

Section I of this instruction sheet provides application procedures for AMP crimping head assemblies.

Section II provides maintenance and inspection procedures for AMP crimping head assemblies.

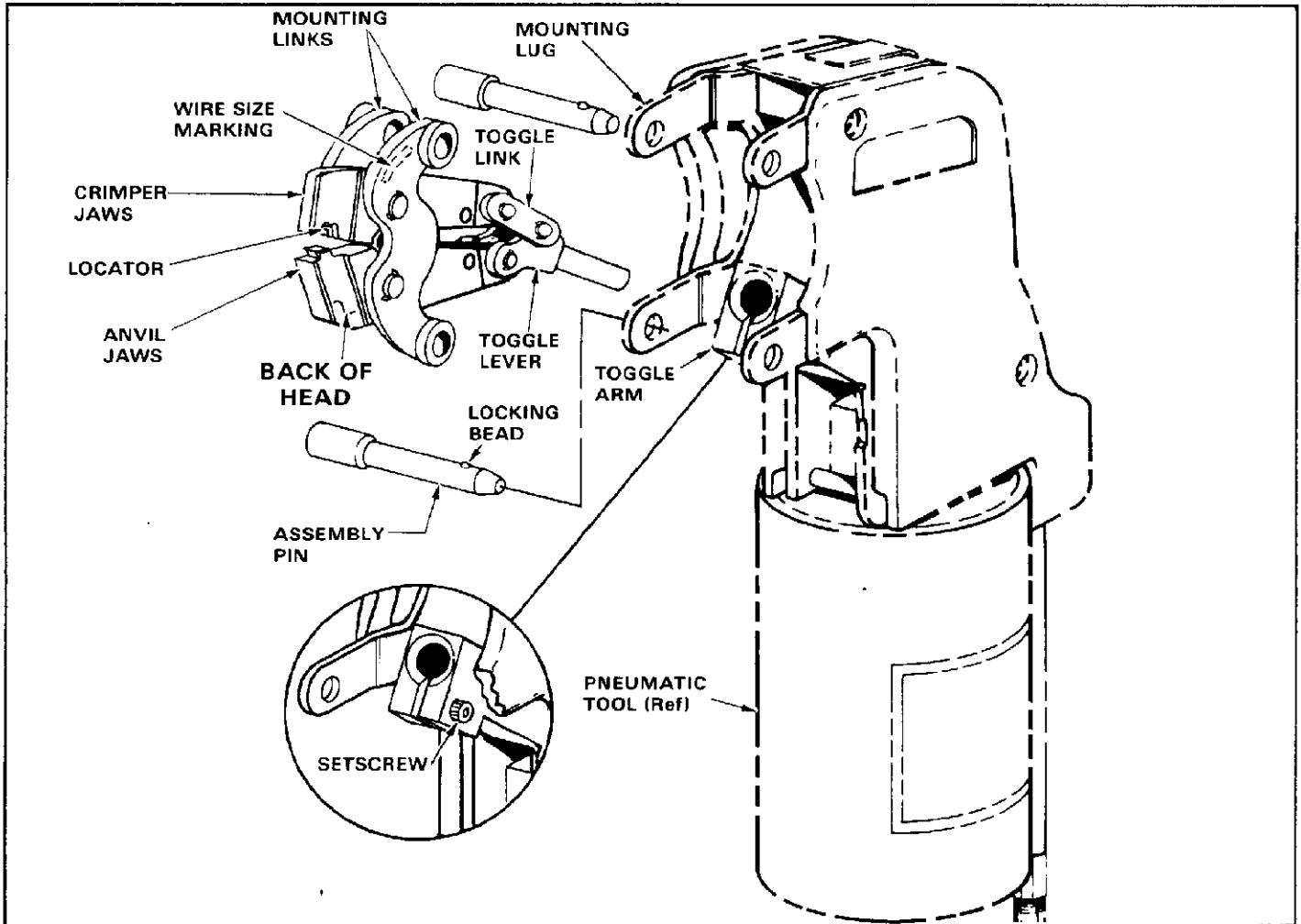


Fig. I-1

SECTION I APPLICATION

I-1. INTRODUCTION

This instruction sheet covers the use of the AMP Crimping Head Assemblies 90105, 90141, and 90163 which are designed for use in the AMP Pneumatic Tool 69005. The head assemblies are used to crimp AMP Flag FASTON terminals listed in Figure I-3.

