AMP INCORPORATED
Harrisburg, Pa. 17105

APPLICATION AND MAINTENANCE FOR AMP★ HAND CRIMPING TOOL 69992

Instruction Sheet
IS 2540
RELEASED 7-23-84

Section I of this instruction sheet provides application procedures for AMP hand crimping tools. *Section II provides maintenance and inspection procedures for AMP hand crimping tools.*

AMP-FIT FITTING	PART NO.
Coupling	332843
Branch Tee Fittings	
H Fitting with Ground	332824
K Fitting with Ground	332823
K Fitting without Ground	561759-1
J Fitting with Ground	332841
L Fitting with Ground	332842
Pulling Eye and Pipe Plug	561274-1
Pipe Plug with F Pressure Testing Valve	561683-1
Tee Fitting	561515-1
Panel Fitting	561411-1
Transition Fitting — CA-3131 Feeder Pipe to 3/8-Inch Plastic Tubing	561720-1

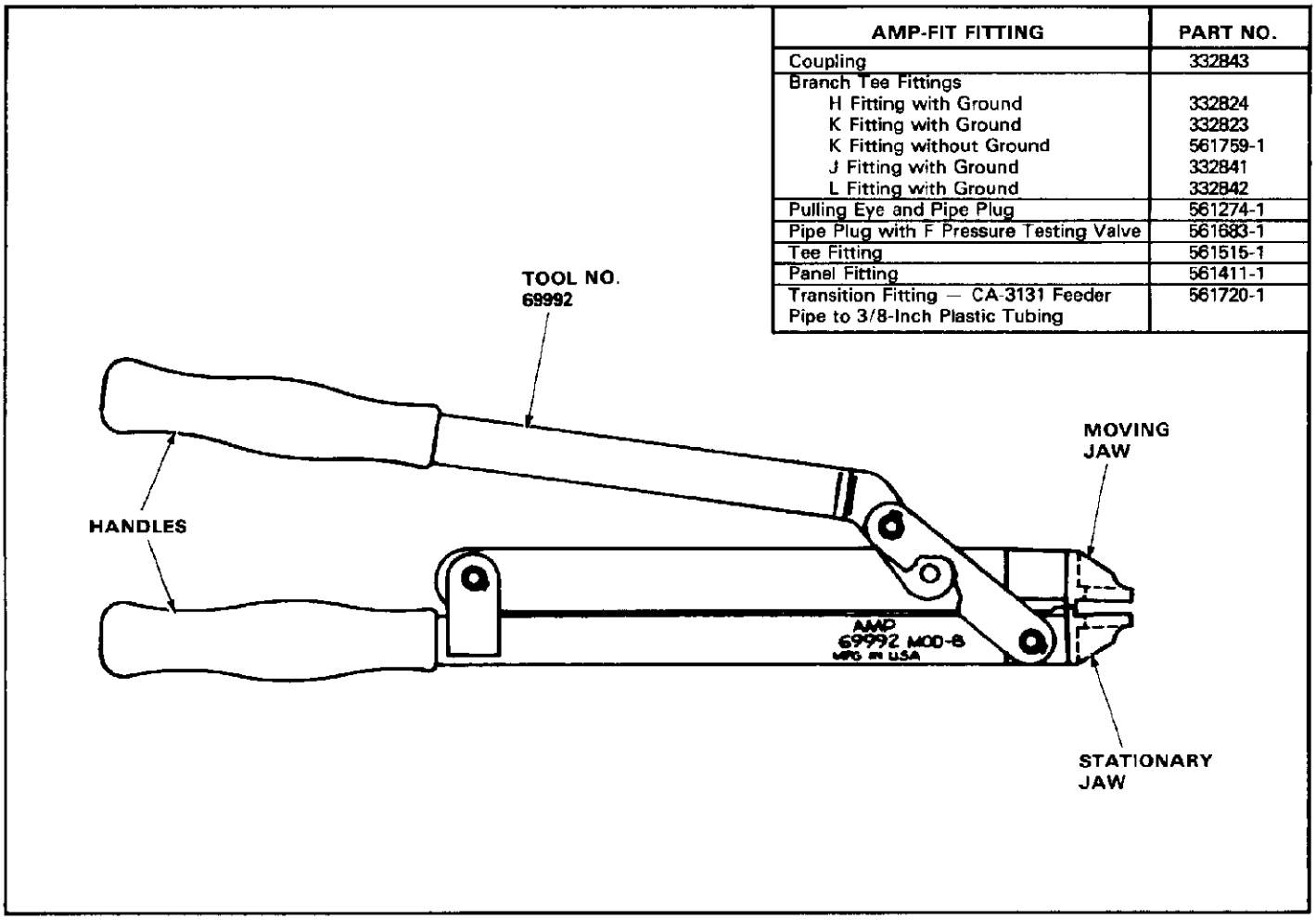

Fig. I-1

SECTION I APPLICATION

I-1. INTRODUCTION (Figure I-1)

This instruction sheet (IS) covers the use of AMP Hand Crimping Tool 69992 which is used to apply AMP-FIT★ fittings listed in Figure I-1 to CA-3131 dry air feeder pipe in pressurized dry air pipe systems.

Read this material carefully before applying the AMP-FIT tube fittings.

NOTE *All dimensions on this instruction sheet are in inches.*

I-2. DESCRIPTION

The hand crimping tool features a stationary jaw and a moving jaw. The stationary jaw butts against the back of the shoulder of the selected fitting; the moving jaw forces the ring flange over the end of the pipe until it bottoms against the front of the shoulder of the fitting.

I-3. PREPARATION AND ASSEMBLY (Figure 1-2)

