

AMP

AMP CRIMPING HEADS P/N'S 752850-1/752851-1
FOR CRIMPING PIDG FASTON* TERMINALS
ON BATTERY-POWERED HAND TOOL 752861-2

411-5182
IS-182J

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INSTRUCTION SHEET

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Introduction:

This instruction sheet covers operation and maintenance of AMP Crimping Heads P/N 752850-1 and 752851-1 for crimping PIDG FASTON* Terminals on AMP Battery-Powered Hand Tool P/N 752861-2.

Read this instruction sheet carefully, before you start operation.

Read IS-169J together with this instruction sheet for inspection and maintenance of crimping head.

(2) Crimping Procedure:

Refer to IS-166J, Para. (4)-1 for detailed crimping procedure by using battery-powered hand tool.

Crimping head must be mounted on the tool rightly, and crimping terminals must be placed correctly in the crimp dies of the head as shown in Fig. 2 below.

(1) Applicable Terminals and Wire Insulation Stripping Length:

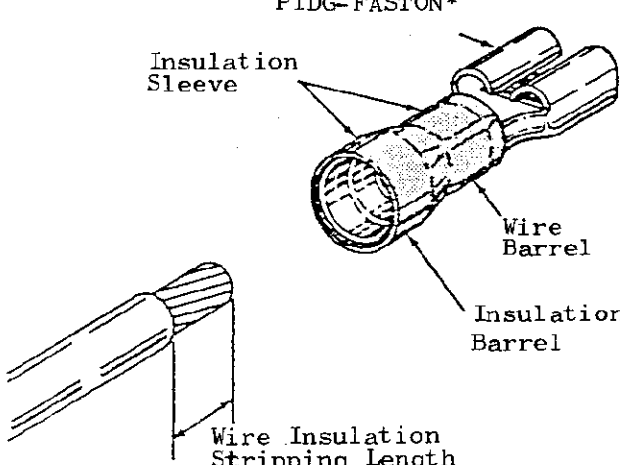
PIDG-FASTON*				
				
Crimp Die Part No.	Terminal Part No.	Wire Size mm ²	Insulation Dia. (mm)	Insulation Stripping mm
752850-1	170604	1.25~2.27	4.06	4.8
	42332			
	42727			
	42747			
	60211			
	60212			
	60213			
	61171			
	61697			
	61429	1.25~2.27	4.57	
752851-1	170603	0.3~0.89	3.43	5.6
	42888			
	60023			
	60180			
	42599			
	42628			
	61205			
	60972			

Fig. 1

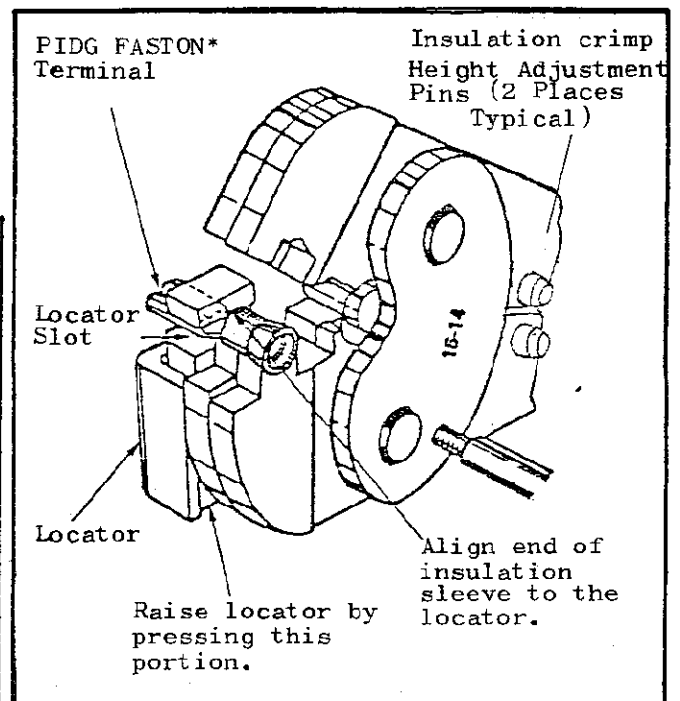


Fig. 2

(3) Adjustment of Insulation Crimp Height:

The insulation crimping section of the head has three positions: (1) tight, (2) medium and (3) loose. To adjust the section:

- Insert the insulation crimp adjustment pins into the No. 3. position for crimping onto thick wires.
- Insert the pins into No. 2 position for crimping on medium diameter wires.
- Insert the pins into No. 1 position for crimping on thin diameter wires.

(4) Periodic Inspection:

Regular inspection should be performed by the operator periodically, once every 500 cycles of crimping approximately.