Read these instructions thoroughly for specific information concerning the head assembly, terminals, wire specifications, and crimping procedures. Refer to IS 1410 packaged with pneumatic tool 69005 for information concerning the setup.

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

I-2. DESCRIPTION (Figure I-1)

Each head assembly features two anvil jaws, two crimper jaws, two mounting links, a locator, two toggle links, and a toggle lever with shank.

I-3. INSTALLATION OF HEAD ASSEMBLY (Figure I-1)

WARNING Do NOT attach air supply to the tool until crimping head is completely installed.

Proceed as follows:

1. Remove the two assembly pins from the mounting lugs.
2. Pull toggle arm forward and hold. Loosen, but do NOT remove, setscrew in toggle arm.

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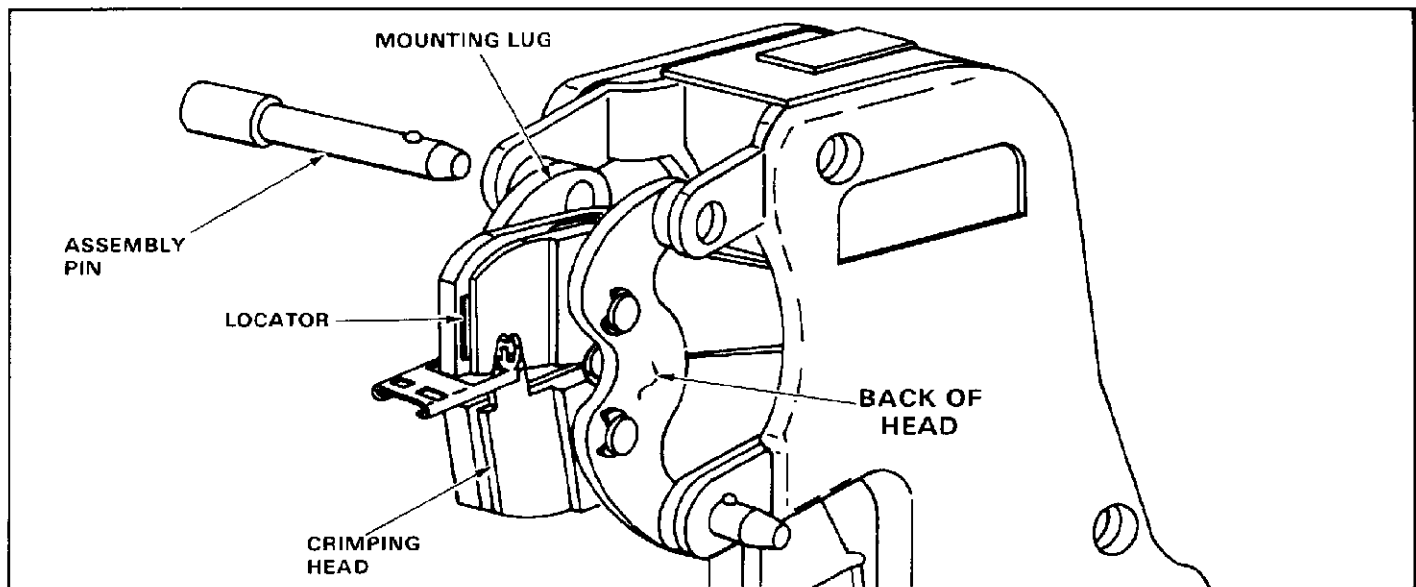


Fig. I-2

NOTE

Make sure the toggle link is ABOVE the toggle lever, as shown in Figure I-1.

