



AMP INCORPORATED
HARRISBURG, PENNA.

A-MP* MULTIPLE-WIRE
POST-INSULATED
STRATO-THERM*
SPLICE CAPS

IS 1499

RELEASED 8-29-62

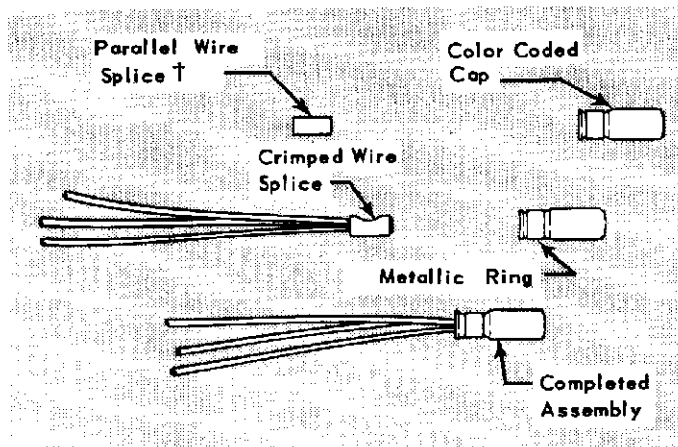
REVISED 7-12-66

SPLICE WIRE SIZE	WIRE STRIPPING LENGTH		SPLICE PART NO.	SPLICE CRIMPING TOOL	INSULATING CAP NO.	MAX. INSULATION DIAMETER	CAP CRIMPING TOOL
	Min.	Max.		Hand Tool			Hand Tool
22-16	$\frac{19}{64}$	$\frac{21}{64}$	322326	46447	329685 (Red)	.135	69308-1
16-14	$\frac{19}{64}$	$\frac{21}{64}$	322347	46447	329686 (Blue)	.160	69309-1
					329687 (Yellow)	.210	69296-1
12-10	$\frac{11}{32}$	$\frac{13}{32}$	323672	46447	329688 (Red)	.255	69322-1
					329688 (Red)	.300	59498
8	$\frac{3}{8}$	$\frac{13}{32}$	2-34318-1	69355			

Fig. 1

The Tools listed in Figure 1 are used to crimp A-MP Post-Insulating Caps onto A-MP Multiple-Wire Strato-Therm Splices. Refer to Figure 1 to select the proper Tool, Splice, Cap and Wire Strip Length for the Assembly to be crimped.

- (i) Complete crimp by closing Handles until Certi-Crimp Ratchet releases.
- (j) Open Tool Handles and remove crimped assembly.



† High Temperature or Heat Resistant
Fig. 2

1. HAND TOOL CRIMPING PROCEDURE - WIRE SIZE 22-16 THRU 12-10

- (a) Strip Wires to dimensions shown in Figure 1.
- (b) Insert Stripped Wires into Splice.
- (c) Open Tool Handles by closing them until the Certi-Crimp Ratchet releases. Note that once Ratchet is engaged, Handles cannot be opened until they are fully closed.
- (d) Center Splice in Barrel Crimping Nest of Tool as shown in Figure 4.
- (e) Complete crimp by closing the Handles until Certi-Crimp Ratchet releases.
- (f) Open Tool Handles and remove crimped Splice.
- (g) Insert crimped Splice into Insulating Cap to maximum depth. See Figure 2.
- (h) Place Metallic Ring in Insulation Crimping Nest as shown in Figure 6.

