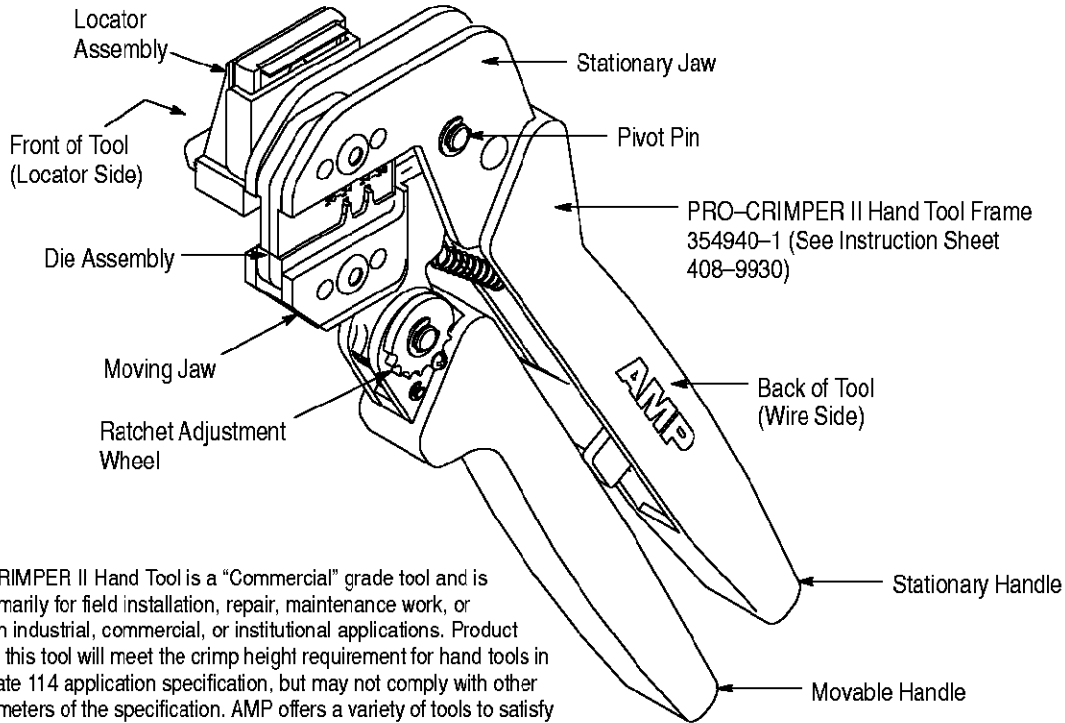


**PROPER USE GUIDELINES**

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.



The PRO-CRIMPER II Hand Tool is a "Commercial" grade tool and is designed primarily for field installation, repair, maintenance work, or prototyping in industrial, commercial, or institutional applications. Product crimped with this tool will meet the crimp height requirement for hand tools in the appropriate 114 application specification, but may not comply with other feature parameters of the specification. AMP offers a variety of tools to satisfy your performance requirements. For additional information, contact the Tooling Assistance Center at 1-800-722-1111.

DIE ASSEMBLY	LOCATOR ASSEMBLY†	PRODUCT FAMILY‡	WIRE		
			SIZE RANGE (AWG)	INSULATION DIAMETER (Max) (mm [in.])	STRIP LENGTH (mm [in.])
58448-3	1214310-1	AMPLIMITE* HDP-20 Connector Crimp Snap-In Contacts with Insulation Support	28-24	1.02 [.040]	2.54 [.100]
			24-20	1.52 [.060]	

† Supplied with die assembly, also available separately.

‡ Contact the Tooling Assistance Center at the number listed below for specific contact part numbers.

Figure 1

**1. INTRODUCTION**

AMP\* PRO-CRIMPER II Hand Tool Assembly 58448-2 consists of Die Assembly 58448-3 and PRO-CRIMPER II Hand Tool Frame 354940-1. The die assembly consists of crimping dies and a locator assembly. Read these instructions thoroughly before crimping any contacts.

**NOTE**

*Dimensions in this instruction sheet are in metric units [with U.S. customary units in brackets]. Figures are not drawn to scale.*

Reasons for reissue of this instruction sheet are provided in Section 10, REVISION SUMMARY.

**2. DESCRIPTION**

The tool features a tool frame with a stationary jaw and handle, moving jaw, moving handle, and adjustable ratchet that ensures full contact crimping. The tool frame holds a die assembly with two crimping chambers. See Figure 1.

The die assembly features a wire anvil, insulation anvil, wire crimper, and insulation crimper.

