



A-MP ★ CRIMPING HEAD  
FOR  
FASTON ★ TERMINALS

**IS 7398**  
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REVISED

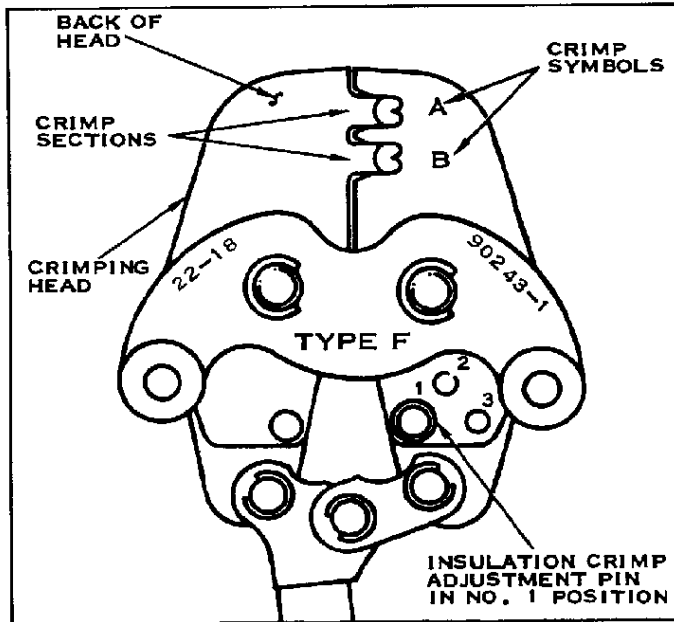


FIGURE 1

1. INTRODUCTION

This Crimping Head, when installed in the A-MP 69005 Pneumatic Hand Tool, is recommended for crimping the FASTON Terminals listed in Figure 2. Read these instructions and those packed with the Tool thoroughly before crimping terminals. The Tool must be bench-mounted.

2. IMPORTANT DATA

Before crimping terminals, check the following information in Figure 2:

WIRE SIZE & INSULATION SIZE - Be sure your wire and insulation are within range.

WIRE TYPE - Crimp stranded wire only.

TERMINAL NUMBER - When ordering FASTON Terminals for pneumatic hand tool application, order LOOSE PIECE Terminals.

CRIMP SECTION - The Head has two crimping sections to cover a large number of FASTON Terminals. Match the proper Crimp Section and Wire Size.

LOOSE PIECE WIRE SIZE	LOOSE PIECE INSULATION SIZE	WIRE TYPE	TERMINAL NUMBER		CRIMP SECTION	CRIMPING HEAD NUMBER	WIRE STRIP LENGTH
			LOOSE PIECE	STRIP			
22-18	.060-.100	STRANDED	42731-1	42640-1	A	90243-1	1/4"
			42731-2	42640-2			
			42731-3	42640-3			
				42860			
			60243-1	60169-1			
			60243-2	60169-2			
	.090-.130	STRANDED	41968	41771	B		
			60130-1	41771			
			60878-1	41771			
			41969	41772			
			60878-2	41772			
			42370-1	42286-1			
			60130-2	42286-1			
			42370-2	42286-2			
	60130-3	42286-3					
	60233-1	42510-1					
		42602					
	60358-2	42743-1					
	60358-1	42743-2					
		60316					