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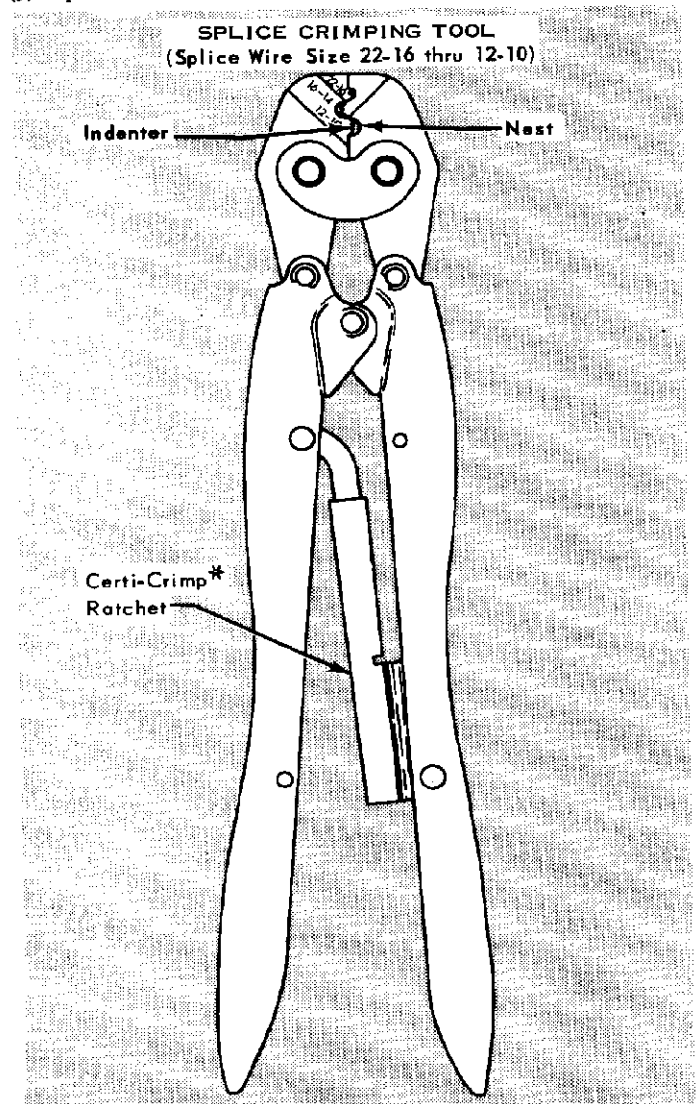


Fig. 3

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2. HAND TOOL CRIMPING PROCEDURE - WIRE SIZE 8

- (a) Strip Wires to dimensions shown in Figure 1.
- (b) Insert Stripped Wire into Splice.
- (c) Open Tool Handles by closing them until Certi-Crimp Ratchet, shown in Figure 7, releases. Note that once Ratchet is engaged, Handles cannot be opened until they are fully closed.
- (d) Center Splice in Barrel Crimping Nest of Upper Die. See Figure 8.
- (e) Hold Wires in place and complete crimp by closing Handles until Certi-Crimp Ratchet releases.
- (f) Open Tool Handles and remove crimped Splice.
- (g) Insert crimped Splice into Insulating Cap to maximum depth.
- (h) Center Metallic Ring in Crimping Die of Hand Tool.

NOTE: Use Tool No. 69322-1, shown in Figure 9, to crimp Cap containing Splice having a maximum Insulation Diameter of .255. Place Cap in Tool as shown in Figure 6.

Use Tool No. 59498, shown in Figure 10, if maximum Insulation Diameter is .300. Place Cap in Tool as shown in Figure 11.

