AMP of Great Britain Ltd.

A-MP* CRIMPING TOOL FOR CLOSED END SPLICES

CATALOG No. 576708

1103 GB	
RELEASED	7.4.83
REVISED	

1. The Tool shown in Figure 1 is used to crimp A-MP Closed End Splice No. 825036

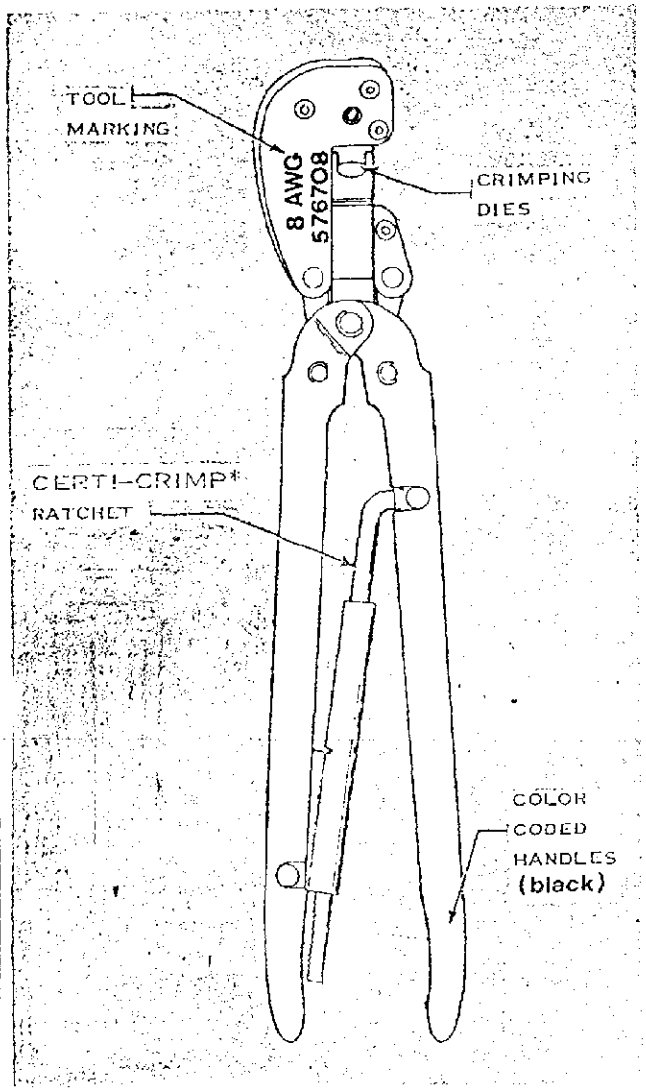

FIG. 1

2. WIRE STRIPPING AND CRIMPING PROCEDURE

(a) Strip Wire to dimensions shown in Figure 2.

(b) To open Crimping Jaws, close Handles until CERTI-CRIMP* Ratchet releases. Note that once Ratchet is engaged, Handles cannot be opened until they are fully closed.

(c) Insert stripped Wires into Splice Barrel.

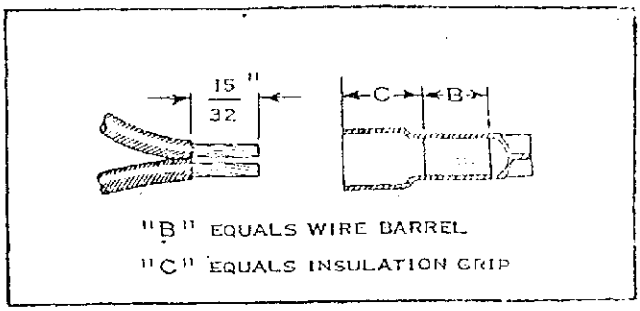

FIG. 2

(d) Place Splice, with Wires inserted, into Crimping Dies as shown in Figure 3.

(e) Hold Splice in place against Locator. Complete crimp by closing Handles until CERTI-CRIMP Ratchet releases.

(f) Handles will open automatically and crimped Splice may be removed from Crimping Dies.

3. MAINTENANCE

3.1 LUBRICATION

Keep all Pins, Pivot Points and Bearing Surfaces lubricated with a good grade S. A. E. No. 20 Motor Oil.

3.2 DIE CLOSURE INSPECTION

Every A-MP Hand Tool is inspected and tested for proper Die (Jaw) closure before being shipped from the factory.

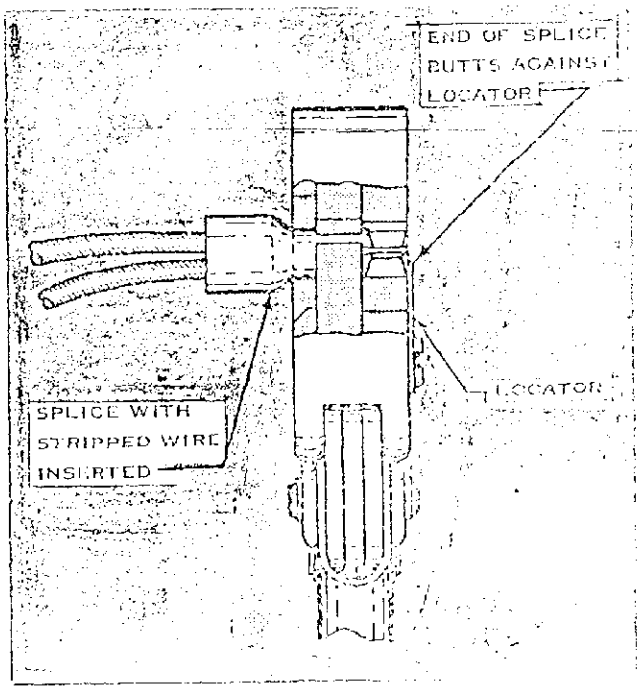

FIG. 3

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It is recommended, however, that an Inspection be performed periodically to measure the Tool Die closure and to check the CERTI-CRIMP Ratchet feature. This is necessary to assure that continued use of the Tool will result in the same dependable and uniform terminations for which the Tool was designed.

