



AMP CRIMPING DIE ASSEMBLY P/N 752856-1
FOR CRIMPING FASTON TERMINALS MOUNTED ON
BATTERY-POWERED CRIMPING TOOL P/N 752861-2

INSTRUCTION SHEET

IS-185J	
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RFA-1140

1. Introduction:

AMP crimping head P/N 752856-1 has been designed to crimp FASTON loose piece terminals of the part numbers listed in Table 1 below, with the use of AMP battery powered tool P/N 752861-2, as the head is mounted on the tool.

The auxiliary information relating to the selection of crimping heads with respect to the terminals to be crimped, inspection and checking of the crimped

terminals and maintenance of the head and tooling will be obtained from the instruction sheet IS-169J, prepared for this product application.

Read the instructions, contained in these materials, before you start operation. The additional materials will be supplied upon request. Contact AMP Japan or the local sales representative of your area.

Crimping Die Part No.	Crimp Symbols	Contact Part No.		Wire Size (mm ²)	Insulation Diameter (mm)	Insulation Stripping Length (mm)
		Loose Piece	Strip (Ref.)			
752856-1	A	42731 60243	42640 60169 42860	0.3 - 0.89	1.5 - 2.5	6.4
	B	41968 60878 60878 41969 42370 60130 60233 61370 60358 61316 62596	41771 41771 41772 41772 42286 42286 42510 42510 42743 60294 62449 42602 60316	0.3 - 0.89	2.3 - 3.3	

Table 1

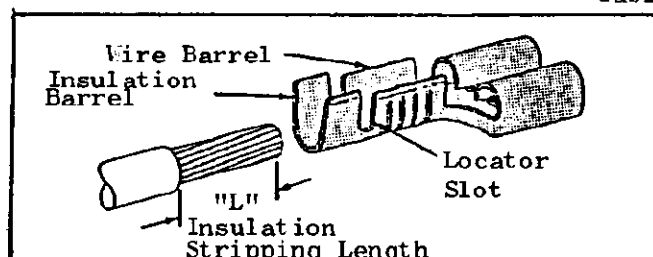


Fig. 1

The insulation of the wire must be removed to the length as specified in Table 1, prior to the crimping operation. Do not cut or nick the conductor strand by the insulation removal operation. Avoid using the wires that are damaged or cut in conductors.

2. CRIMPING OPERATION:

- 1) Referring to Table 1, confirm the application of the wire size, contact part number and the crimp symbol before you start.
- 2) Close the dies lightly so that the locator insulation stop enters the terminal locator slot. Hold the terminal in this position. DO NOT DEFORM THE TERMINAL AT THIS STAGE OF CRIMPING.
- 3) Insert the stripped end of the wire into the wire barrel through the window of the locator insulation stop until the wire insulation stops against the locator insulation stop. This position is the correct depth of wire insertion, at which the optimum crimping is performed.
- 4) Start crimping by operating the tool, according to the operation instructions provided in Para. (4)-1 of the instruction sheet, IS-166J prepared for operation of the battery-powered, AMP crimping hand tool. The tool opens when the crimping of the terminal is finished.

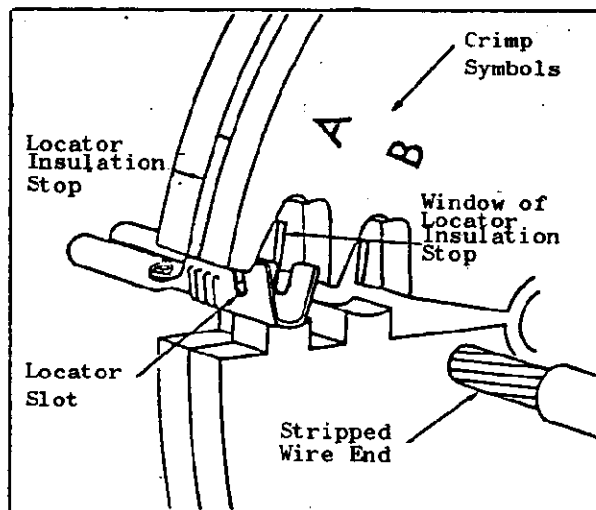


Fig. 2

3. ADJUSTMENT OF INSULATION CRIMP HEIGHT:

This crimping die has three steps of the insulation crimp height adjustment setting. Find the most suitable insulation crimp height by inserting the adjustment pin into the hole of the die. The steps are: No. 3 (Large), No. 2 (Medium) and No.1 (Small). The optimum gripping is to hold the wire firmly without breaking the insulation after crimping.

4. INSPECTION OF WIRE BARREL CRIMP HEIGHT:

For checking the crimp height of the crimping die, a modified micrometer as shown in

Fig. 3 is used. Order AMP-Japan for purchasing the micrometer, or request for supplying the drawing for modification of a micrometer, in case the user can modify it by his in-house facilities. The drawing is supplied without charge.

Check the crimp height from time to time during operation. When the measured height is conforming to the value shown in Fig. 3, the tool proves to have been acceptable. If not, the tool must be returned to AMP factory for repair.

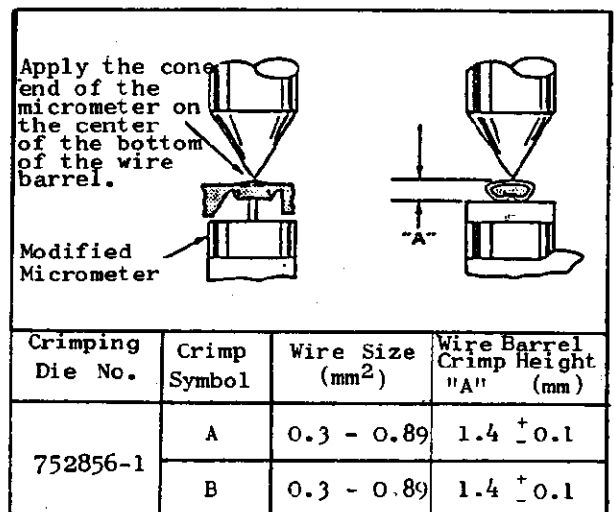


Fig. 3

5. INSPECTION OF CRIMPING DIES:

For assuring normal crimping, a periodical inspection on crimping dies must be performed in the intervals of approximately 500 cycles of crimping according to the procedure described below.

- 1) Measure the dimension of the mounting hole diameter of the crimping dies on the crimping tool, according to Para. 2-1 of the instruction sheet, IS-169J.
- 2) Visually check if any cracks, chip-off or breakage are evident on all corners and edges of the crimping jaws.
- 3) Check to see if any retaining rings and pins are missing from the designated positions.

6. REPAIR:

When any abnormalities are found on the tool, as a result of inspection checking per Para. 4 and Para. 5, return the tool to AMP-Japan or local sales offices or representative of your area with clear descriptions of the status and conditions of the tool immediately.