When practical, complete the threaded connections on the fittings prior to crimping CA-3131 Feeder Pipe connections. For example, install required F Pressure Testing Valves or pipe plugs before crimping pipe to fittings. Use pipe thread compound to coat threads. Hand tighten each connection and then use a wrench to tighten an additional 1 1/2 turns, leaving two or three threads exposed. When this is done, the pipe is ready to be prepared and assembled to the fitting.

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Proceed as follows:

1. Cut the end of the pipe squarely. Remove any burrs from both the inner and outer diameters of the pipe. See Figure I-2, A.
2. Size and chamfer the pipe using the appropriate pipe shaper.
3. Slide stainless steel ring over end of pipe with flanged end of ring toward fitting, as shown in Figure I-2, B.
4. Slide fitting onto pipe until pipe bottoms inside fitting. The minimum insertion depth is 5/8 inch. Refer to Figure I-2, C.
5. Slide stainless steel ring forward until it butts against the end of the fitting. The assembly is now ready to be crimped.

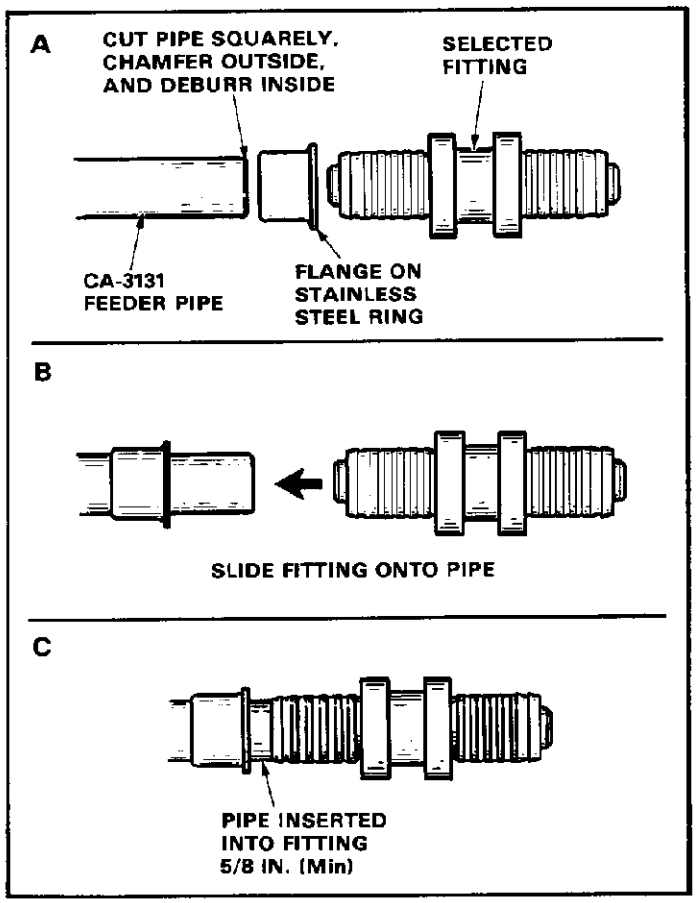


Fig. I-2

I-4. CRIMPING (Figures I-3 and I-4)

If crimping under normal temperature conditions, the procedures listed below are recommended. However, if crimping in cold temperatures (below freezing), the ends of the fittings to be crimped should be coated with the same soap solution that is used for leak detection. This will aid in the crimping process.