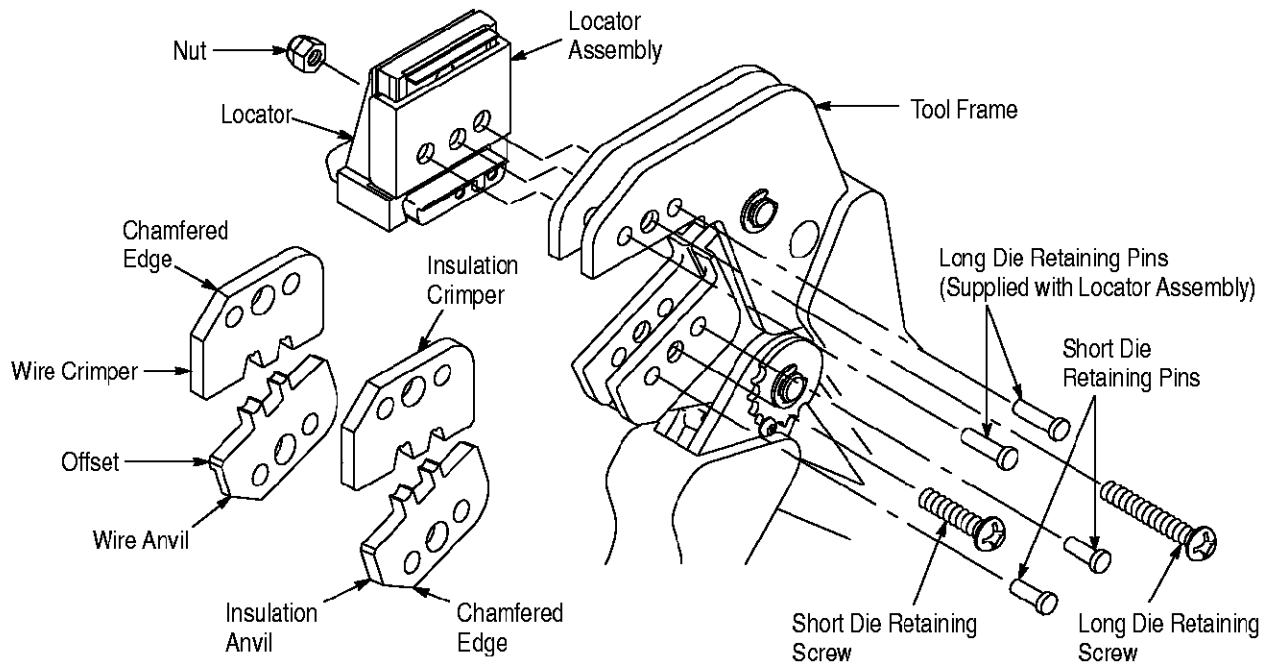


Figure 2

Die retaining pins and die retaining screws are used to position and secure the dies in the tool frame.

Attached to the outside of the frame is a locator assembly, which contains a locator and contact retainer. A nut is used on the upper die retaining screw to hold the locator assembly in place.

### 3. INSTALLATION AND REMOVAL OF DIE ASSEMBLY AND LOCATOR ASSEMBLY

1. Open the tool handles, and remove the two die retaining screws from the tool jaws.
2. Place the wire anvil and insulation anvil so that the chamfered sides and marked surfaces face outward, when mounted in the moving jaw of the tool frame.
3. Insert the two short die retaining pins through the tool frame and into the anvils.
4. Insert the short die retaining screw through the jaw and through both anvil dies, and tighten the screw just enough to hold the dies in place. Do *not* tighten the screw completely at this time.
5. Place the wire crimper and insulation crimper so that their chamfered sides and their marked surfaces face outward, when mounted in the stationary jaw of the tool frame.
6. Insert the two long die retaining pins (supplied with the locator assembly) through the tool frame and into the crimpers.

7. Insert the long die retaining screw through the jaw and through both crimper dies, and tighten the screw just enough to hold the dies in place. Do *not* tighten the screw completely at this time.

8. Carefully close the tool handles, making sure that the anvils and crimpers align properly. Continue closing the tool handles until the ratchet in the tool frame has engaged sufficiently to hold the anvils and crimpers in place, then tighten both die retaining screws.

9. Remove the pin from the center hole in the locator assembly. Place the locator assembly over the end of the long die retaining screw and long die retaining pins. Position the locator assembly against the side of the tool jaw.

10. Place the nut onto the end of the long screw and tighten the nut enough to hold the locator assembly in place, while still allowing the locator to slide up and down.