FIGURE 2

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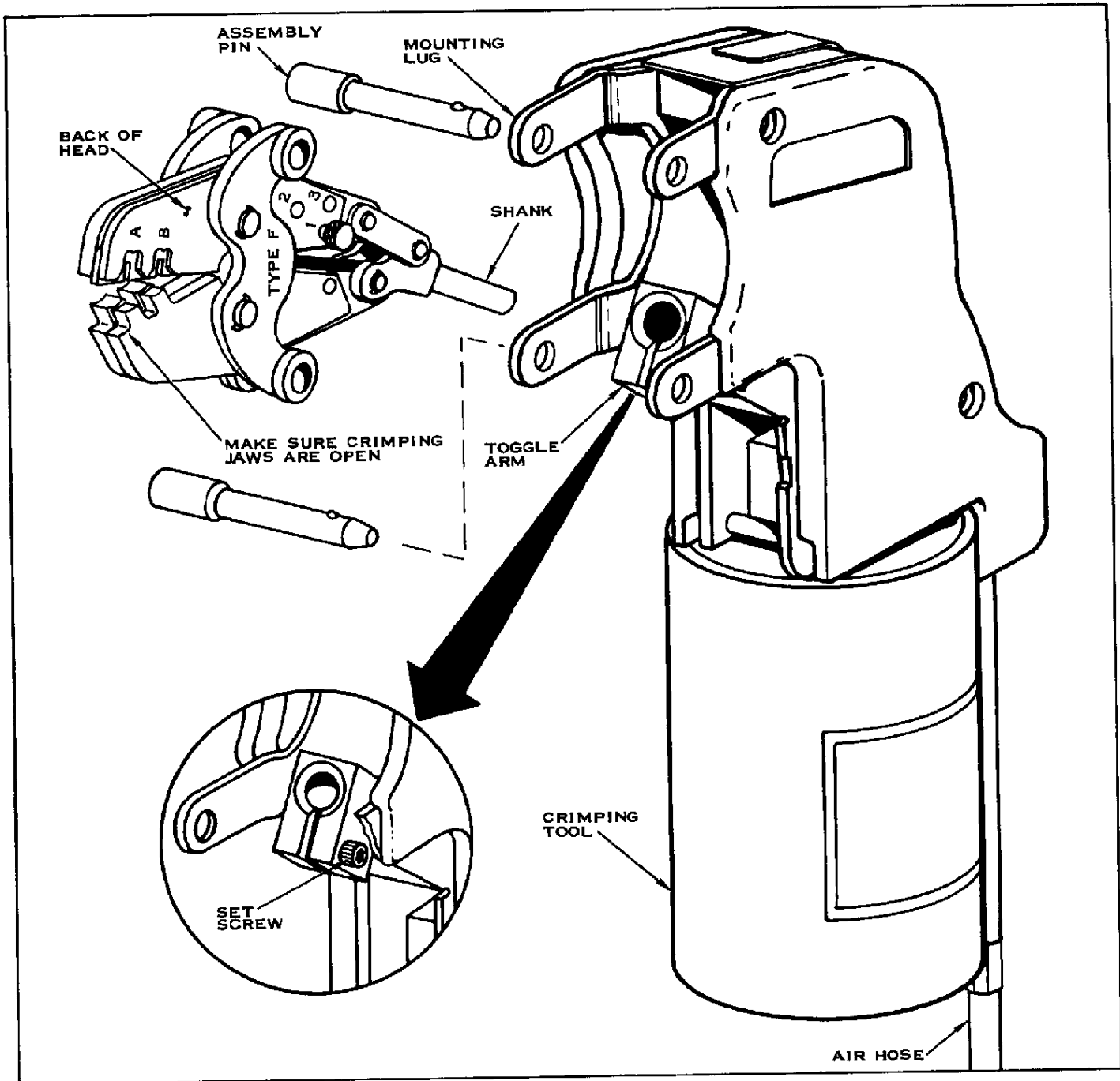


FIGURE 3

**WIRE STRIP LENGTH** - Strip your wire to the length shown. Do not crimp wire that has cut or nicked strands.

### 3. INSTALLING THE CRIMPING HEAD

**CAUTION**

Do not attach tool to air supply until crimping head is attached.

1. Remove the two Assembly Pins from the Mounting Lugs on the Tool. Figure 3.

2. Pull the Toggle Arm forward as shown in Figure 3, and loosen the Set Screw.

3. Make sure the Crimping Head Jaws are open. Then, insert the Crimping Head Shank into the Toggle Arm Hole as far as it will go. The Links of the Crimping Head must fit between the Tool's Mounting Lugs.

4. Tighten the Set Screw in the Toggle Arm.

5. Align the holes in the Links and Mounting Lugs, and insert the Assembly Pins. The Locking Beads on the Assembly Pins must pass through both Mounting Lugs. Figure 4.

