



APPLICATION AND MAINTENANCE FOR AMP* HAND CRIMPING TOOL ASSEMBLIES 91239

Instruction Sheet
IS 6678
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Section I of this instruction sheet provides application procedures for AMP hand crimping tools. Section II provides maintenance and inspection procedures for AMP hand crimping tools.

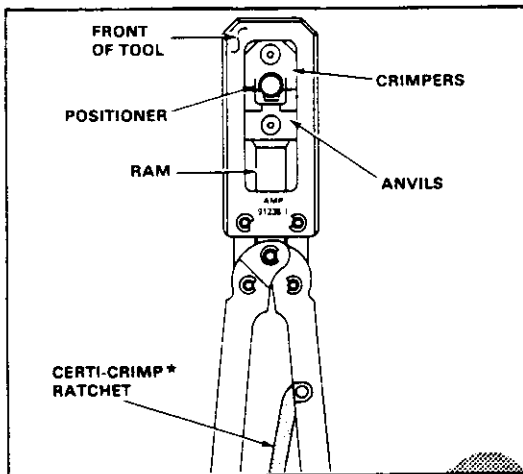


Fig. I-1

SECTION I APPLICATION

I-1. INTRODUCTION

This instruction sheet (IS) covers the use of the AMP Hand Crimping Tool Assemblies with base part number 91239 which are used to crimp AMPLIMITE* Crimp Ferrules listed in Figure I-2 to jacketed cable. Read these instructions thoroughly before crimping any ferrules.

NOTE: All dimensions on this instruction sheet are in inches.

I-2. DESCRIPTION (Figures I-1 and I-3)

The crimping assembly consists of a base hand tool 91238-1 and die assemblies with a base part number of 543013. The die assembly consists of crimpers, anvils, and ferrule positioners. Refer to Figure I-2 to match the proper tooling with the positioner and die markings.

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CONNECTOR SIZE	CABLE DIA RANGE	CRIMP FERRULE		HAND CRIMPING TOOL	DIE ASSEMBLY NUMBER	POSITIONER/DIE MARKING	OUTER FERRULE STOP	POSITIONER
		INNER	OUTER					
1 (9 Posn)	190-240	1-7	-8	91239-2	543013-2	B-1	543022-1	543021-2
	190-240	1-7	-6			A-1		
	230-280	3-4	-6			B-8		
	320-370	1-7	-6			B-3		
	190-240	2-1	-8			C-1		
	190-240	2-1	-6			B-1		
2 (15 Posn)	190-240	2-1	-8			C-8		
	230-280	2-1	-8			C-8		
	230-350	2-1	-9			C-2		
	315-365	1-7	-0			B-3		
	380-430	1-7	-1			C-4		
	190-240	2-1	-1			C-1		
3 (28 Posn)	190-240	2-1	-8			C-1		
	230-280	3-1	-6			C-8		
	300-350	2-1	-9			C-2		
	300-350	2-1	-4			D-2		
	380-430	1-7	-1			C-4		
	380-430	2-1	-3			D-4		
4 (37 Posn)	190-240	2-1	-1			D-5		
	230-280	3-1	-6			C-1		
	230-350	2-1	-9			C-8		
	380-430	1-7	-4			C-2		
	380-430	1-7	-1			C-4		
	465-525	2-1	-6			E-4		
5 (50 Posn)	190-240	1-7	-8			E-5		
	300-350	2-1	-3			E-6		
	315-365	1-7	-0			B-1		
	380-430	2-1	-3			D-2		
	470-530	2-1	-2			B-3		
	470-530	3-1	-2			D-4		
6 (63 Posn)	190-240	1-7	-8			D-5		
	300-350	2-1	-4			F-5		
	315-365	1-7	-7			F-6		
	380-430	2-1	-3			F-7		
	470-530	2-1	-2					
	470-530	3-1	-2					
7 (76 Posn)	190-240	1-7	-8					
	300-350	2-1	-4					
	315-365	1-7	-7					
	380-430	2-1	-3					
	470-530	2-1	-2					
	470-530	3-1	-2					

Fig. I-2