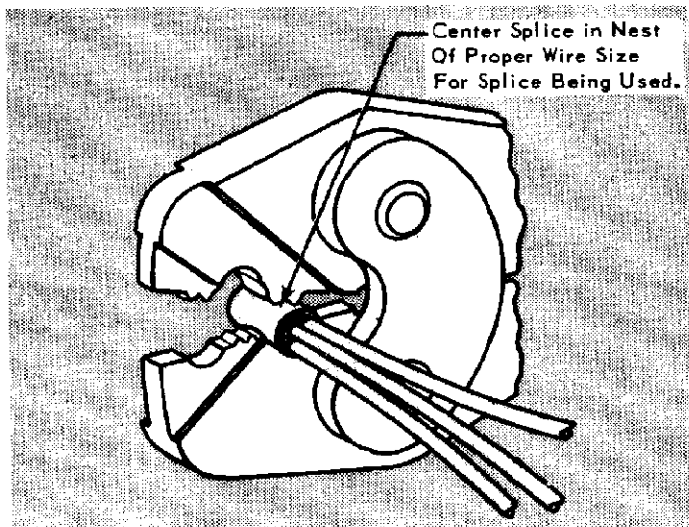


Fig. 4

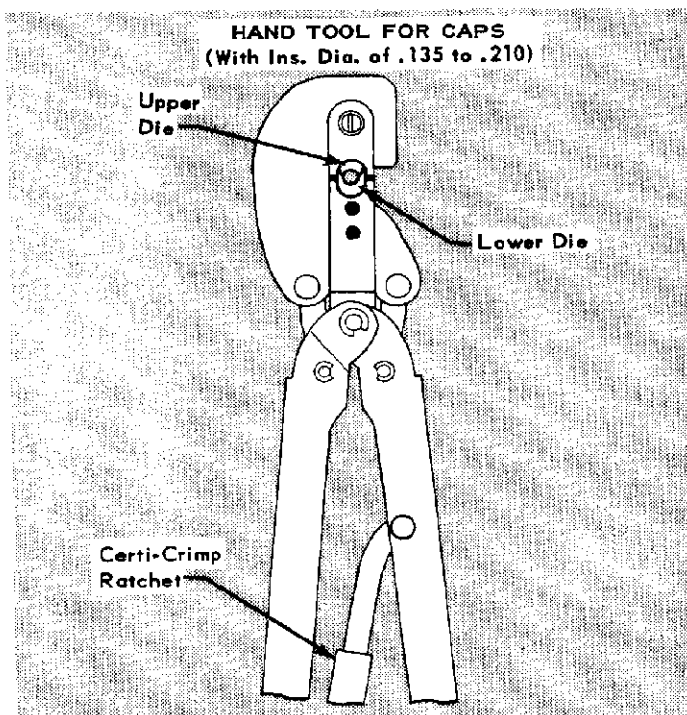


Fig. 5

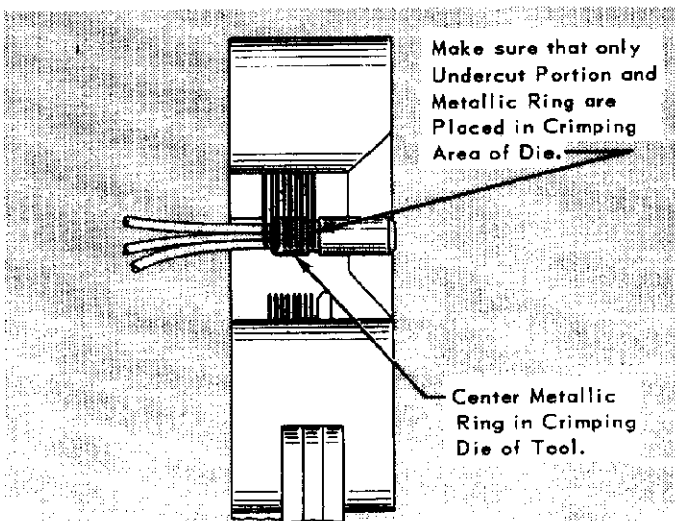


Fig. 6

HAND TOOL NO. 69355
(Splice Wire Size No. 8)