The checking should be visually performed to see the following points.

- 1) Refer to Paragraph 2.1, Page 2 of Instruction Sheet, IS-169J, for checking mounting hole distance of crimping head, and measure the distance between the holes.
- 2) Refer to Paragraph 2.2, Page 2 of Instruction Sheet, IS-169J, for checking crimping pressure of the tool on dies.
- 3) Visually inspect for the following:
 - a) Check to see if any abnormalities such as chip-off of die edge, crack, damage and breakage took place in crimping dies, as shown in Fig. 3.
 - b) Confirm if all the component parts, including retaining pins and rings, are in attached places. If any of them is missing, it must be placed in with the new part.

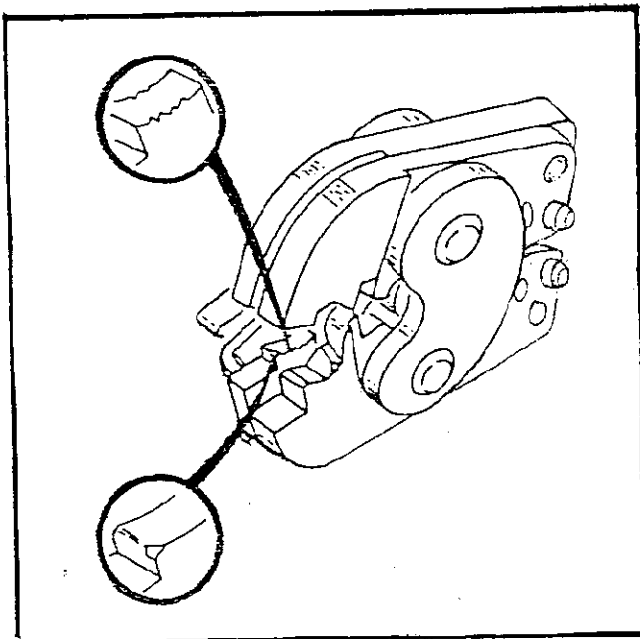


Fig. 3

4) Die Closure Inspection:

Every tool is inspected for proper die closure before packaging. An inspection should be performed periodically to check the die closure for excessive wear. The die closure inspection is performed using GO, NO-GO gages. So long as proper inspection according to the procedures stated in Paras. 2.1 and 2.2 of IS-169J, it may not be necessary to check the dies.

However, for correct control of the crimp height of the die, check the die as follows:

- (a) Mount crimping jaws on handle assembly of hand crimping tool accordingly.
- (b) Clean oil or dirt from the die closures and plug gage members.
- (c) Close handles of the tool until crimping jaws are bottomed. Do not apply additional pressure to tool handles.
- (d) With crimping jaws bottomed, check the die closure using the proper plug gage. Hold gage in straight alignment with the die closure and carefully try to insert, without forcing the GO member. The GO member must pass completely through the crimping die closure.
- (e) Try to insert the NO-GO member. The NO-GO member may enter partially, but must not pass completely through the die closure.
- (f) If the die closures meet the GO, NO-GO gage conditions, the closures may be considered dimensionally correct.
- (g) If you find that the tool die closures do not conform with the GO, NO-GO gage conditions, contact your local AMP field representative.

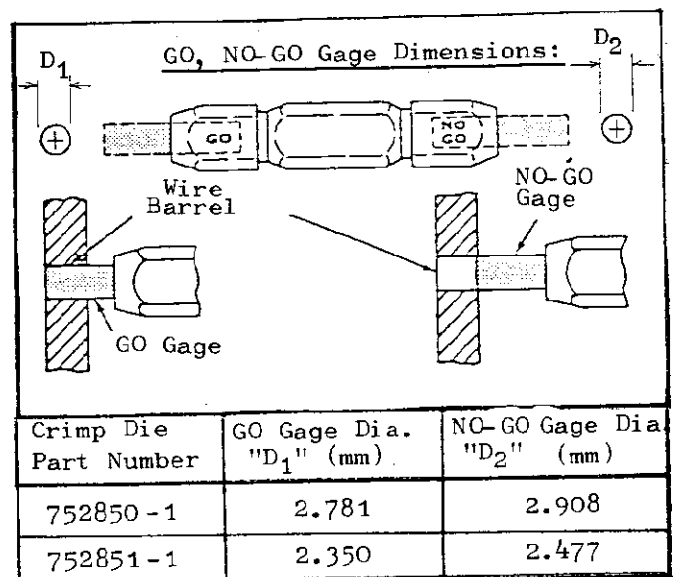


Fig. 4

(5) Repair:

When tool repair is required, send the tool to AMP Company with the document stating the details of failure condition.