

AMP* DOUBLE ACTION HAND TOOL P/N 752873-1
 FOR CRIMPING 250 SERIES POSITIVE LOCK
 RECEPTACLE CONTACT FOR AUTOMOBILES
 INSTRUCTION SHEET

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1. INTRODUCTION:

AMP* Double Action Hand Tool, P/N 752873-1 has been designed to crimp AMP* 250 Series Positive Lock Receptacle Contact for Automobiles on the wires of the sizes specified in Table 1 below. Contacts to be crimped by this tool should be purchased from AMP in loose piece form. Read this instruction sheet carefully, before you start crimping.

2. PREPARATION FOR CRIMPING:

- Correct contact numbers vs. wires to be crimped should be selected properly by referring to Table 1. Confirm contact part number which is marked on packaging.
- Wire end must be stripped neatly to a length specified in Table 1. When stripping, care must be taken not to nick, cut and damage the strands. If defective wires are crimped, reliability of termination deteriorates greatly.
- Inside the tool head, two sets of crimping dies are provided, where crimp symbols (A or B) are marked on to indicate proper selection of dies. (See Fig. 1.)

To obtain reliable wire termination, correct selection of contact, wire size and crimping dies is very important.

3. CRIMPING PROCEDURE:

- This hand tool features AMP* CERTI-CRIMP* Ratchet to regulate handle pressure. This ratchet assures full crimping of the contact. Once this ratchet is engaged, it will not release until the tool handles have been fully closed.

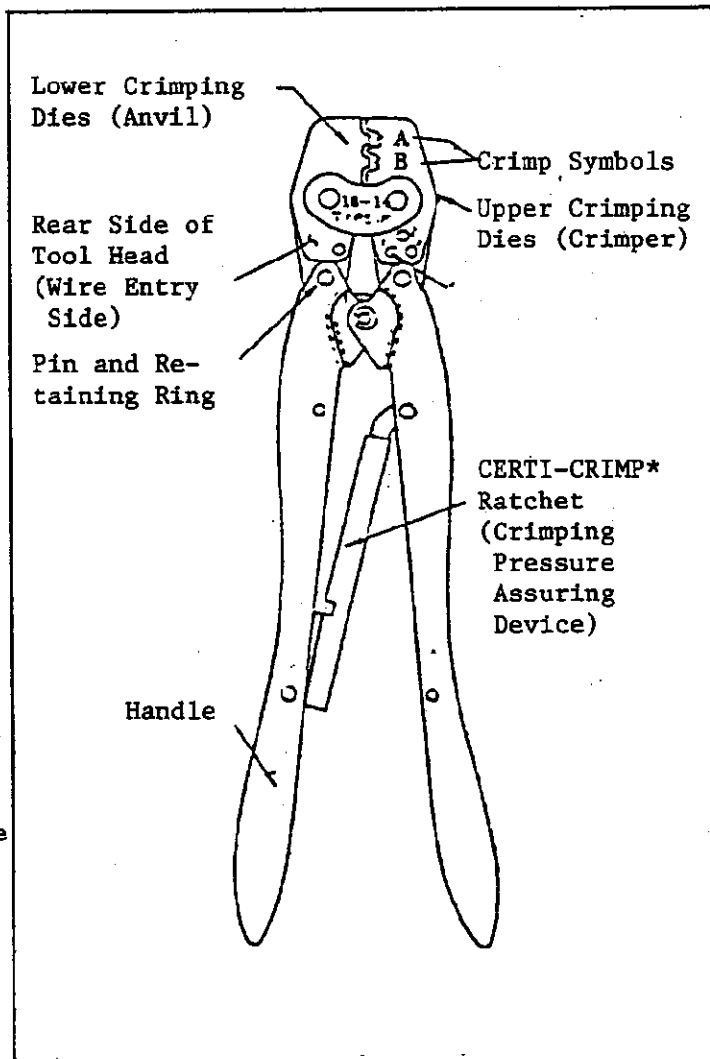


FIG. 1

Crimp Symbols	Contact Part Number		Wire Size mm ² (AWG)	Insulation Diameter (mm)	Insulation Stripping Length (mm)	Wire Barrel Crimp Height (mm)
	Strip Form	Loose Piece				
A	—//	170455	0.75-1.38 (#18-#16)	2.2-3.4	4.7 ± 0.5	1.36 - 1.51
B	—//	170455	2.00-2.27 (#14)	3.0-3.4	4.7 ± 0.5	1.55 - 1.88