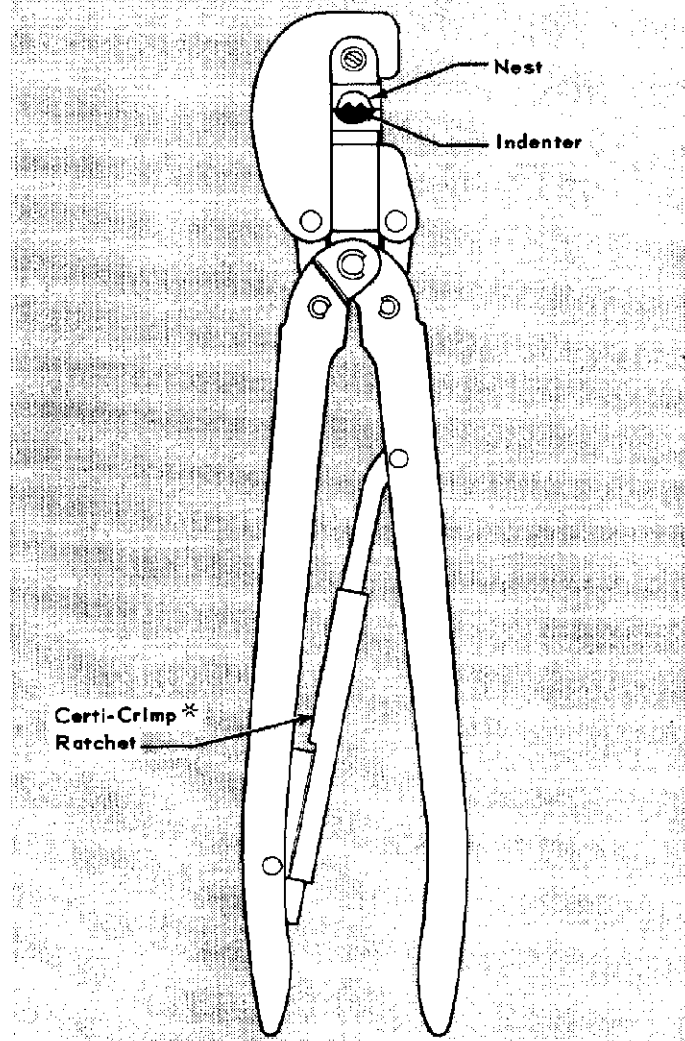


Fig. 7

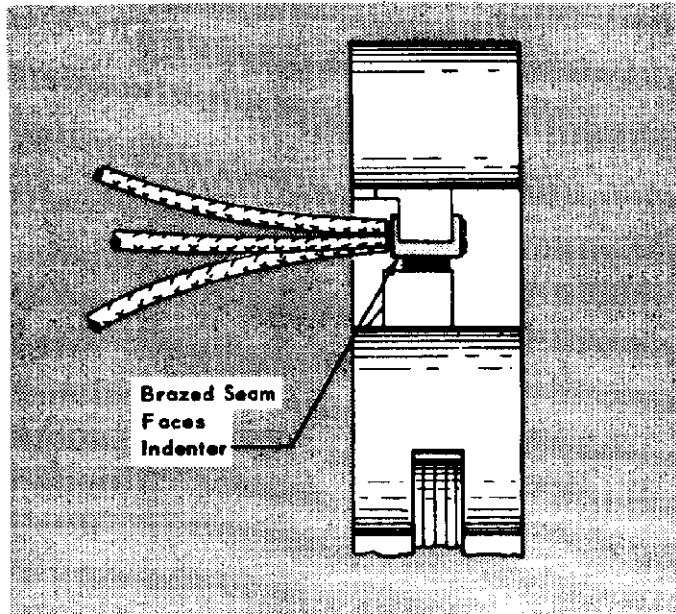


Fig. 8

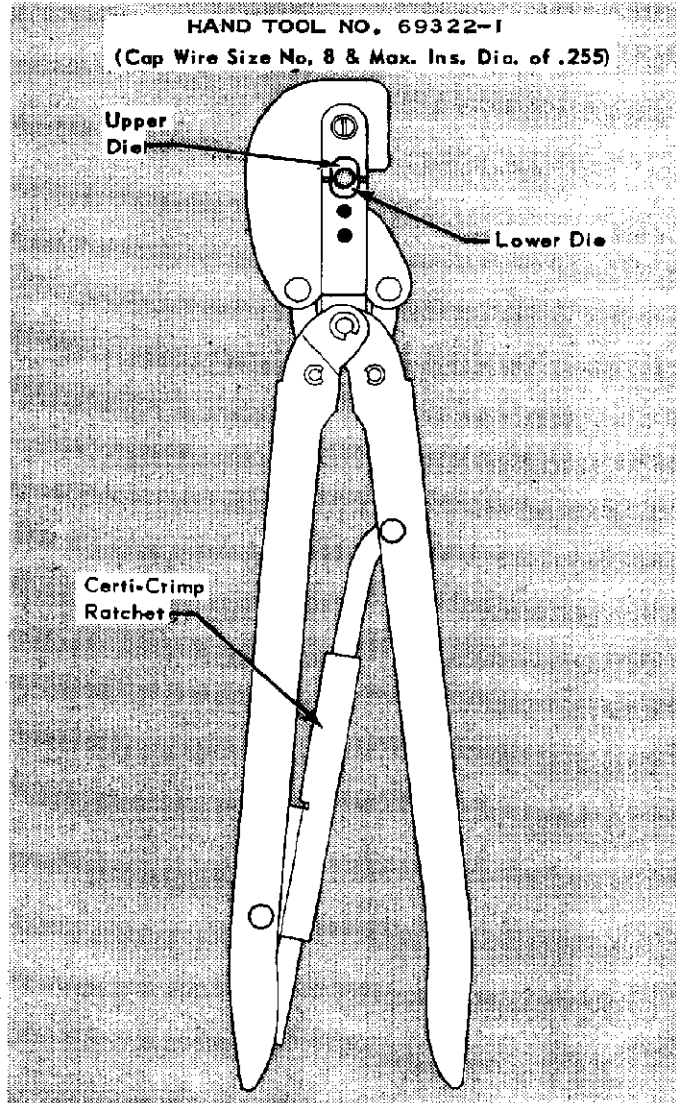


Fig. 9

- (i) Complete crimp by closing Handles