

AMP CRIMPING HEADS P/N'S 752853-1, 752854-1
FOR CRIMPING MATE-N-LOK* CONNECTOR CONTACTS
USED ON BATTERY-POWERED HAND CRIMPING TOOL

INSTRUCTION SHEET

IS - 184J	
Released	3-8-82
Revised	2-21-91
RFA-1399	

1. INTRODUCTION:

This instruction sheet covers procedure of crimping operation, inspection and maintenance of AMP Crimping Heads P/N's 752853-1 and 752854-1, to be used on AMP battery-powered hand crimping tool. The selection chart for contacts 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.

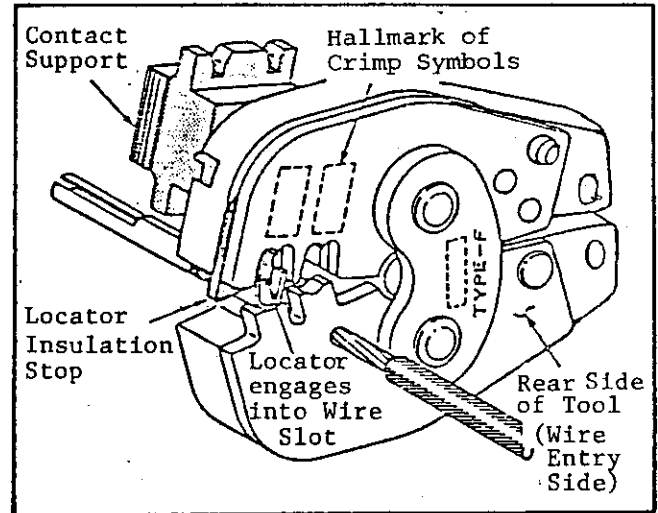


Fig. 2

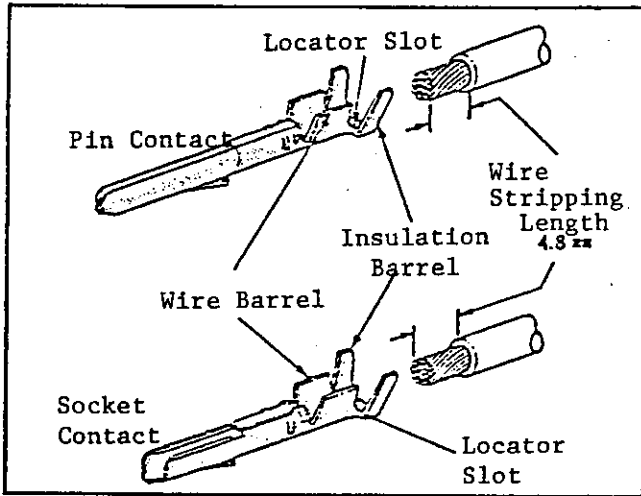


Fig. 1

2. CRIMPING PROCEDURE:

- 1) See Table 1 and confirm the correct combination of wire, contact and crimping dies.
- 2) Determine the direction of contact support according to the kind of contact (pin contact and socket contact). (When turning it, lift it up slightly first and then, turn it 180° and confirm that it is firmly fitted into slot.)

Crimping Head Number	Crimp Symbols	Contact Number				Wire Size (mm ²)	Insulation Diameter (mm)	Wire Stripping Length (mm)
		Loose Piece		Strip Form(Ref.)				
		Pin	Socket	Pin	Socket			
752853-1	A	60618	60617 61473 61602 170148 172760	61116 60511	61115 60510 61314 60964 170147 172759	0.75-0.89	1.52-2.54	4.8
	B	60618	60617 61473 61602 170148 172760	61116 60511	61115 60510 61314 60964 170147 172759	0.2 -0.56	1.52-2.54	4.8
752854-1	20-14	60620	60619 170121	61118 60528	61117 60527 170120	0.5 -2.27	2.54-3.3	4.8
	15-14	60616	60615	60497	60496	0.75+1.25 0.75x2	less than 3.0	4.8

Table 1

- 3) Hold the contact with crimping dies in position where contact's locator slot can be inserted into locator-insulation stop, as shown in Fig. 2
- 4) Insert a properly stripped wire through the window of locator-insulation stop into contact wire barrel. The proper position is where the wire's insulation butts against the locator-insulation stop.
- 5) Refer to Paragraph 4, Page 3 of 4 of Instruction Sheet, IS-166J, for crimping procedure by using battery-powered hand crimping tool.

3. ADJUSTMENT OF INSULATION CRIMP HEIGHT:

This crimping dies is capable of adjusting the insulation crimp height in three settings. Use No. 3 slot of adjustment pin for large insulation wire, No. 2 for medium insulation wire and No. 1 for small insulation wire.

4. INSPECTION OF WIRE BARREL CRIMP HEIGHT:
For checking crimp height of wire barrel, a micrometer with modified anvil is used as shown in Fig. 3. Modification of micrometer is usually difficult and costly. It is recommended that customers would purchase the micrometer modified 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. 3. And the obtained value conforms to the listing of Fig. 3, the wire crimp is considered acceptable.

5. 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.

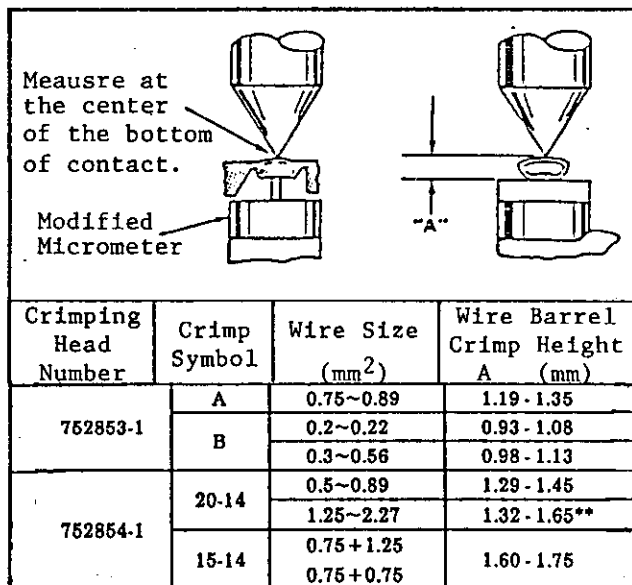


Fig. 3

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

6. REPAIR:

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

Applicable Application Specification:

Use application specification for control of crimped condition of contacts.

114-1012, 114-5075

Handle Pressure Control Data:

The minimum required handle pressure to achieve normal hand tool crimping is shown below.

For checking and control of normal hand tool handle pressure, refer to Users' Hand Tool Control Guide.

Tool Number	Handle Pressure (Min.)
752853-1	25 kg
752854-1	34 kg