3. With crimping jaws open, insert head assembly shank into toggle arm until it bottoms. Mounting links must fit between tool mounting lugs. See Figure I-2.
4. Tighten setscrew in toggle arm.
5. Align mounting holes of head assembly and tool. Insert assembly pins through mounting holes until locking beads pass outer edge of mounting lugs.

I-4. CRIMPING PROCEDURE

Refer to the chart in Figure I-3 and select stranded wire within the specified size and insulation diameter. Strip the wire to the length indicated — do NOT cut or nick the wire strands.

The crimping head must be the one designed for crimping the selected wire and terminal. Identify the appropriate crimp section according to the wire size or letter markings on the BACK of the tool. Connect air supply to tool.

After selecting an applicable loose-piece terminal, refer to Figure I-2 and proceed as follows:

1. Looking straight into BACK of appropriate crimp section, insert terminal (insulation barrel first) into FRONT of crimp section. Position terminal in crimpers so locator enters locator slot in terminal.
2. Insert a properly stripped wire through wire slot in locator and into wire barrel of terminal until insulation butts against locator/insulation stop.

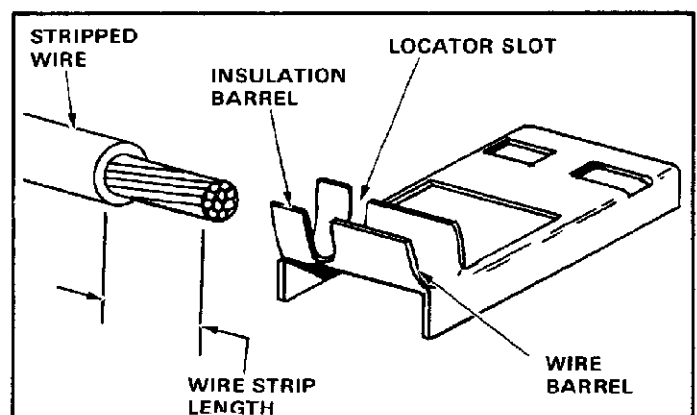
3. Holding wire in place, actuate the tool to complete the crimp. Release the crimped terminal from the crimping head.

I-5. REMOVAL OF HEAD ASSEMBLY (Figure I-1)

WARNING

Disconnect air supply before removing head assembly.

1. Remove the two assembly pins from the tool.
2. Pull head assembly forward to expose setscrew in toggle arm. Loosen setscrew and remove head assembly.



SIZE (AWG)	WIRE		TERMINAL NO.		CRIMPING HEAD	
	INSUL DIA	STRIP LENGTH	LP	STRIP	CRIMP SECT	NO.
22 to 18	.090 to .130	5/32 (.156)	60540	60314	22-18	90141
18 to 14	.140 (Max)	3/16 (.187)	60419	60290	18-14	90105
24 to 20	.048 to .078	5/32 (.156)	60811	60736	24-20	90163

