with a written description of the problem to:

AMP [Great Britain] Ltd
Tool Repair Section
Industrial Estate
Port Glasgow

PA14-SUX

or a wholly owned subsidiary of AMP Incorporated