To crimp the fitting, proceed as follows:

1. Open the handles of the hand tool and place the fitting between the crimping jaws of the tool with the stationary jaw in back of the fitting shoulder and the moving jaw in back of the ring flange. See Figure I-3.

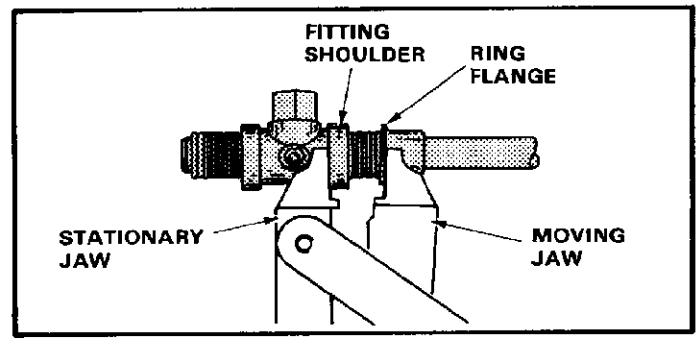


Fig. I-3

2. Close the handles until the ring flange is resting against the fitting. Then apply a steady, even pressure to the tool handles until the ring flange bottoms against the fitting shoulder. Do *not* "snap" the tool closed. See Figure I-4.
3. Pull handles open and remove crimped assembly.

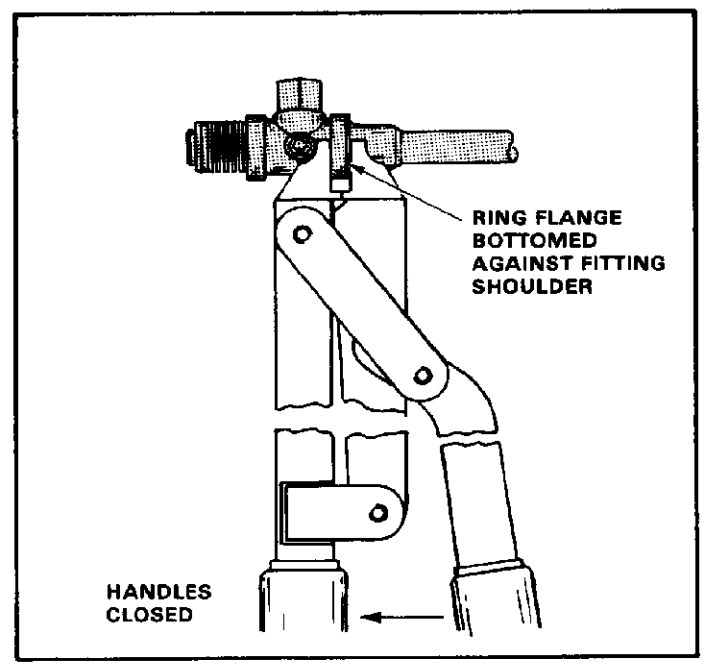
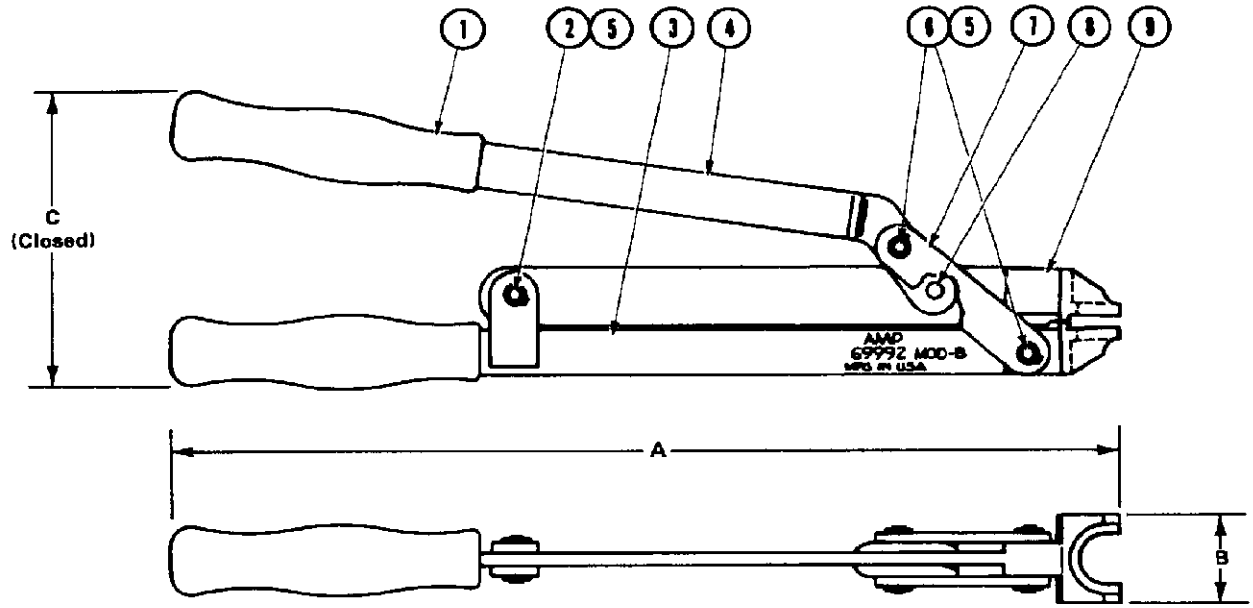


