CRIMPING HEADS P/N'S 752858-1, 752859-1
USED ON BATTERY-POWERED HAND CRIMPING TOOL
P/N 752861-2

1. INTRODUCTION:

This instruction sheet covers procedure of crimping operation, inspection and maintenance of AMP crimping heads P/N's 752858-1 and 752859-1, to be used on AMP battery-powered hand crimping tool, P/N 752861-2.

The selection chart for terminals versus hand tools with proper crimping dies, Table 1, assists you to determine which wire and tool to use for operation.

Read this instruction sheet carefully, before you start operation.

PART NUMBER	NEST SYMBOL	TERMINAL STRIP NO.	TERMINAL L.P. NO.	WIRE RANGE AWG [mm2]	INSUL RANGE (mm)	WIRE STRIP LENGTH (mm)
752858-1	A	42100	42238	18 [0.75-0.85]	2.2-3.1	5.1-6.1
		170092	170108			
		42100	42238	16 [1.25-1.42]		
		170092	170108			
	B	170151	170153	14 [2.0-2.27]		
		42098	42241	18-16 [0.75-1.42]		
		42741	42806			
		170151	170153			
		42100	42238	14 [2.0-2.27]		
		170092	170108			
752859-1	24-22	170043	170048	24-22 [0.2-0.35]	1.4-2.6	3.5-4.2
	20	170043	170048	20 [0.5-0.56]		

Table 1

2. CRIMPING PROCEDURE:

Refer to Paragraph 4, Page 3 of 4 of Instruction Sheet, IS-166J, for crimping procedure by using battery-powered hand crimping tool. See Fig. 1 for correct placement of contact in crimping dies.

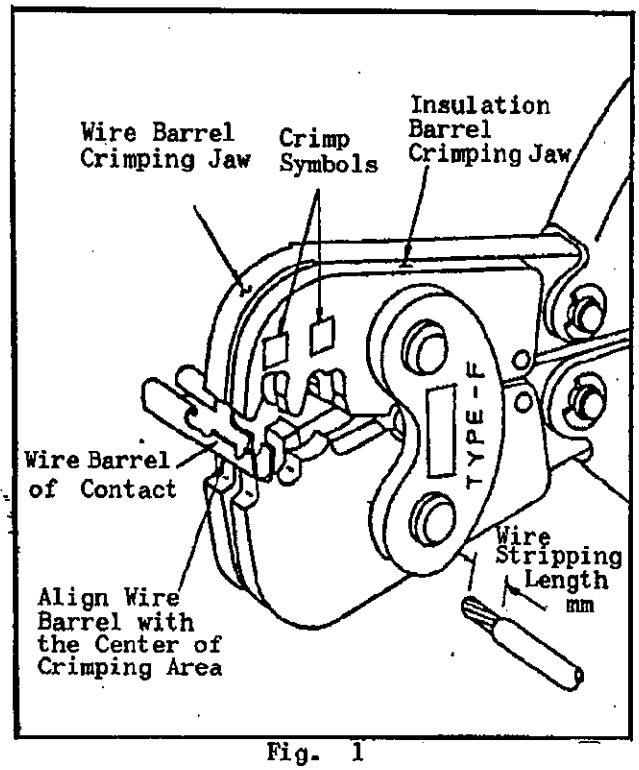
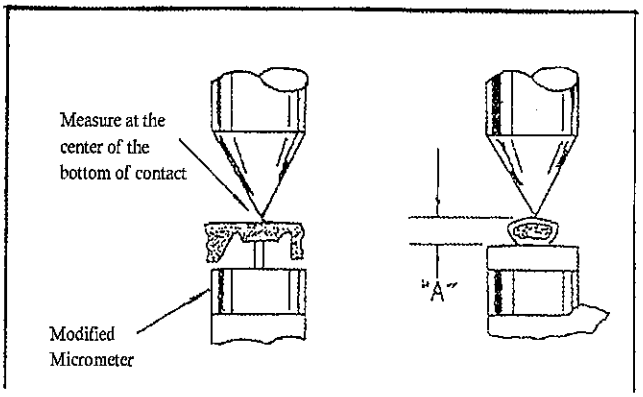


Fig. 1

3. INSPECTION OF WIRE BARREL CRIMP HEIGHT:

For checking crimp height of wire barrel, a micrometer with modified anvil is used as shown in Fig. 2. Modification of micrometer is usually difficult and costly It is recommended that customers would purchase the micrometer modfied by AMP-Japan. The modification drawing can be supplied to the customer freely upon request. Contact AMP-Japan if any of the users would try to modify by in-house facilities.

Measure the crimp height in the manner shown in Fig. 2. And the obtained value conforms to the listing of Fig. 2, the wire crimp is considered acceptable.



PART NUMBER	NEST SYMBOL	TERMINAL STRIP NO.	TERMINAL L.P. NO.	WIRE RANGE AWG [mm2]	TERMINAL CRIMP HEIGHT (mm)
752858-1	A	42100	42238	18 [0.75-0.85]	1.12-1.28
		170092	170108		
		42100	42238	16 [1.25-1.42]	1.12-1.40
		170092	170108		
	B	170151	170153	14 [2.0-2.27]	1.45-1.84
		42098	42241	18-16 [0.75-1.42]	1.45-1.72
		42741	42806		
		170151	170153		
		42100	42238	14 [2.0-2.27]	
		170092	170108		
752859-1	24-22	170043	170048	24-22 [0.2-0.35]	0.81-0.97
	20	170043	170048	20 [0.5-0.56]	0.89-1.16

Fig. 2

4. PERIODIC INSPECTION:

Regular inspection should be performed by the operator periodically, once every 500 cycles of crimping approximately.
The checking should be visually performed to see the following points:

1) Refer to Paragraph 3.1, Page 2 of Instruction Sheet, IS-169J, for checking mounting hole distance of crimping head, and measure the distance of the holes.

2) Check to see if any abnormalities such as chip off of die edge, crack, damages and breakage took place in criping dies.

3) Confirm if all the component parts including retaining pins and rings are all in attached places. If any of them is missing, it must be placed in with new parts.

5. REPAIR:

As a result of crimp height inspection and visual inpection of crimping dies, if any abnormalities are found, return the tool to AMP factory or sales representatives of your area with detailed descriptions of malfuction or problem you have found.