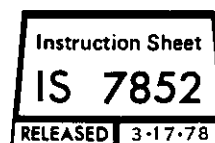




APPLICATION AND MAINTENANCE FOR AMP* HAND CRIMPING TOOL 90222-5



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.

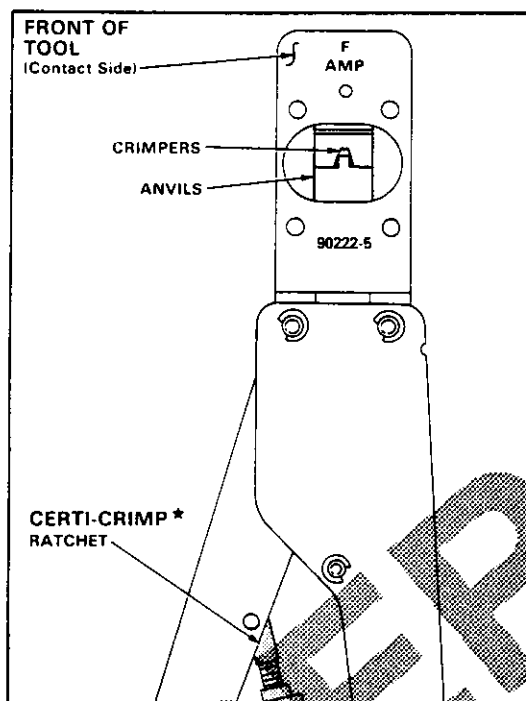


Fig. I-1

SECTION I APPLICATION

I-1. INTRODUCTION

AMP Hand Crimping Tool 90222-5 is designed to crimp the loose piece (LP) contacts used in AMP Flexible Flat Cable (FFC) Connectors (see Figure I-2). Read these instructions thoroughly before crimping any contacts.

NOTE

All dimensions presented on this instruction sheet are in inches, unless otherwise stated.

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

The FRONT OF TOOL (Contact Side), into which the contact is inserted, has the tool number marked on it. The BACK OF TOOL (Wire Side), into which the wire is inserted, has the wire size marked above the crimp section.

This tool features two fixed dies (crimpers), two movable dies (anvils), a contact support, a locator/insulation stop, and a CERTI-CRIMP ratchet.

The contact support prevents the contact from bending during the crimping operation.

The locator/insulation stop has two functions. First, it positions the contact between the crimping dies, and second, it aids in locating the wire in the contact. In use, it rests in the contact locator slot (see Figures I-2 and I-3).

The ejector pulls the locator down and ejects the crimped contact when the tool handles are FULLY opened.

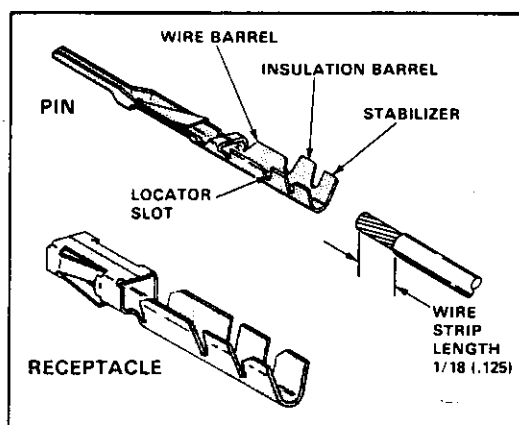
The CERTI-CRIMP ratchet ensures full crimping of the contact. Once engaged, the ratchet will not release until the handles have been FULLY closed.

CAUTION

The crimping dies bottom before the CERTI-CRIMP ratchet releases. This is a design feature that ensures maximum electrical and tensile performance of the crimp. Do NOT re-adjust the ratchet.

I-3. CRIMPING PROCEDURE

Refer to the chart in Figure I-2, and then select wire of the specified size and insulation diameter. Strip the wire to the length indicated — do NOT cut or nick the wire strands.



WIRE		CONTACT		CRIMP SECT WIRE SIZE MARKING
SIZE (AWG)	INSUL DIA	TYPE	LP	
24	.043	Pin	86561	24-22
to	to		86557	
22	.056	Rept	86571	24-22
			86566	