

IS 7652

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**AMP**AMP INCORPORATED  
Harrisburg, Pa. 17105APPLICATION AND MAINTENANCE  
FOR AMP ★ HAND CRIMPING TOOL  
90299-1

Instruction Sheet

**IS 7652**

RELEASED 8-8-80

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.

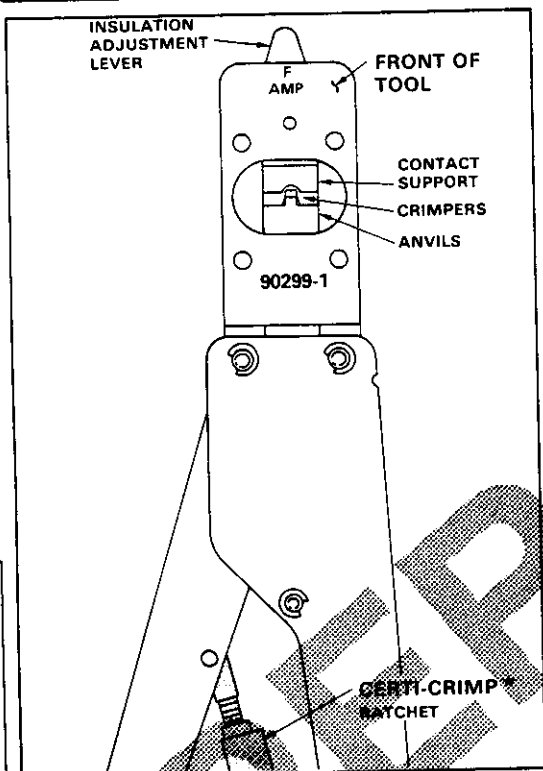


Fig. I-1

## SECTION I APPLICATION

## I-1. INTRODUCTION

AMP Hand Crimping Tool 90299-1 is designed to crimp the AMP Universal MATE-N-LOK ★ loose-piece (LP) pin and socket contacts listed in 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 (Figures I-1 and I-3)

The FRONT OF TOOL 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), an insulation adjustment lever, a contact support, a locator/insulation stop, and a CERTI-CRIMP ratchet.

The insulation adjustment lever is used to regulate the crimp height of the contact insulation barrel. Refer to Paragraph I-4, INSULATION CRIMP ADJUSTMENT.

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 locator slot of the contact (see Figures I-2 and I-3).

The CERTI-CRIMP ratchet assures 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 assures 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 select wire of the specified size and insulation diameter. Strip the wire to the length indicated — do NOT cut or nick the wire strands.

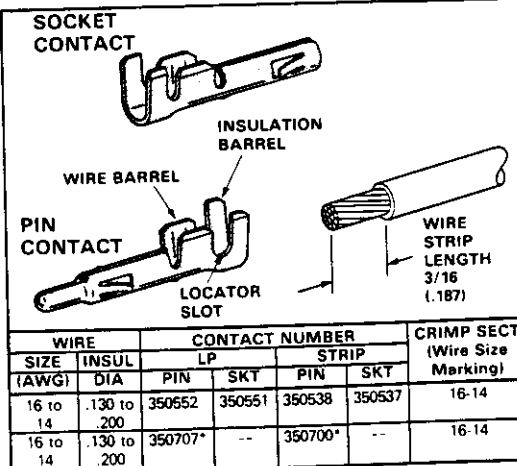


Fig. I-2

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