11. To disassemble, close the tool handles until the ratchet releases, remove the nut, the locator assembly, the two die retaining screws, and the four die retaining pins, and slide the anvils and crimpers out of the tool jaws.

### 4. CRIMPING PROCEDURE

#### NOTE

*This tool is provided with a crimp adjustment feature. Initially, the crimp height should be verified as specified in Section 5, CRIMP HEIGHT INSPECTION, and Section 6, CRIMP HEIGHT ADJUSTMENT, before using the tool to crimp desired contacts.*

Refer to Figure 1, and select wire of the specified size and insulation diameter. Strip the wire to the length indicated, taking care not to nick or cut wire strands. Select an applicable contact and identify the appropriate crimping chamber according to the wire size markings on the tool.

Refer to Figure 3, and proceed as follows:

1. Hold the tool so that the front (locator side) is facing you. Squeeze tool handles together and allow them to open fully.
2. Insert the contact—mating end first—into the hole in the locator which corresponds with the appropriate crimping chamber. Make sure that the open “U” of the wire barrel and insulation barrel face the stationary jaw.

**CAUTION**

*Do NOT attempt to close the tool handles when locator contact retainer is between the dies. Damage to the tool jaws or locator may result.*

3. Slide the locator contact retainer out from between the dies (spring tension will pull the locator down). Make sure that the wire stop enters the contact wire stop slot between the wire barrel and contact shoulder. Release contact retainer.

**CAUTION**

*Make sure that both sides of the contact insulation barrel are started evenly into the crimping chamber. Do NOT attempt to crimp an improperly positioned contact.*

4. Hold the contact in position, and squeeze the tool handles together until ratchet engages

sufficiently to hold the contact in position. Do NOT deform insulation barrel or wire barrel.

5. Insert stripped wire into contact insulation and wire barrels until it is butted against the wire stop, as shown in Figure 3.

6. Holding the wire in place, squeeze tool handles together until ratchet releases. Allow tool handles to open and remove crimped contact.

**NOTE**

*The crimped contact may stick in the crimping area, but can be removed by pushing downward on the top of the locator (see Figure 3).*

7. Check the contact crimp height as described in Section 5, CRIMP HEIGHT INSPECTION. If necessary, adjust the crimp height as described in Section 6, CRIMP HEIGHT ADJUSTMENT.

**5. CRIMP HEIGHT INSPECTION**

This inspection requires the use of a micrometer with a modified anvil. It is recommended that the modified micrometer (Crimp Height Comparator RS-1019-5LP) which may be purchased from:

Shearer Industrial Supply Co.	or	VALCO
20 North Penn Street		1410 Stonewood Drive
York, PA 17401-1014		Bethlehem, PA 18017-3527

Proceed as follows:

1. Refer to Figure 4 and select the *maximum* size wire for the crimping chamber.
2. Refer to Section 3, CRIMPING PROCEDURE, and crimp the contact accordingly.

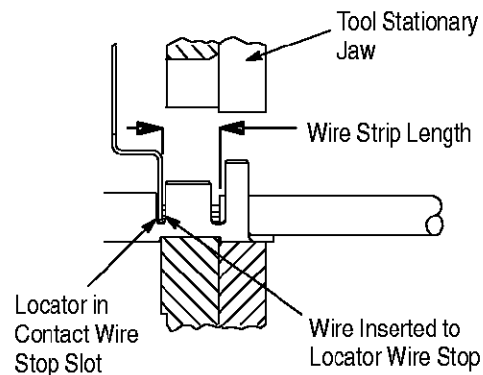
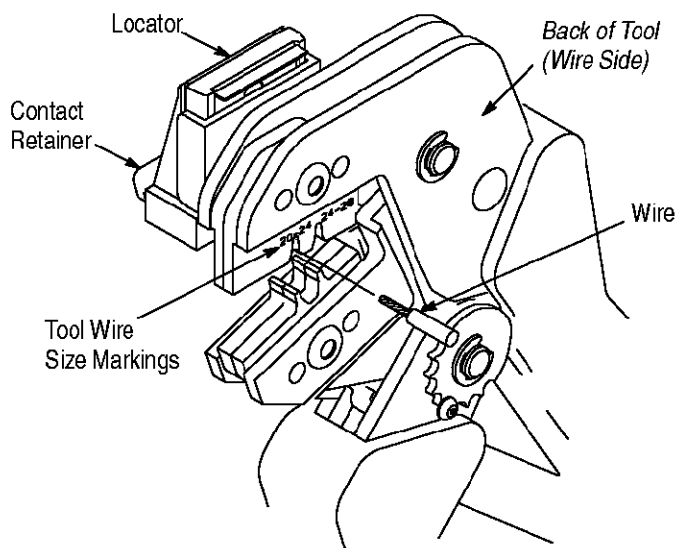
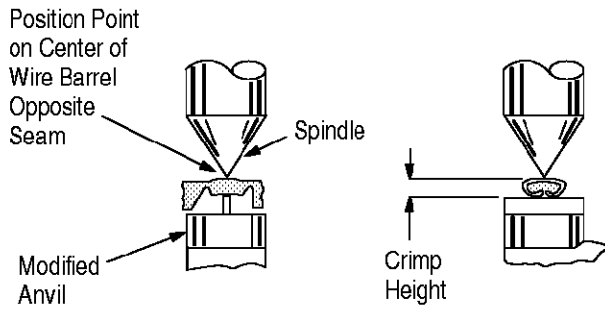