Fig. I-3

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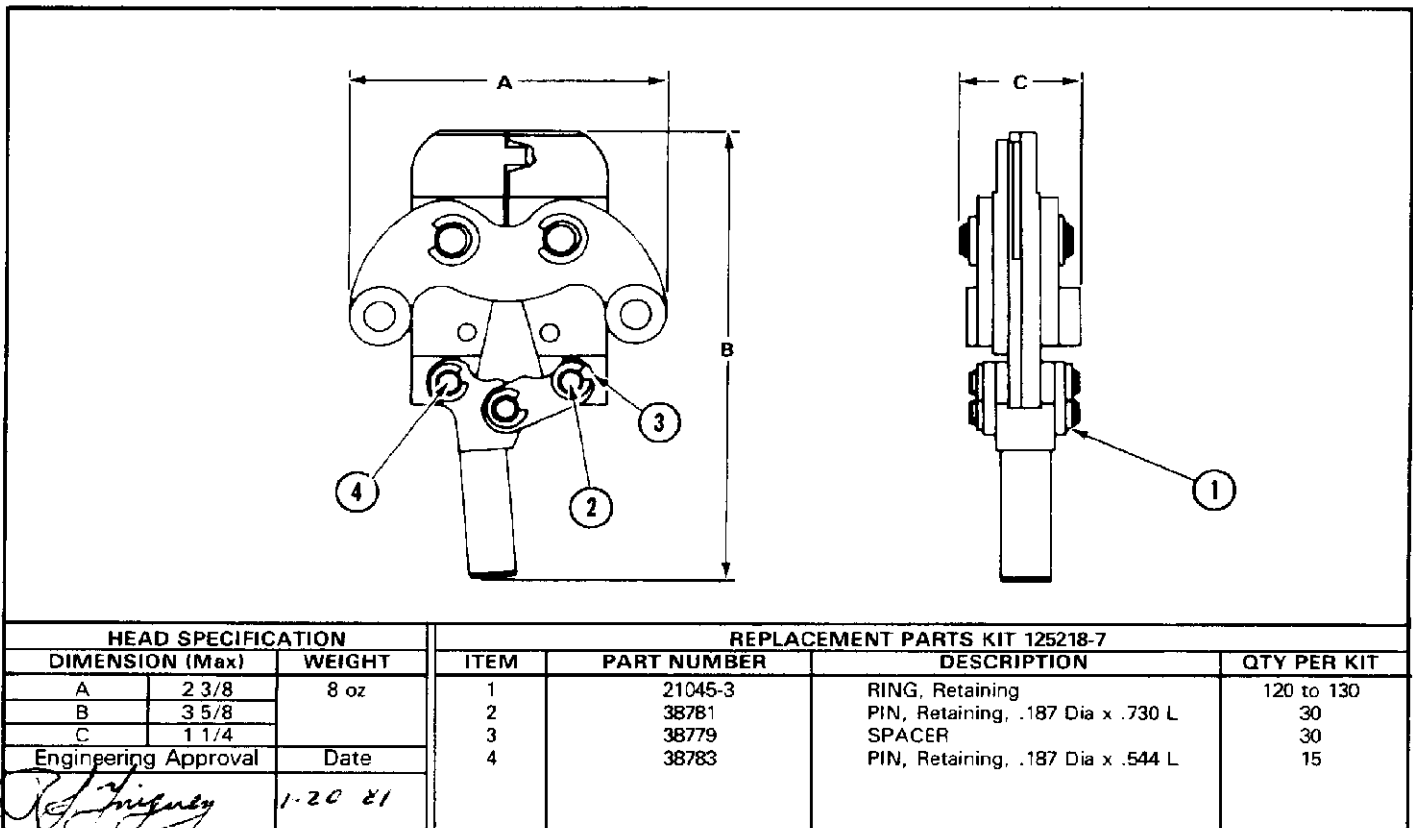


Fig. II-1

SECTION II MAINTENANCE/INSPECTION

II-1. CRIMPING HEAD CERTIFICATION

These instructions have been approved by AMP Design, Production, and Quality Control Engineers to provide documented maintenance and inspection procedures in accordance with AMP Corporate Policy No. 3-3. Through AMP test laboratories and the inspection of production assembly, the procedures described herein have been established to ensure quality and reliability of AMP crimping head assemblies.

Customer replaceable parts are listed in Figure II-1. A complete inventory should be stocked and controlled to prevent lost time when replacement of parts is necessary. When kit items are needed, order replacement kit part number.

II-2. INSPECTION PROCEDURES

A. Daily Maintenance

It is recommended that each operator of the crimping head assembly be made aware of — and responsible for — the following four steps of daily maintenance:

1. Remove dust, moisture and other contaminants with a clean brush, or a soft, lint-free

cloth. Do NOT use objects that could damage the crimping head assembly.

