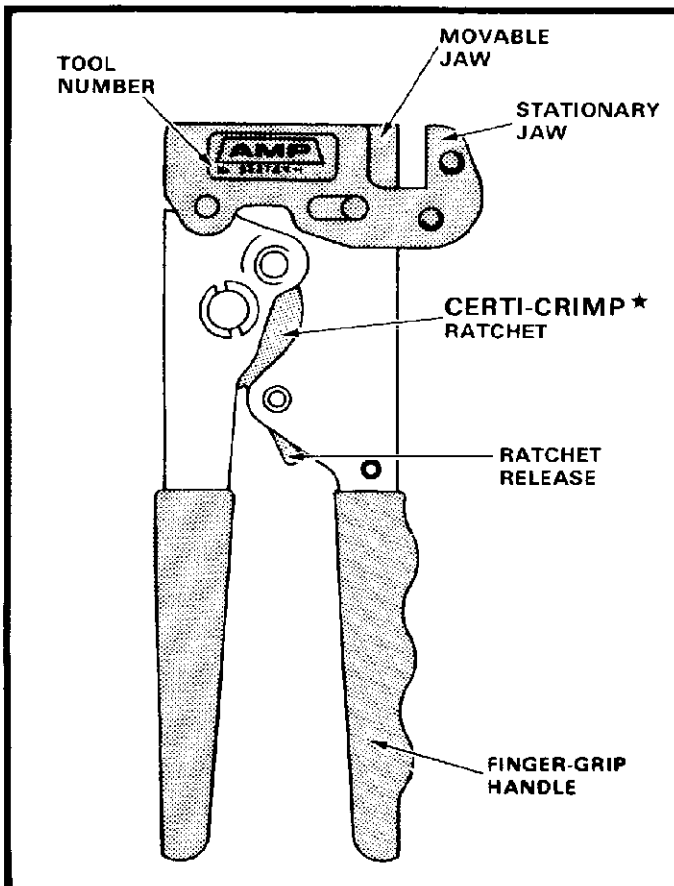


AMPAMP INCORPORATED
Harrisburg, Pa. 17105**AMP ★ TEL-SPLICE CONNECTOR
HAND TERMINATING TOOL 552724-1**

Instruction Sheet

IS 6502

RELEASED 2 • 15 • 85

**Fig. 1****1. INTRODUCTION**

This instruction sheet (IS) covers the AMP Hand Terminating Tool 552724-1 which is designed to terminate the AMP Tel-Splice loose-piece connectors listed in Figure 2.

Read this sheet thoroughly before using the tool.

NOTE

All dimensions on this sheet are in inches.

2. DESCRIPTION

The hand tool features a movable and a stationary terminating jaw, a wire cutter, a CERTI-CRIMP ratchet, and a ratchet release (see Figure 1).

The jaws provide a smooth, even surface for compressing the two halves of the connector together.

The CERTI-CRIMP ratchet assures full termination of the connectors. Once engaged, the ratchet will NOT release until the handles are fully closed — unless the ratchet release is depressed.

The ratchet release will allow you to disengage the ratchet in the event of a faulty termination.

Each connector consists of a pre-assembled two-piece housing (contact retainer and wire entry) and an insulation-displacement contact which will accept solid copper conductors — any combination of 19 through 26 AWG with a maximum insulation diameter of .080 in.