until Certi-Crimp Ratchet releases.
- (j) Open Tool Handles and remove crimped Assembly.

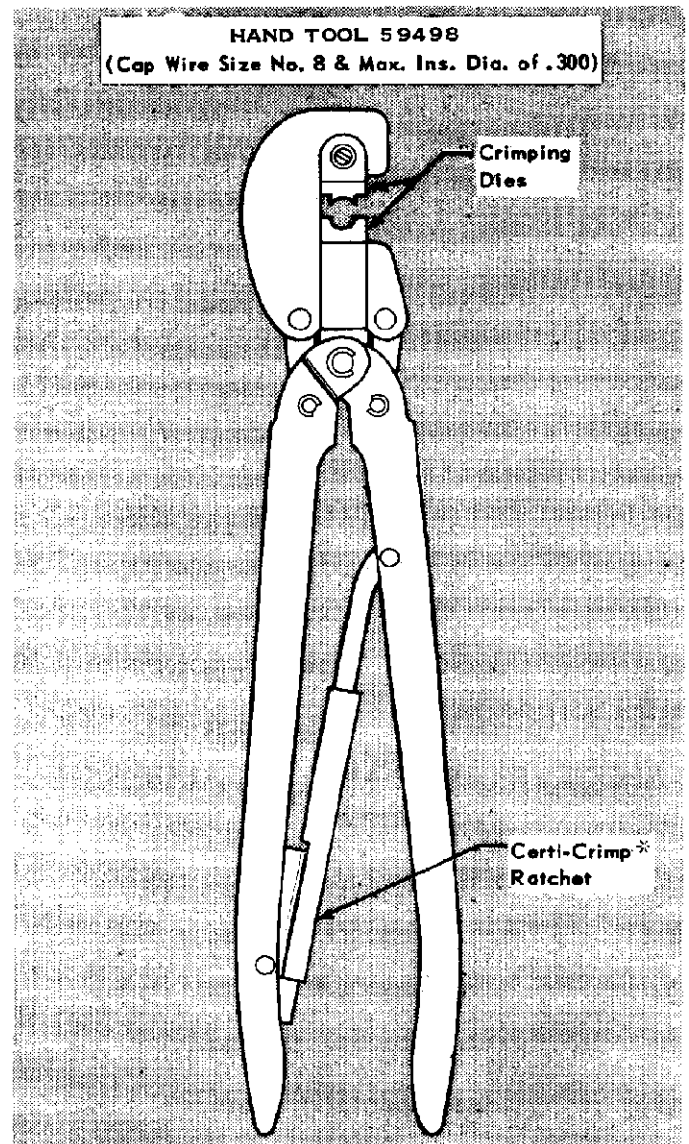


Fig. 10

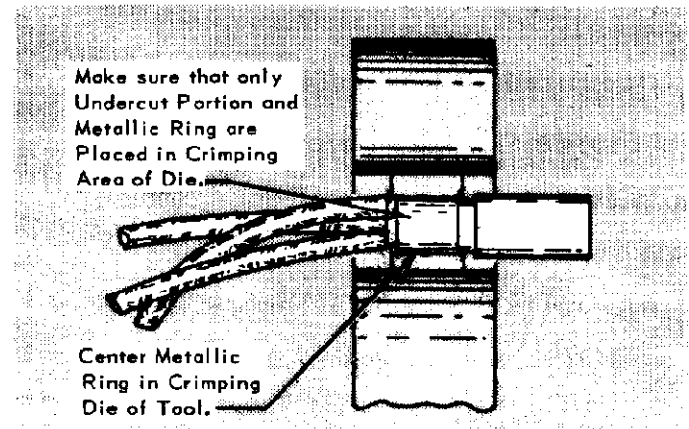


Fig. 11