We recommend an initial frequency of Inspection of once a month. This frequency may be adjusted to suit your requirements through experience.

The frequency of an Inspection is dependent upon:

1. The care, amount of use, and handling of the Tool.
2. The type and size of the products crimped.
3. The degree of operator skill.
4. The presence of abnormal amounts of dust and dirt.
5. Your own established standards.

The Tool Die closure measurement is accomplished using a GO-NO GO Plug Gage. A suggested Plug Gage design is shown in Figure 4. The GO-NO GO dimensions of the Plug Gage for the Wire Barrel Crimping Dies are also listed in Figure 4. The following procedure is recommended for measuring the Tool Die closure.

(a) Remove traces of oil or dirt from Tool Crimping area and Plug Gage.

(b) Close Handles of Tool until Crimping Jaws are bottomed. Do not apply additional pressure to Tool Handles.

(c) Measure Tool Wire Barrel Crimping Die using the Plug Gage with Barrel Crimp dimensions given in Figure 4. Hold Gage in straight alignment with the Tool and carefully try to insert, without forcing, the GO element, and then the NO GO element. See Figure 5. The GO element must pass completely through the length of the crimping surface.

(d) The NO GO element may enter partially, but must not pass completely through the length of the crimping surface.

(e) If the Wire Barrel Dies meet the GO-NO GO Gage conditions, the Tool may be considered dimensionally correct.

(f) If you find that the Tool Crimping Dies do not conform with the GO-NO GO Gage conditions, contact your local AMP Field Representative.

3.3 CERTI-CRIMP RATCHET FEATURE

The CERTI-CRIMP Ratchet feature on A-MP Hand Tools should be checked to make certain that the Ratchet does not release prematurely allowing Dies to open before they have fully bottomed.

To check Ratchet feature:

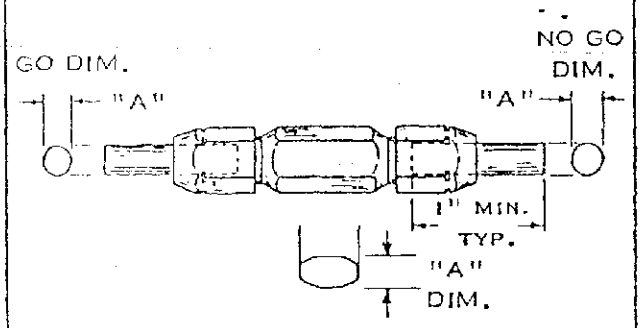
(a) Make a test crimp using the maximum Wire Load, i.e., the maximum number of wires permitted from the Wire Combination Chart for the Splice being used. When this crimp is made, squeeze Handles until the Ratchet is free, however, DO NOT RELAX PRESSURE ON TOOL HANDLES.

(b) If a .005 or smaller shim can be inserted between the bottoming surfaces of the Dies, the CERTI-CRIMP Ratchet is satisfactory.

(c) If the clearance between the bottoming surfaces of the Dies is greater than .005 the Dies are considered as not bottoming. Contact your local AMP Field Representative.

SUGGESTED PLUG GAGE DESIGN

BARREL CRIMP

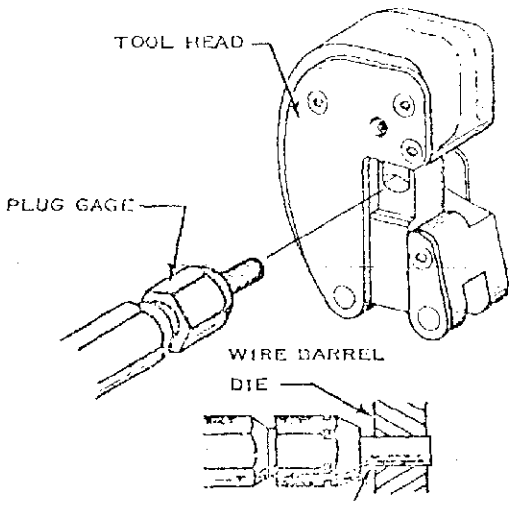


TOOL NO.	BARREL CRIMP DIMENSIONS "A" †	
	GO	NO GO
576708	.156	.162

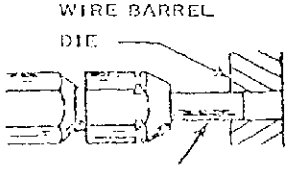
† PLUG GAGE DIMENSIONS APPLY WHEN TOOL IS BOTTOMED, BUT NOT UNDER PRESSURE.

FIG. 4

INSPECTION OF WIRE BARREL CRIMPING DIES WITH PLUG GAGE



"GO" GAGE MUST PASS COMPLETELY THROUGH THE CRIMPING SURFACE.



"NO GO" GAGE MAY ENTER PARTIALLY, BUT MUST NOT PASS COMPLETELY THROUGH THE LENGTH OF THE CRIMPING SURFACE.

FIG. 5