AMP* Straight Action Hand Tool (P/N 753788-1) for 5/7.5mm Pitch Connector Instruction Sheet

AMP

PROPER USE GUIDELINES

Cumulative Trauma Disorders can result from the prolonged use of manually powered hand tools. AMP hand tools are intended for occasional use and low volume applications.AMP offers a wide selection of powered application equipment for extended-use, production operations.

1. INTRODUCTION

This instruction sheet covers the operation and maintenance on Crimping Hand tool P/N 753778-1 for 5/7.5 mm PITCH Receptacle. Read this manual before operation

2. DESCRIPTION

The combinations among tool P/N crimping dies contact and wire are shown in Table-1. Make sure that the wire specification range and the insulation diameter to compare with other dimension.

3. STRIPPING METHOD

Stripping length on wire is 3.0 to 4.0mm as shown in following. Do not crimp wires that are cut or nicked when insulation is stripped.
The designed performance is not certified if unacceptable proper wire is used.

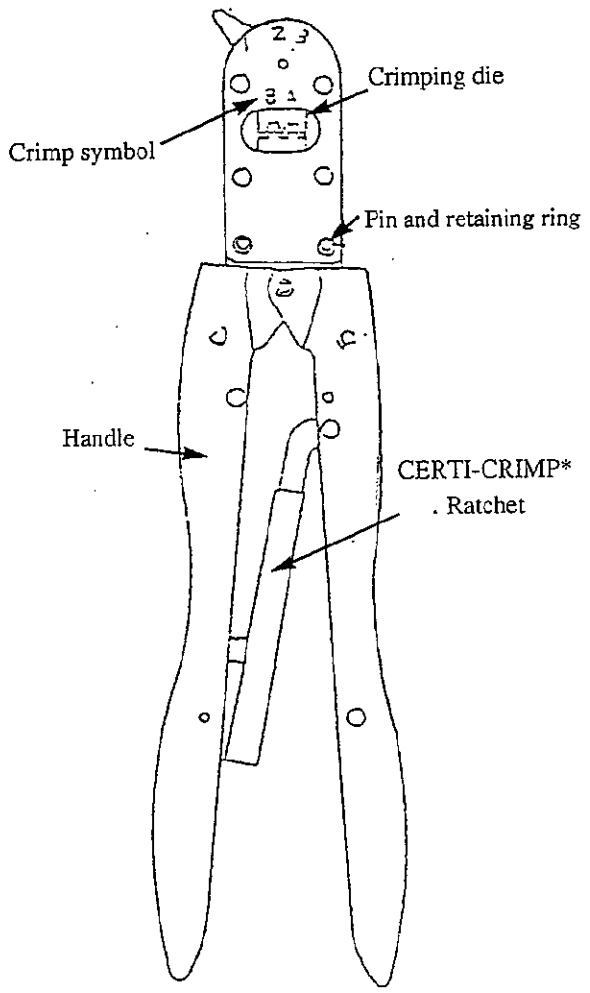

Fig.1

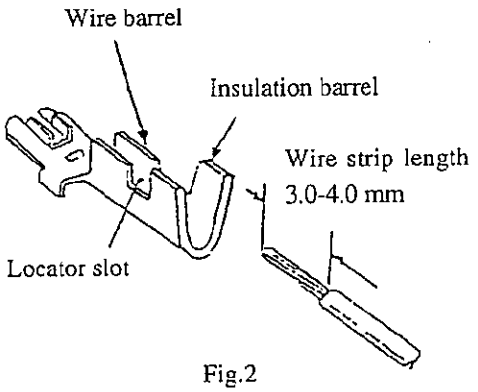

Fig.2

Table-1

CRIMPING MARK	CONTACT		WIRE		WIRE CRIMPING HEIGHT (mm)
	STRIP	LP	SIZE (AWG) mm2	INSULATION DIAMETER (mm)	
A	-	171601	0.20-0.35 (#24-#22)	1.5 - 2.5	0.75-0.89
B	-	171601	0.50-0.56 (#20)	1.5 - 2.5	0.90-1.07