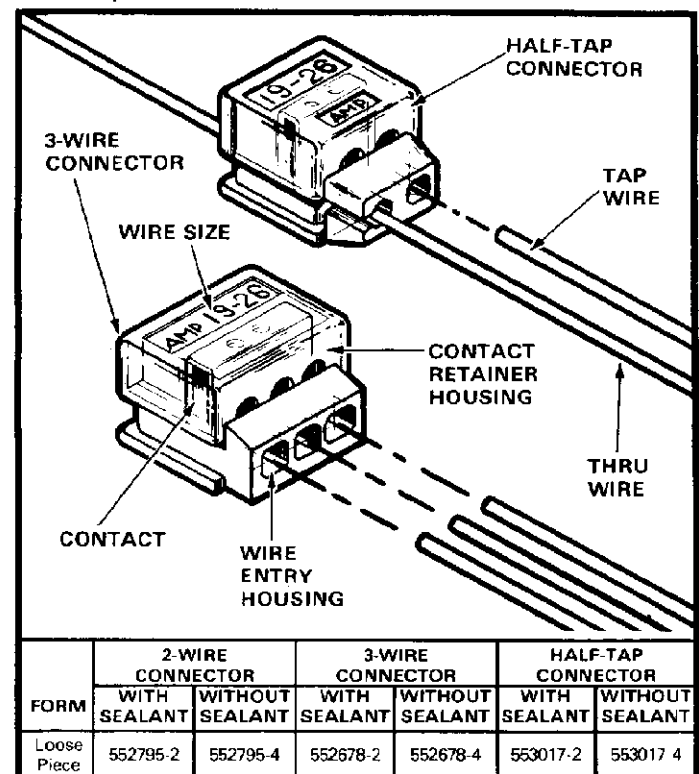
3. TERMINATION PROCEDURES

Determine whether you are going to terminate two or three wires, or a half-tap application, and whether the application requires a sealed or unsealed connector. Refer to the chart in Figure 2 and select the proper connector. Select wire within the specified size and proceed as follows:

1. Trim wire ends flush using wire cutter on side of tool.
2. For two- or three-wire connectors, insert wires into wire holes until bottomed in wire entry housing.

For half-tap connector, place thru wire into slot of connector at desired tap location. Make sure thru wire is fully contained in slot. Insert tap wire into wire hole until bottomed in the wire entry housing.

3. Press connector halves together with fingers in order to pre-crimp and help hold wires in place for final termination.

**Fig. 2**

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4. Make sure the ratchet is disengaged by squeezing the tool handles together and allowing them to open fully.
5. Place connector between tool jaws with wire holes to the left, top (except half-tap connector), or right — depending on which is most convenient. See Figure 3.

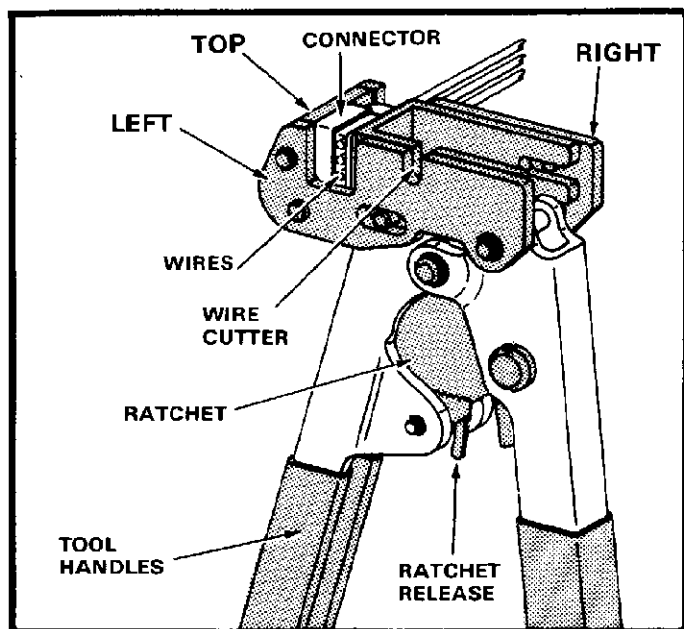


Fig. 3

6. Check to be sure wires have not shifted. Hold wires in place and squeeze tool handles together until ratchet releases. Allows tool handles to open FULLY and remove terminated connector.

NOTE

If it becomes necessary to disengage the ratchet before completion of a cycle, squeeze the tool handles just enough to relieve pressure on the ratchet release — then depress ratchet release and allow tool handles to open fully.

4. TOOL CERTIFICATION

AMP Hand Terminating Tool 552724-1 should be certified with the information provided in Figure 4. We suggest that you visually inspect the tool, and terminate and inspect some sample connectors, to be sure the tool has not been damaged during handling. The following procedures have been established to ensure quality and reliability of AMP hand terminating tools.

A. Daily Maintenance

Remove all foreign particles with a clean, soft brush, or a clean, soft, lint-free cloth. Make sure the proper retaining pins are in place, and are secured with the proper retaining rings. If foreign matter cannot be removed easily, return the tool to your supervisor.

Make certain all pivot points and bearing surfaces are protected with a THIN coat of any good SAE No. 20 motor oil. Do NOT oil excessively. When the tool is not in use, keep the handles closed to prevent objects from becoming lodged between the terminating jaws, and store the tool in a clean, dry area.

