

1. INTRODUCTION

This Instruction Sheet provides "Instructions" on product application and a "Maintenance and Inspection" procedure on the following AMP Hand Crimping Tool, Part Number

525692

This tool will crimp PIDG and PLASTI-GRIP terminals and splices on wire sizes 12 through 10 AWG.

NOTE:- THESE TOOLS ARE COATED WITH A PRESERVATIVE TO PREVENT RUST AND CORROSION. ON RECEIPT WIPE THIS PRESERVATIVE FROM THE TOOL, PARTICULARLY FROM THE CRIMPING AREA, WHERE NO PRESERVATIVE SHOULD BE PRESENT ON COMMENCEMENT OF CRIMPING.

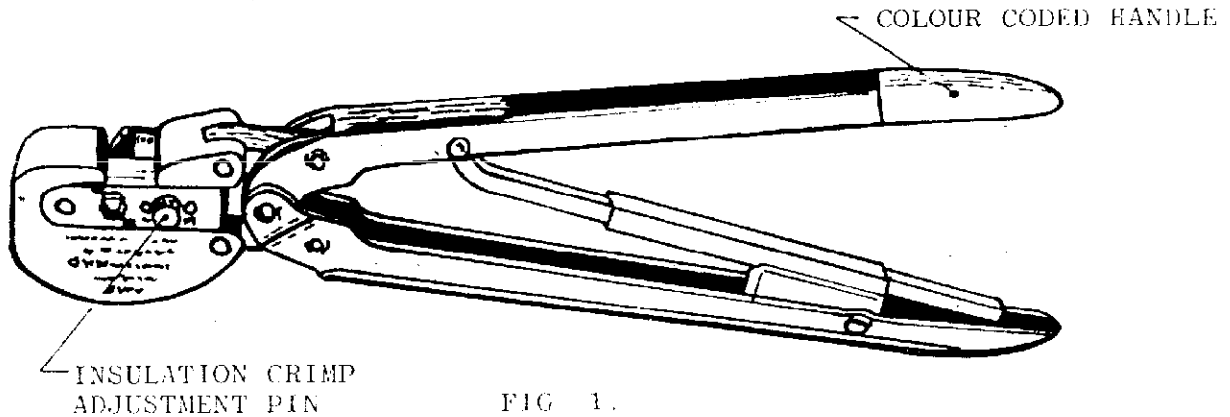


FIG 1.

2. INSTRUCTIONS

Note that tool handles and terminals or splices are colour coded for a given wire range as listed in Fig 2. Crimp colour coded terminal or splice in the matching colour coded tool.

TOOL NUMBER	CRIMPING RANGE	HANDLE COLOUR CODE
525692	12 - 10	YELLOW

FIG 2

HEAVY HEAD HAND TOOL2. INSTRUCTIONS (cont'd)2.1. CRIMPING PROCEDURES

- a) Strip wire to dimensions listed in Fig 3. Do not use wire with nicked or missing conductor strands.

TOOL NUMBER	WIRE RANGE	TOOL COLOUR & DOT CODE	PRODUCT COLOUR CODE	WIRE STRIP LENGTH			
				TERMINALS		SPICES	
				MIN	MAX	MIN	MAX
525692	12-10	YELLOW 1 DOT	YELLOW	5/16	11/32	11/32	3/8

FIG 3

- b) Open tool crimping dies by closing the handles until certi-crimp ratchet releases, open handles. Note that once the ratchet is engaged handles cannot be opened until they are first fully closed.
- c) Place terminal or splice in dies as shown in Fig 4.
- d) Close handles until terminal or splice is held firmly in place. Do not deform terminal or splice wire barrel.
- e) Insert stripped wire into terminal or splice wire barrel as shown in Fig 4.

NOTE:- DO NOT ALLOW WIRE INSULATION TO ENTER TERMINAL OR SPLICE WIRE BARREL.

- f) To complete crimp close handles until certi-crimp ratchet releases. Handles may now be opened and crimped item may be removed.
- g) To crimp other half of splice, remove it and reposition uncrimped half as shown in Fig 4. Repeat above procedure, if splice cannot be turned, turn tool around.

