

See IS 9479

**AMP**AMP INCORPORATED  
Harrisburg, Pa. 17105APPLICATION AND MAINTENANCE  
FOR AMP ★ HAND CRIMPING TOOL 90300-1Instruction Sheet  
**IS 7706**

RELEASED 3-5-85

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.

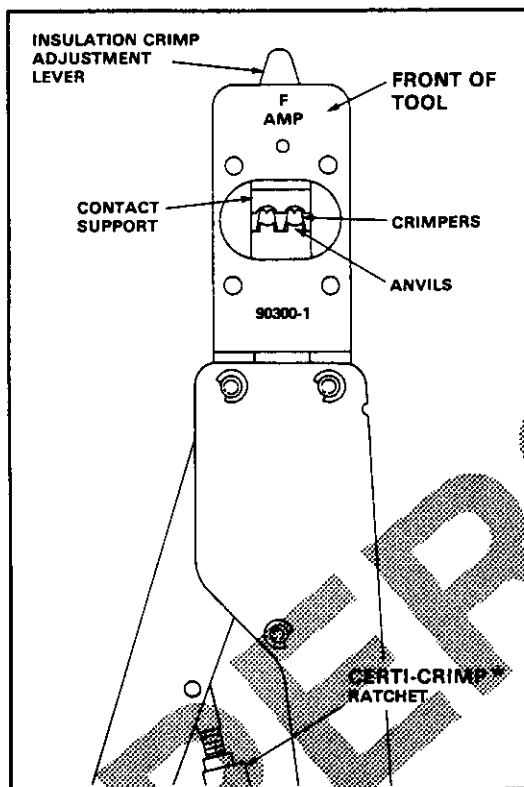


Fig. I-1

## SECTION I APPLICATION

## I-1. INTRODUCTION

AMP Hand Crimping Tool 90300-1 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.

## 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 each crimp

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

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

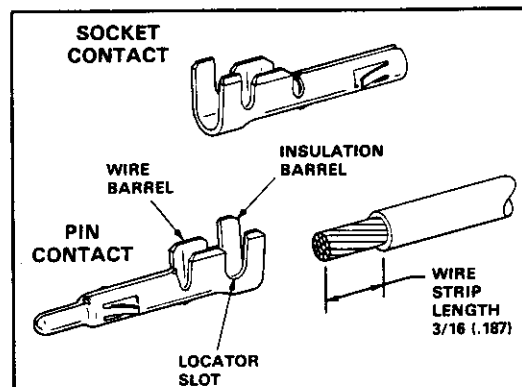
The contact support prevents the contact from bending during the crimping operation.

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.



WIRE		CONTACT				CRIMP SECT (Wire Size Marking)
SIZE (AWG)	INSUL DIA	LOOSE PIECE		STRIP		
		PIN	SOCKET	PIN	SOCKET	
24 to 22	.040 to .100	350690 350690 350706*	350689 640347 --	350561 350561 350699*	350570 350651 --	22-24
20 to 18		350690 350690 350706*	350689 640347 --	350561 350561 350699*	350570 350651 --	18-20

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