



TAPER PIN CRIMPING DIES  
FOR AMPORTAMATIC★  
CRIMPING TOOL

|                |          |
|----------------|----------|
| <b>IS 1656</b> |          |
| RELEASED       | 3-22-60  |
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**1. INTRODUCTION**

These instructions cover the Dies used in AMPORTAMATIC Tool No. 69114 for crimping A-MP★PIDG★ solid Taper Pins on Tape.

**2. IMPORTANT DATA**

Select the proper Taper Pin and Die according to the wire size you plan to use. Figure 1. The Dies and Taper Pins are color-coded for easy matching.

Strip your wire to the proper length for each Taper Pin. Do not use wire which has cut or nicked strands.

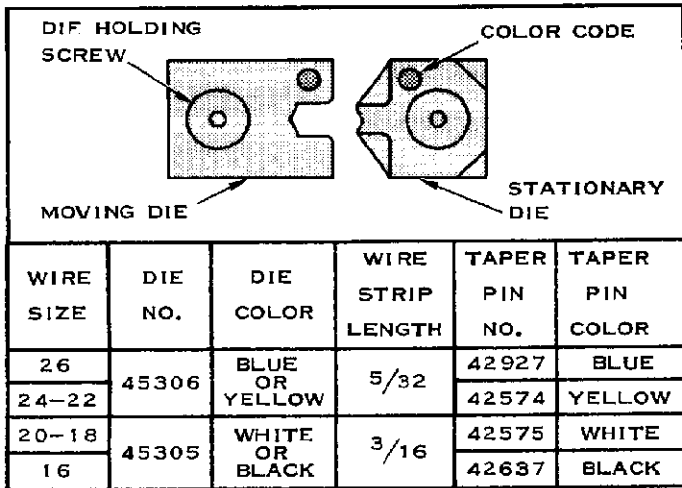


FIGURE 1

**3. INSTALLING THE DIES**

**CAUTION**

Disconnect the Air Supply.

Each Die Set has a Moving Die and a Stationary Die. Figure 1. Install the Dies as follows:

1. Place the Stationary Die in the Stationary Die Holder, and tighten the holding screw finger tight. Figure 2.

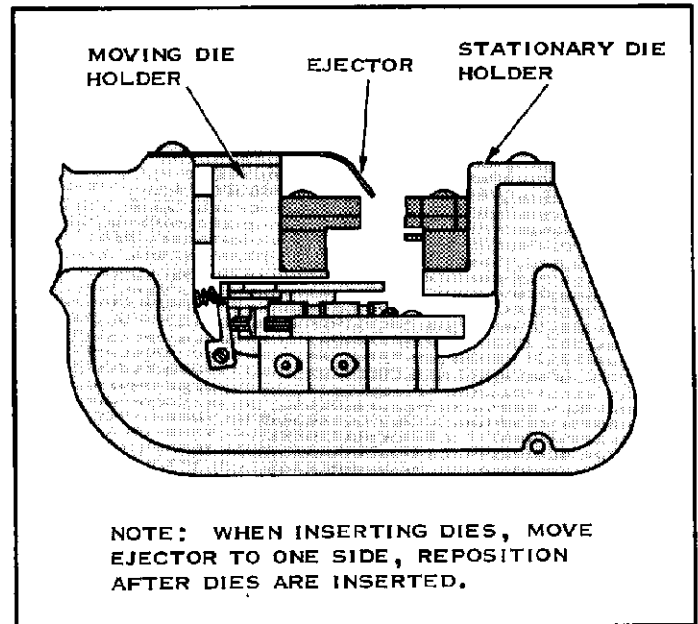


FIGURE 2

2. Loosen the Ejector holding screw, and move the Ejector to one side.
3. Place the Moving Die in the Moving Die Holder, and tighten the holding screw finger tight.
4. Press and hold down the Trigger. The Moving Die will close.
5. While the Moving Die is closed, tighten both holding screws.
6. Release the Trigger. The Die will open.
7. Move the Ejector back in place, and tighten the holding screw.

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#### 4. CRIMPING TAPER PINS

**NOTE**

Read the instructions packed with the AMPORTAMATIC Tool before crimping Taper Pins.

Crimp Taper Pins as follows:

1. Place the roll of Taper Pins in the Magazine. Figure 3.
2. Pull the end of the tape through the slot in the Magazine.
3. Move the Magazine Lid over the roll of Taper Pins. If necessary, adjust the lid height to the height of the roll.
4. Remove the tape leader from the end of the roll.
5. Engage the first slot in the tape with a Sprocket Tooth and depress the Tape Guide Levers. Figure 4.