Figure 3



WIRE SIZE (AWG) (Max)	CRIMP HEIGHT DIMENSION ±0.05 mm [±.002 in.]
24	0.724 [.0285]
20	0.749 [.0295]

Figure 4

3. Using a crimp height comparator, measure the wire barrel crimp height as shown in Figure 4. If the crimp height conforms to that shown, the tool is considered dimensionally correct. If not, the tool must be adjusted. Refer to Section 6, CRIMP HEIGHT ADJUSTMENT.

**6. CRIMP HEIGHT ADJUSTMENT** (Figure 5)

1. Remove the lock screw from the ratchet adjustment wheel.
2. With a screwdriver, adjust the ratchet wheel from the locator side of the tool.
3. Observe the ratchet adjustment wheel. If a tighter crimp is required, rotate the adjustment wheel *counterclockwise* to a higher-numbered setting. If a looser crimp is required, rotate the adjustment wheel *clockwise* to a lower-numbered setting.

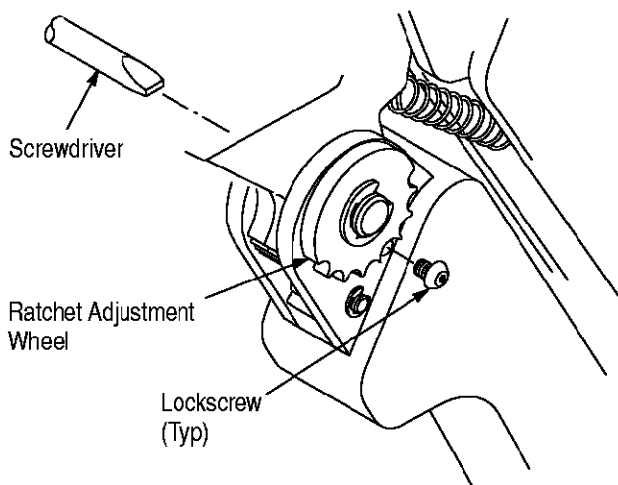


Figure 5

4. Re-assemble the lock screw.
5. Make a sample crimp and measure the crimp height. If the dimension is unacceptable, continue to adjust the ratchet, and again measure a sample crimp.

**7. MAINTENANCE**

Ensure that the tool and dies are clean by wiping them with a clean, soft cloth. Remove any debris with a clean, soft brush. Do not use objects that could damage the tool. When not in use, keep handles closed to prevent objects from becoming lodged in the crimping dies, and store in a clean, dry area.

**8. VISUAL INSPECTION**

The crimping dies should be inspected on a regular basis to ensure that they have not become worn or damaged. Inspect the crimping chambers for flattened, chipped, worn, or broken areas. If damage or abnormal wear is evident, the tool must be replaced. See Section 9, REPLACEMENT.

**9. REPLACEMENT**

Customer-replaceable parts are shown in Figure 1. Available separately, PRO-CRIMPER II Repair Kit 679221-1 includes a replacement nut and a variety of pins, rings, screws, and springs. If the dies are damaged or worn excessively, they must be replaced. Order repair kit and replaceable parts through your representative, or call 1-800-526-5142, or send a facsimile of your purchase order to 717-986-7605, or write to:

CUSTOMER SERVICE (38-35)  
AMP INCORPORATED  
PO BOX 3608  
HARRISBURG, PA 17105-3608

**10. REVISION SUMMARY**

Revisions to this instruction sheet per EC 0990-1380-99 include:

- Updated document to corporate requirements
- Replaced Locator Assembly 58516-1 with 1214310-1
- Modified Section 3
- Removed previous Section 4, and modified new Section 4, Steps 2 and 3
- Modified Section 6, Step 5