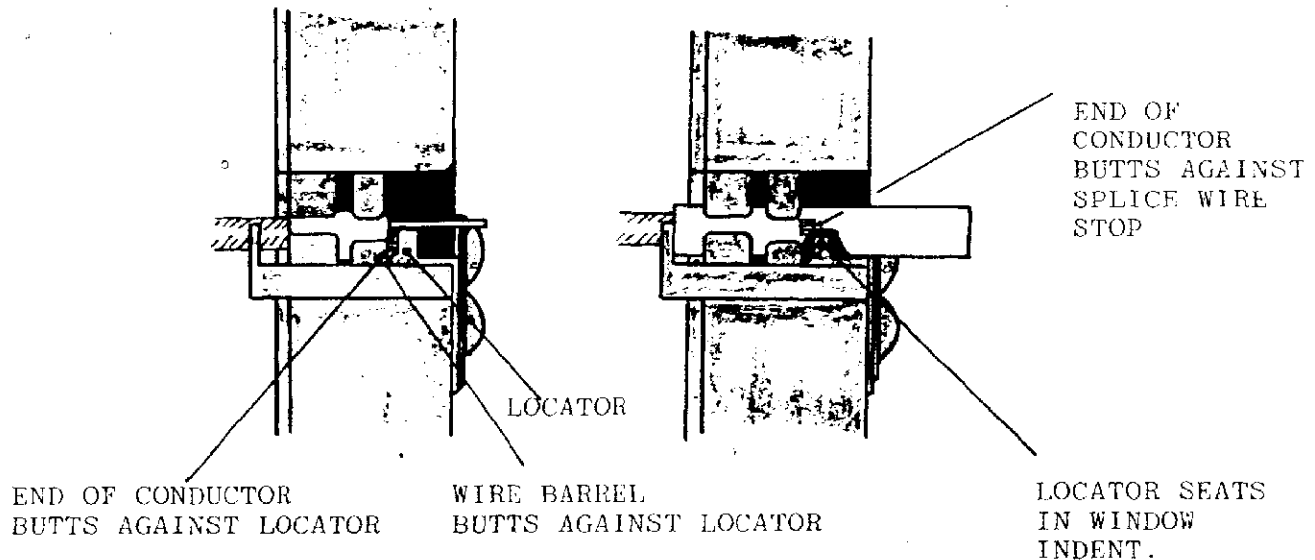
PIDG & PLASTI-GRIP
TERMINALSPIDG & PLASTI-GRIP
SPLICES

FIG 4.

2.2. INSULATION CRIMP ADJUSTMENT2.2.1. PIDG TERMINALS & SPLICES

The insulation crimping section of this tool has three positions, see Fig 1.

1 - Tight, 2 - Medium, 3 - Loose.

Insert insulation adjustment pin in No 3 position.

Place terminal or splice in crimp dies as shown in Fig 4.

Insert UNSTRIPPED wire into ONLY the insulation barrel of the terminal.

Make a test crimp. Remove crimped terminal and check insulation grip as follows: bend wire back and forth 90° once. Terminal should retain grip on insulation. If wire pulls out repeat above procedure using next tighter position until desired grip is obtained. Do not use a tighter setting than required.

2.2.2. PLASTI-GRIP TERMINALS & SPLICES

These terminals feature a wire insulation SUPPORT only. The terminal insulation should ideally be in contact with the wire insulation.

3. DOT CODING

Dot coding will appear on terminal and splices crimped in this tool, see Fig 5. This is used to identify that the correct tool has been used, reference Fig 3.

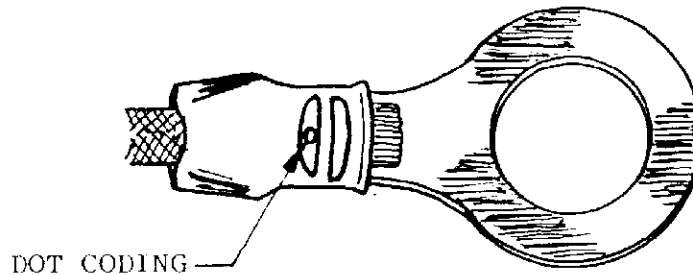


FIG 5.

4. MAINTENANCE AND INSPECTION

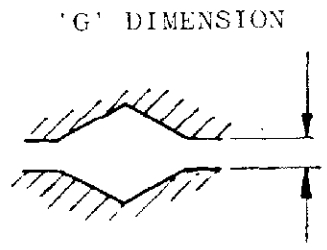
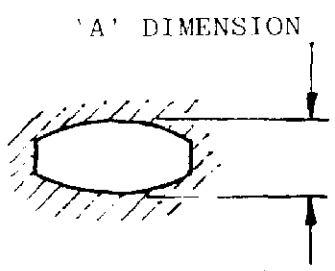
- a) Lubricate all pins, bearing surfaces and pivot points as necessary with any good grade S.A.E. No 20 Motor oil or equivalent. Inspect the tool regularly for missing parts e.g. retaining pins and circlips and replace accordingly.
- b) Inspect the tool for correct die closures using GO, NO-GO gauges listed in Fig 6.

Should any of the requirements in Paragraph 4 (b) not be met or damage i.e. chipping is found in the crimp area, return the tool to AMP Port Glasgow for repair.

NOTE:- DIES SHOULD BE BOTTOMED BUT NOT UNDER PRESSURE WHEN GAUGING. WHEN GAUGING 'G' DIMENSION INSERT INSULATION ADJUSTMENT PIN IN NO 1 POSITION.

CONDUCTOR CRIMP DIES

INSULATION SUPPORT DIES



TOOL NUMBER	'A' DIMENSION			'G' DIMENSION		
	GO	NO-GO	GAUGE P/N	GO	NO-GO	GAUGE P/N
525692	.169	.175	574915	.064	.084	575909-6

FIG 6