

AMP

AMP CRIMPING HEAD P/N 752852-1
FOR CRIMPING FASTON CONTACTS

P/N 752861-2

INSTRUCTION SHEET

日本イー・エム・ピー株式会社

411-5183
IS-183J

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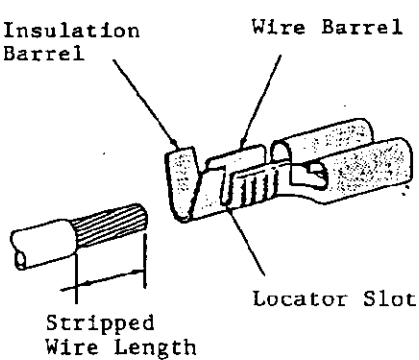
(INTRODUCTION)

This instruction sheet covers procedure of crimping operation, inspection and maintenance of AMP crimping head P/N 752852-1, to be used on AMP battery-powered hand crimping tool, P/N 752861-2.

The selection chart for contacts versus hand tools with proper crimping dies, Fig. 1 assists you to determine which wire and tool to use for operation.

Read this instruction sheet carefully before you start operation.

(1) Applicable Contacts, Wires, and Wire-stripping Length



Crimp Symbol	Applicable Contacts		Wire Size (mm)	Insulation Diameter (mm)	Wire Stripping Length (mm)
	Loose Piece	Strip Form (Ref.)			
14-12	41858	41449	2.00~3.37	4.1 max.	8.0
	61227	41450			
	41829	41450			
	41712	41679			
	61722	42437			
	42075	41449	2.00~3.37	3.8 / 5.1	
	42075	41679			
	60104	42437			
	60131				
	62087				
10	61227	41450	4.60~5.27	4.1 max.	8.0
	61722	42437			
	62087	42437			
		41449	4.60~5.27	3.8 / 5.1	
		41450			
		41679			

Fig. 1

(2) Crimping Procedure

Refer to Paragraph 4-1 of Instruction Sheet, IS-166J, for crimping procedure by using battery-powered hand crimping tool.

See Fig. 2 for correct placement of contact against crimping dies.

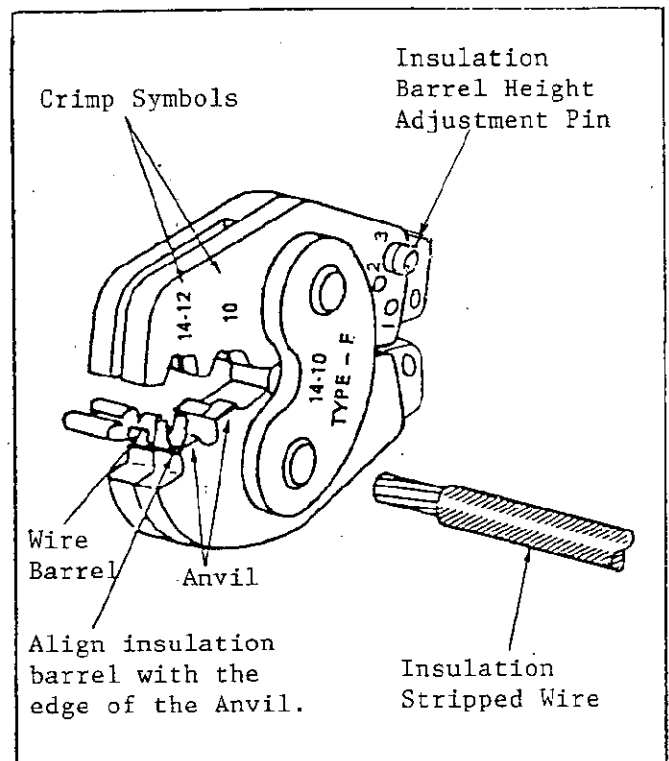


Fig. 2

(3) Adjustment of Insulation Crimp Height

This crimping dies is capable of adjusting the insulation crimp height in three settings. Use No. 3 slot of adjustment pin for large insulation wire, No. 2 for medium insulation wire and No. 1 for small insulation wire.

(4) Inspection of Wire Barrel Crimp Height

For checking crimp height of wire barrel, a micrometer with modified anvil is used as shown in Fig. 3. Modification of micrometer is usually difficult and costly. It is recommended that customers would purchase the micrometer modified by AMP-Japan. The modification drawing can be supplied to the customer freely upon request. Contact AMP-Japan if any of the users would try to modify by in-house facilities.

Measures the crimp height in the manner shown in Fig. 3. And the obtained value conforms to the listing of Fig. 3, the wire crimp is considered acceptable.

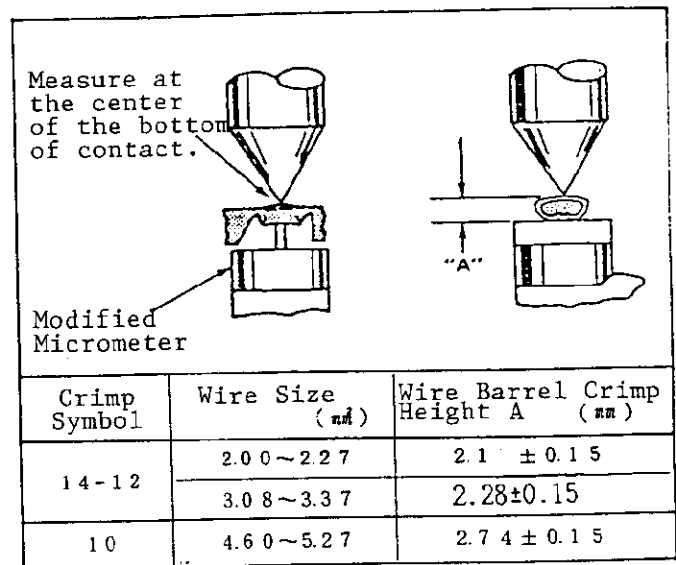


Fig. 3

(5) Periodic Inspection

Regular inspection should be performed by the operator periodically, once every 500 cycles of crimping approximately. The checking should be visually performed to see the following points:

1. Refer to Paragraph 2.1 of Instruction Sheet, IS-169J, for checking mounting hole distance of crimping head, and measure the distance of the holes.

3. Confirm if all the component parts including retaining pins and rings are all in attached places. If any of them is missing, it must be placed in with new parts.

(6) Repair

As a result of crimp height inspection and visual inspection of crimping dies, if any abnormalities are found, return the tool to AMP factory or sales representatives of your area with detailed descriptions of malfunction or problem you have found.