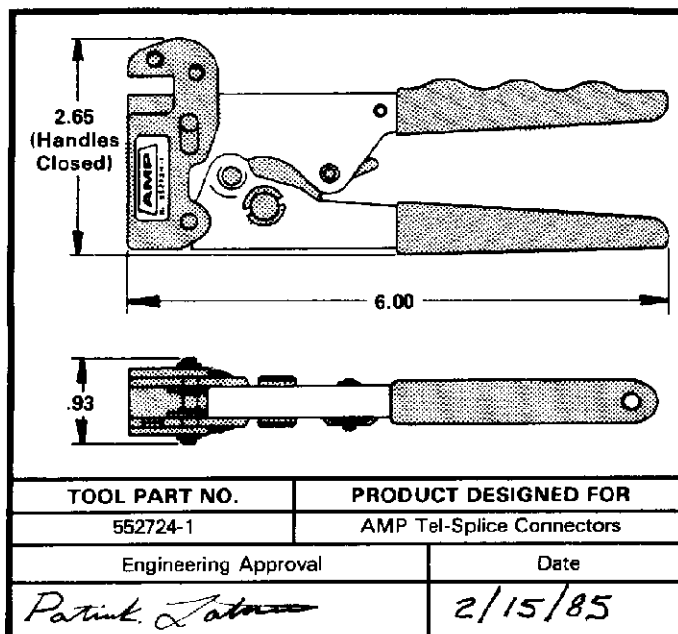


Fig. 4

B. Periodic Inspection

Regular inspections should be performed by quality control personnel. A record of scheduled inspections should remain with the tool and/or be supplied to supervisory personnel responsible for the tool. Through recommendations call for at least one inspection a month, the inspection frequency should be based on the amount of use, ambient working conditions, operator training and skill, and established company standards.

1. Remove all lubrication and accumulated film by immersing the tool (handles partially closed) in a suitable commercial degreaser that will not affect paint or plastic material.
2. Make certain all retaining pins are in place and secured with retaining rings.
3. Close the tool handles until the ratchet releases, then allow handles to open freely. If they do not open quickly and fully, the spring is defective.
4. Inspect the head assembly, with special emphasis of checking for worn, cracked, or broken areas.

If any parts are missing or damaged, return the tool to AMP for evaluation and repair (see Paragraph 6, REPAIR).

Terminate some sample connectors and check the termination height (see Paragraph C, Gaging Connector Termination height).

C. Gaging Connector Termination Height

This inspection requires the use of AMP Tel-Splice Connector Gage 230495-1 which is designed to assure proper wire insertion depth.

Proceed as follows:

1. Terminate several sample connectors.
2. Check each connector by placing connector in gage so contact is aligned with gage members as shown in Figure 5.

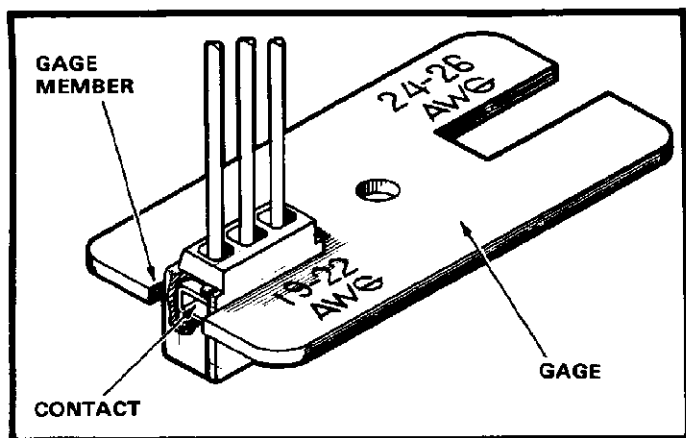


Fig. 5

3. Slide gage off connector — it should slide off easily with little or no drag. Improperly terminated connectors will stick or have very noticeable drag.

If the sample connectors conform to inspection procedure, lubricate the tool with a THIN coat of any good SAE No. 20 motor oil and return it to service. If the sample connectors do NOT gage properly, the tool must be repaired before returning it to service (see Paragraph 6, REPAIR).

6. REPAIR

When repair is necessary, return the tool with a description of the problem to:

AMP Incorporated
Tool Repair
3600 Gum Tree Road
Winston-Salem, NC 27107

Additional tools can be purchased from:

AMP Incorporated
P.O. Box 3608
Harrisburg, PA 17105