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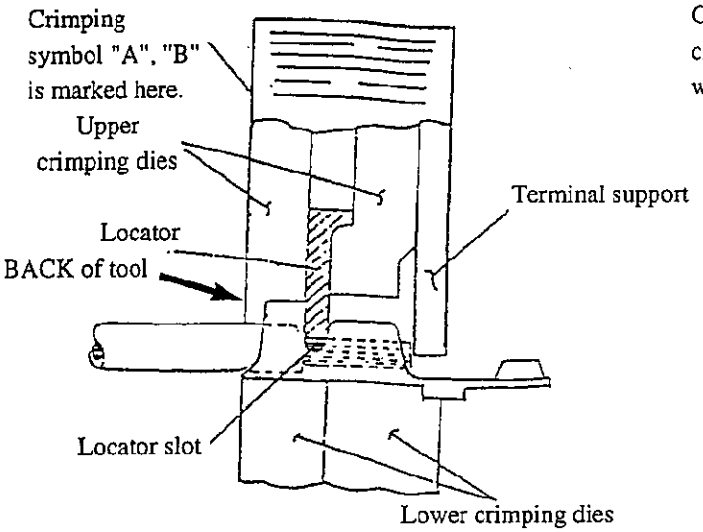
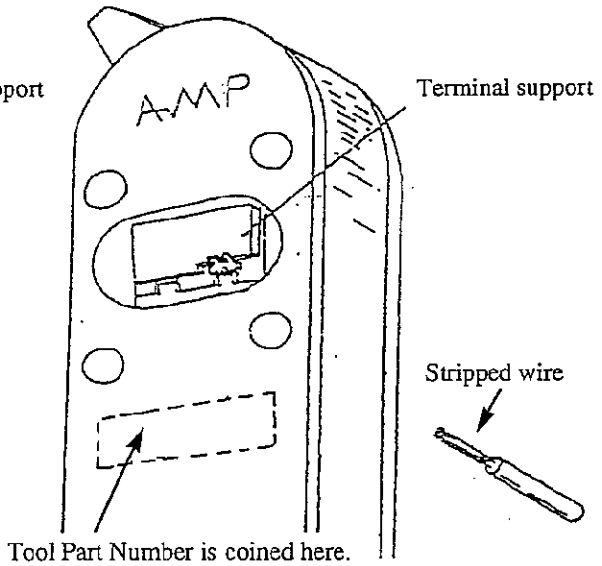


The terminal is inserted into crimping dies for locator slot to fit with locator on tool.

Center wire barrel on wire barrel crimping die and close handle until terminal is held in place. Insert wire and complete crimp.



4. CRIMPING PROCEDURE

(a) The tool is provided with CERTI-CRIMP* Ratchet to regulate crimping pressure which is required crimping of terminals. Once it engages, the handle cannot be opened unless the handles are closed to the bottom where the correct crimping is achieved.

(b) INSULATION CRIMP ADJUSTMENT
The insulation crimping section of the hand tool has three positions 1-Tight 2-Medium 3-Loose
This is depend upon the diameter of wire and can be adjusted with three positions 1-Tight , 2-Medium, 3-Loose. Make test crimp and remove crimped terminal a few time. It is not proper the Insulation barrel makes wire barrel damaged with tight adjustment. Wire should be supported by the insulation crimp adjustment Insulation crimp adjustment is proper position.
Hold the hand tool so the BACK of it is facing to you. Insert the contact into the crimping dies of tool shown in Fig.3

(c) Close the handles lightly just enough to hold the terminal in place. DO NOT CLOSE THE WIRE BARREL STRONGLY. Terminal must not be deformed at this stage.

(d) Insert stripping wire end into the wire barrel of the terminal until it stops in the bottom

(e) Holding the wire in place close the handles strongly as far as they go until the ratchet release.

(f) Remove the contact from dies handles strongly after crimping.

5. MAINTENANCE

For keeping reliable performance of the tool. The care must be taken to handle it moderately. The following cautions should be observed.

(a) Do not throw nor the tool onto the floor, nor strike things with tools.

(b) Avoid crimping terminals of the sizes other than instructed in Table-1.
Apply a thin coat of machine oil of good quality, which is equivalent to SAE #20, to the bearing surfaces but do not oil excessively.

(c) Remove dirt and greasy foreign matters from the tool with the use of soft lint-free cloth wiping off gently. After using wipe the die surfaces, and close the handles for preventing from foreign matters from entering into the die.

(d) Wipe excess oil off from tool particularly from crimping are. Oil transferred from crimping area onto certain termination may affect the electrical characteristics of an application.