Table 1

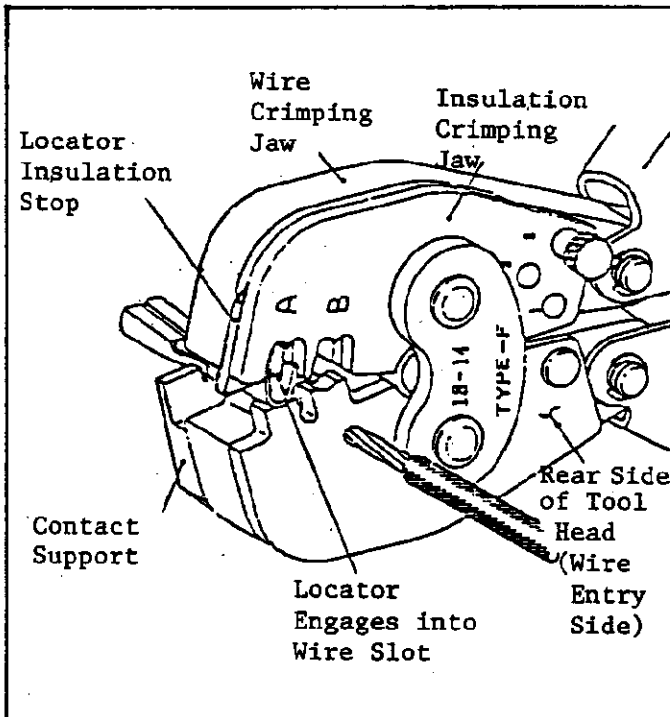


FIG. 2

- b) To open tool handles, close them to the bottom with sufficient pressure, until the ratchet releases. When the ratchet releases, a small clicking sound is heard inside the ratchet housing. Handles can be opened automatically by spring action.
- c) Hold the tool in hands with the rear side of tool facing to you. Then, insert the contact between appropriate crimping dies from front side of tool with insulation support end of contact first, until locator of tool under crimper seats into locator slot between insulation barrel and wire barrel. Then, close the handles lightly enough to retain contact in position, and hold them halfway in crimping stroke. Do not DEFORM contact in this step of procedure.
- d) Insert stripped end of wire into wire barrel of contact until it bottoms on locator insulation stop at the edge of stripped insulation edge. This is where the wire is placed correctly on the contact.

- e) Hold the wire and contact in place, close the handles as far as they go and apply pressure on them until the ratchet releases.
- f) When the ratchet releases, handles will open automatically. Then, remove wire-crimped contact from the tool.

4. MAINTENANCE:

To maintain reliable performance of tool for long time, proper care for maintenance should be taken as described below.

- a) Remove dust, moisture and other contaminants with a clean brush or lint-free soft cloth.
- b) Never handle roughly, such as throwing onto rigid floor or striking things with like a hammer.
- c) Do not attempt crimping wires and contacts other than specified.
- d) When not in use, close handles and keep in dry and clean place.
- e) Inspect periodically if all pins and retaining rings are set in place. If missing of such parts is found, replace with new one.
- f) Make certain all pins, pivot points and bearing surfaces are protected with a thin coat of oil. If necessary, lubricate with any good S.A.E. No. 20 Motor Oil or equivalent. Do not oil excessively.
- g) For parts replacement other than indicated, return the tool to AMP-Japan factory.

5. ADJUSTMENT OF INSULATION CRIMPING HEIGHT:

Adjust the insulation crimping height by moving the adjusting pin. To determine an adequate height, insert unstripped wire into the crimping dies, and crimp with the pin set to position "3" (large). Twist the wire at this terminal. If it slips, change the pin to "2" hole (medium), and crimp. Repeat this to "1" hole (small). Then, an adequate position will be found which holds the wire firmly without demaging the insulation.