Fig. I-4

I-5. ELECTRICAL BONDING

Electrical bonding of CA-3131 feeder pipe fittings is described in AMP Instruction Sheet IS 2539, supplied with the fittings.

Section I of this instruction sheet provides application procedures for AMP hand crimping tools. *Section II provides maintenance and inspection procedures for AMP hand crimping tools.*



TOOL SPECIFICATIONS	
DIMENSION (Max)	WEIGHT
A 15 in.	4 1/4 lb
B 1 1/4 in.	
C 6 1/4 in.	
Engineering Approval	Date
L.C. Osman	7-23-84

REPLACEMENT PARTS			
ITEM	PART NUMBER	DESCRIPTION	QTY
1	24696-1	GRIP, Handle	2
2	300448	PIN, Retaining	1
3	307038-3	JAW, Stationary Subassembly	1
4	307031-1	HANDLE, Subassembly	1
5	21048-7	RING, Retaining	6
6	306055-4	PIN, Retaining	2
7	1- 59645-3	LINK	2
8	306061-2	PIN	1
9	307034-3	JAW, Moving Subassembly	1

Fig. II-1

SECTION II MAINTENANCE/INSPECTION

II-1. TOOL CERTIFICATION

These instructions have been approved by AMP Design, Production, and Quality Control Engineers to provide documented maintenance and inspection procedures in accordance with AMP Corporate Policy No. 3-3. Through AMP test laboratories and the inspection of production assembly, the procedures described herein have been established to ensure quality and reliability of AMP hand crimping tools.

Customer replaceable parts (when applicable) are listed in Figure II-1. A complete inventory should be stocked and controlled to prevent lost time when replacement of parts is necessary.

II-2. INSPECTION PROCEDURES

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 a soft, lint-free cloth. Do NOT use objects that could damage the tool.

2. Make sure the proper retaining pins are in place and secured with the proper retaining rings.

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 jaws 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:

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 are in place and secured with retaining rings. If replacements are necessary, refer to parts listed in Figure II-1.

3. Inspect the head assembly, with special emphasis on checking for worn, cracked, or broken jaws. If damage to any part of the head assembly is evident, return the tool to AMP for evaluation and repair (see Paragraph II-3, REPAIR).

II-3. REPAIR

Parts other than those specified in Figure II-1 must be replaced by AMP to ensure certification of the tool. When repair is necessary, return the tool with a written description of the problem to:

AMP Incorporated
Customer Repair
1523 North 4th Street
Harrisburg, Pennsylvania 17102

or a wholly owned subsidiary of AMP Incorporated.