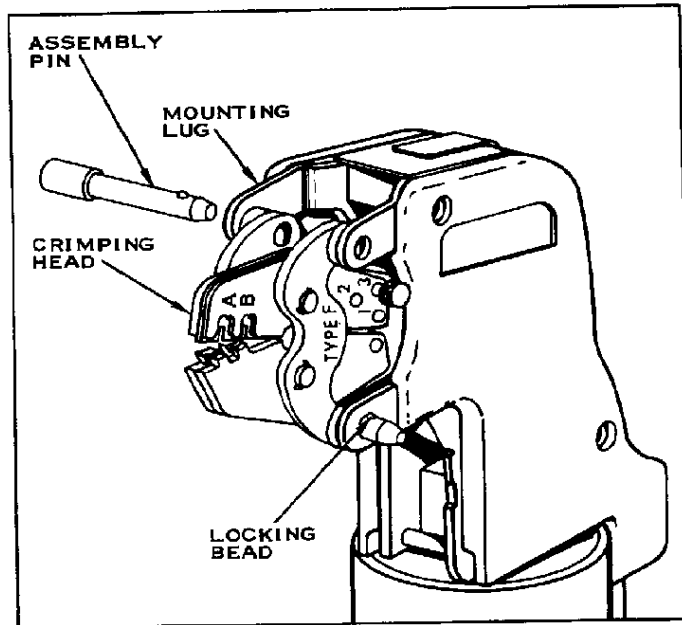


FIGURE 4

#### 4. CRIMPING PROCEDURE

Crimp a terminal as follows:

1. Attach the Pneumatic Hand Tool to the Air Supply.
2. Place the terminal into the proper Tool Crimp Section as shown in Figure 2. Make sure the Locator fits into the slot between the terminal's wire barrel and insulation barrel. Figure 5.
3. Hold the Terminal in place, and insert a stripped wire into the Terminal until the Wire Insulation butts against the Locator.
4. Depress the Operating Pedal, and hold it down until the crimping cycle is completed.
5. Release the Operating Pedal, and remove the crimped Terminal from the Crimping Jaws.

#### 5. INSULATION CRIMP ADJUSTMENT

The main purpose of the insulation support is to keep the bare wire from flexing against the edge of the wire crimp. The insulation barrel should be just tight enough to support the wire insulation.

Adjust the Insulation Support as follows:

1. Set the Insulation-Crimp Adjustment Pin in the No. 3 (loose) position. Figure 4.

2. Place a Terminal in the Crimping Jaws, and insert an unstripped wire into the Insulation Barrel.
3. Crimp the Terminal, and remove it from the Crimping Jaws.
4. Bend the wire back and forth one time. If the wire pulls out, place the Adjustment Pin in the No. 2 position. Repeat the procedure until you get the proper Insulation Crimp.

#### 6. REMOVING THE CRIMPING HEAD

1. Disconnect the Tool from the Air Supply.
2. Remove the two Assembly Pins from the Tool.
3. Loosen the Set Screw in the Toggle Arm, and pull the Crimping Head out of the Tool.

#### 7. MAINTENANCE

Lubricate all Pins, Pivot Points, and Bearing surfaces of the Crimping Head with any good S.A.E. No. 20 Motor Oil.

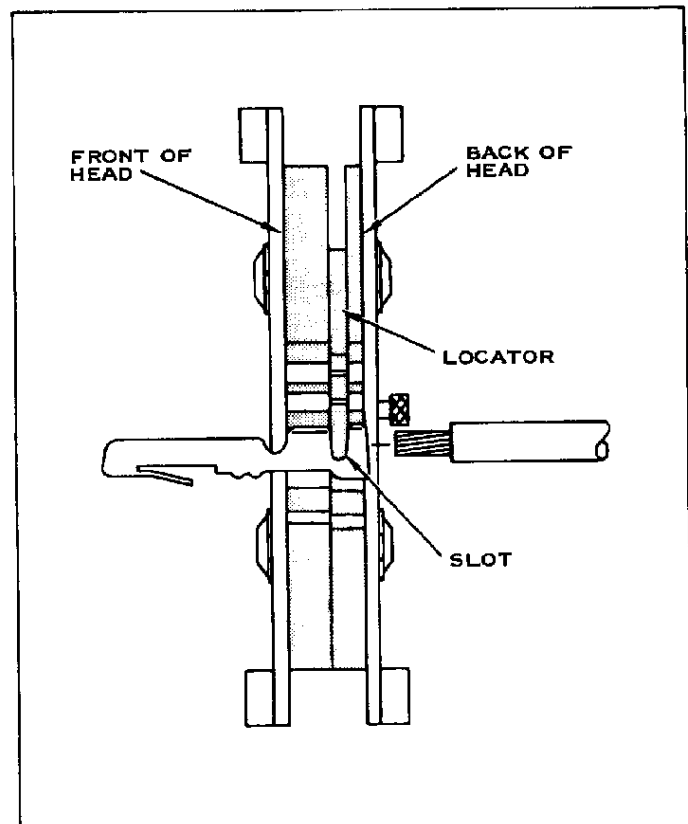


FIGURE 5