2. Make sure the proper retaining pins are in place and secured with the proper retaining rings.
3. Make certain all pins, pivot points, and bearing surfaces are protected with a THIN coat of any good SAE No. 20 motor oil. Do NOT oil excessively.
4. When the head assembly is not in use, keep the head assembly closed to prevent objects from becoming lodged in the crimping jaws and store in a clean, dry area.

B. Periodic Inspections

Regular inspections should be performed by quality control personnel. A record of scheduled inspections should remain with the head assembly and/or be supplied to supervisory personnel responsible for the head assembly. Though 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. These inspections should be performed in the following sequence:

B-1. Visual Inspection

1. Remove all lubrication and accumulated film by immersing the head assembly 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. If replacements are necessary, refer to parts listed in Figure II-1.
3. Inspect the head assembly, with special emphasis on checking for worn, cracked, or broken jaws. If damage to any part of the head assembly is evident, return the head assembly to AMP for evaluation and repair (see Paragraph II-3, REPAIR).

B-2. Crimp Height Inspection

This inspection incorporates the use of a micrometer with a modified anvil as shown in Figure II-2. We recommend the modified micrometer (Crimp Height Comparator RS-1019-5L) which can be purchased from:

York Machinery & Supply Co. 20 North Penn St. York, PA 17401	or	VALCO 1410 Stonewood Dr. Bethlehem, PA 18017
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Proceed as follows:

1. Refer to the chart in Figure II-2, and select a terminal and a wire (maximum size) for each crimp section listed in the chart.
2. Refer to Paragraph I-3, CRIMPING PROCEDURE, and crimp the terminal accordingly.
3. Using a crimp height comparator, measure wire barrel crimp height as shown in Figure II-2.

If the crimp height conforms to that shown in the chart, the tool is considered dimensionally correct. If not, return the tool to AMP for evaluation and repair (see Paragraph II-3, REPAIR).

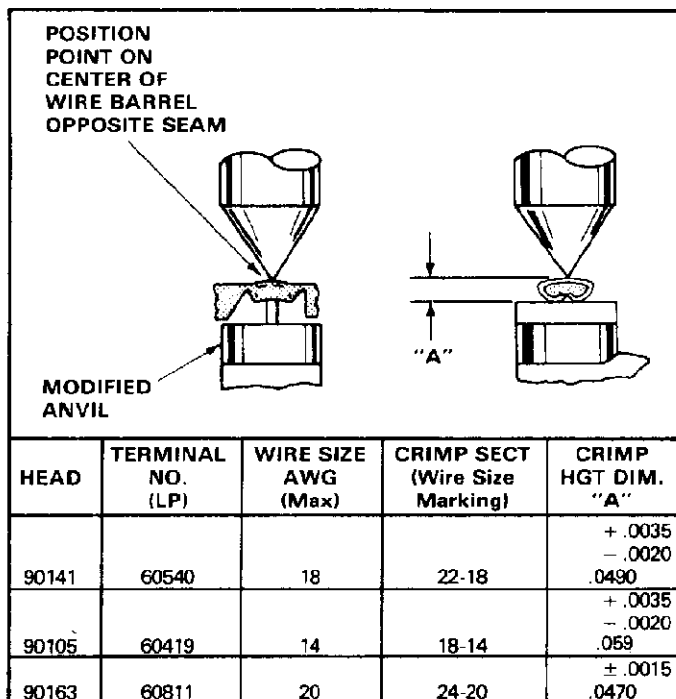


Fig. II-2

For additional information concerning the use of the crimp height comparator, refer to AMP Instruction Sheet IS 7424.

II-3. REPAIR

Parts other than those specified in Figure II-1 must be replaced by AMP to ensure certification of the head assembly. When repair is necessary, return the head assembly with a written description of the problem to:

AMP Incorporated
Customer Repair
1523 North 4th Street
Harrisburg, Pennsylvania 17105

or a wholly owned subsidiary of AMP Incorporated.