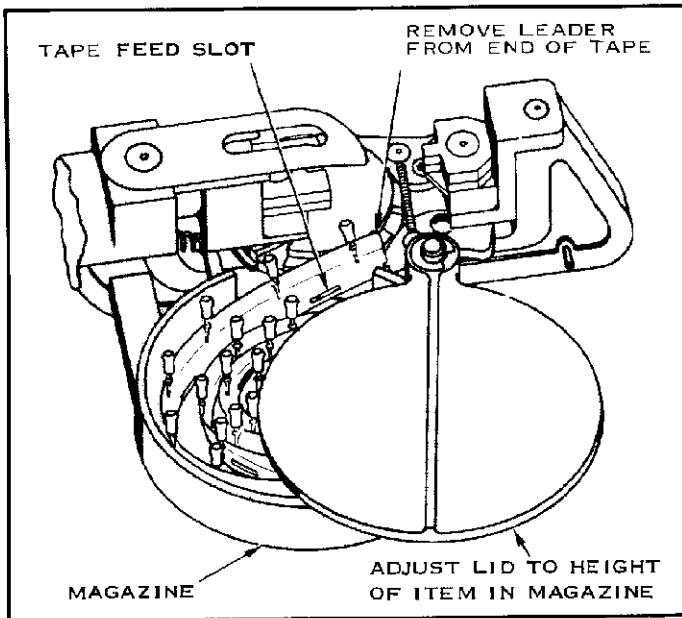


FIGURE 3

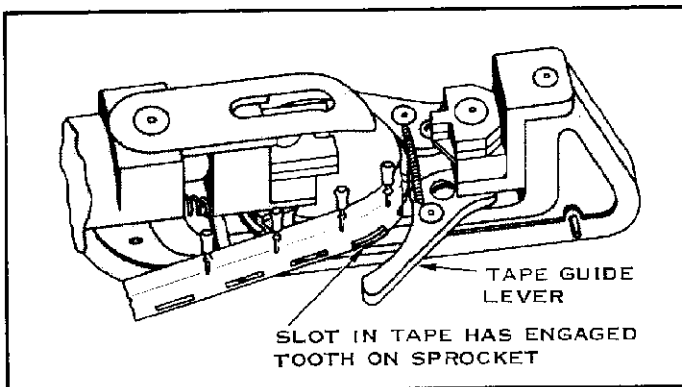


FIGURE 4

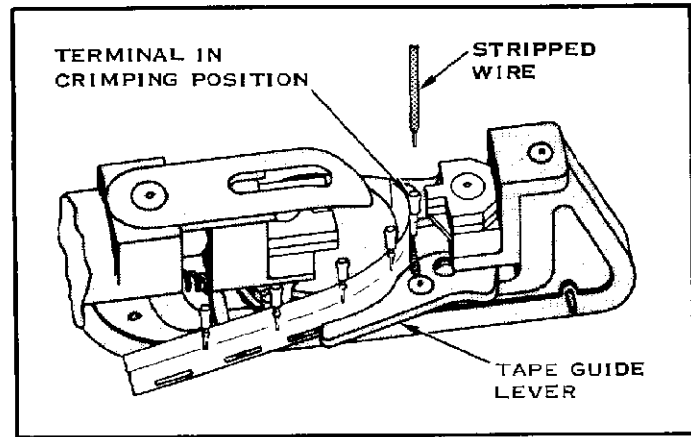


FIGURE 5

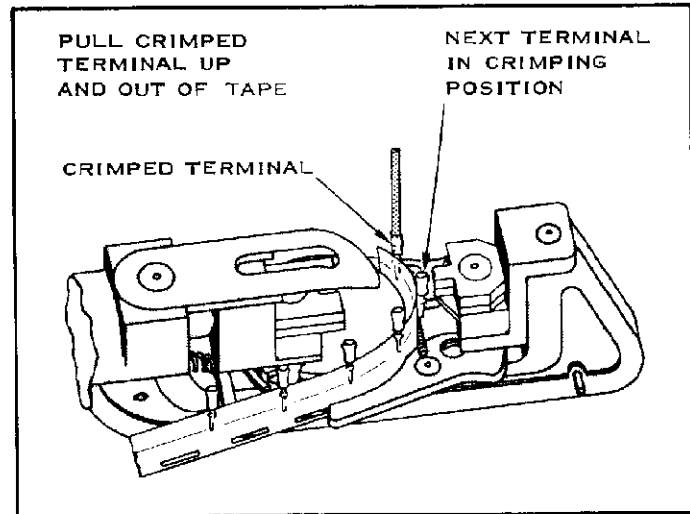


FIGURE 6

6. Press and release the Trigger, until the first Taper Pin moves into crimping position. Figure 5.
7. Insert your stripped wire into the Taper Pin. (The wire does not need to be held during the crimping cycle.)
8. Press and release the Trigger. The Taper Pin will be crimped and moved into position for removal from the tape. The next Taper Pin will be moved into crimping position. Figure 6.
9. Remove the crimped Taper Pin by pulling it straight out of the tape.
10. When the last Taper Pin has been crimped, remove the tape from the Tool by pressing and releasing the Trigger several times. To remove the roll of Taper Pins before it is used up, release both Tape Guide Levers and lift out the roll.

**CAUTION**

Disconnect the Air Supply before removing the Dies.