

1. INTRODUCTION.

The hand tools are used to crimp AMP PIDG* and PLASTI-GRIP* terminals and splices on wire, sizes 0,25-2,6 mm² (22-14 AWG).

2. INSTRUCTIONS.

Wire stripping and crimping procedures.

Strip wire to dimension listed in fig. 2. Strip length is determined by product to be crimped and by wire size.

Open crimping jaws by closing handles until CERTI-CRIMP* ratchet releases. See fig. 1. Note that once ratchet is engaged, handles cannot

be opened until they are fully closed. Place terminal in crimping jaws as shown in fig. 3,4, or 5.

Place PIDG-Nylon Butt Splices in crimping jaws as shown in fig. 6.

For crimping of PLASTI-GRIP Butt Splices the locator has to be removed from the tool. The splice should be located as shown in fig. 7.

Close handles until terminal or splice is held firmly in place. Do not deform terminal or splice barrel.

MAKE SURE TERMINAL BARREL RESTS AGAINST LOCATOR.

Insert stripped wire into barrel.

To complete crimp, close handles until CERTI-CRIMP ratchet releases.

Handles will open automatically and crimped item may be removed.

To crimp other half of splice, remove it and reposition uncrimped half in tool.

3. INSULATION CRIMPING ADJUSTMENT.

PIDG Terminals and Splices.

The insulation crimping section of the hand tool has three positions: 1- Tight, 2- Medium, 3- Loose.

Insert insulation adjustment pins in nr. 3 position. See fig. 1.

Place terminal or splice in crimping jaws and insert UNSTRIPPED wire into ONLY the insulation barrel portion of the terminal or splice. See fig. 2.

Make crimp.

Remove crimped terminal or splice and check insulation support as follows:

Bend the wire back and forth once.

Terminal or splice should retain grip on wire insulation.

If wire pulls out, set insulation adjustment pins in next tighter position (nr. 2).

Make test crimp and repeat adjustment as necessary until desired insulation grip is obtained.

Do not use a tighter setting than required.

Always make certain that both insulation adjustment pins are in the same position.

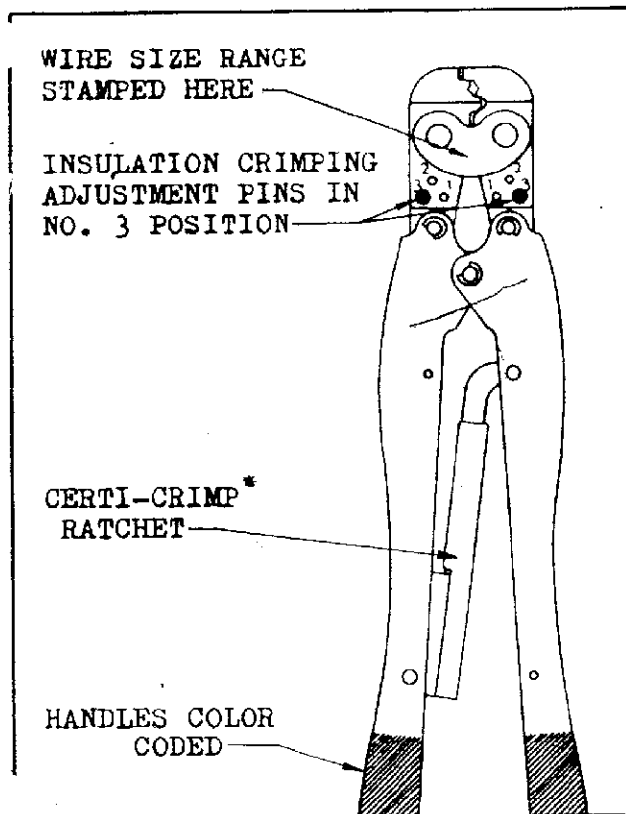
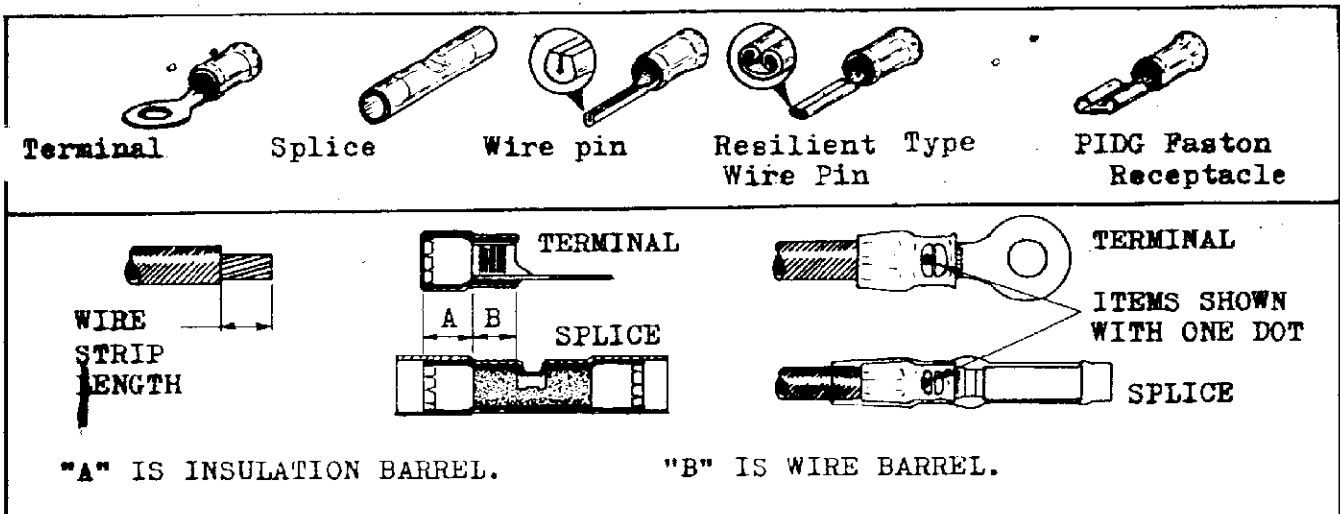


FIG. 1



| TOOL NO. | WIRE SIZE in mm ² . | COLOR/DOT CODE | PRODUCT CRIMPED | WIRE STRIPPING LENGTH | | | |
|----------------------------|--------------------------------|------------------------------|--|-----------------------|------------------|------------------|------------------|
| | | | | Terminals | | Splices. | |
| | | | | Min. | Max. | Min. | Max. |
| 525690-1 and 47386-4 | 0,25-1,6 (Code 22-16) | Red One dot | PIDG and PLASTI-GRIP terminals, splices and wire pins. | 5,5mm (7/32") | 6,4mm (1/4") | 6,3 mm (1/4") | 7,1mm (9/32") |
| | 0,75-1,5 (18-16 AWG) | | '110' Series PIDG FASTON Receptacles. | | | | |
| | 1,0-1,5 (17-16 AWG) | | '187' and '250' Series PIDG FASTON Receptacles and Resilient type PIDG wire pin. | 6,3mm (1/4") | 7,1mm (9/32") | | |
| | 0,3-1,0 (22-17 AWG) | | '250' Ser. PIDG FASTON Receptacle, overlapping barrel type, partnumber 160583-□□ | | | | |
| 47387-7 | 1,0-2,6 (Code 16-14) | Blue Green Two dots | PIDG and PLASTI-GRIP terminals, splices and wire pins. | 5,5mm (7/32") | 6,4mm (1/4") | 6,3mm (1/4") | 7,1mm (9/32") |
| | 3,0-3,4 (12 AWG) | | '187' and '250' Series PIDG FASTON Receptacles and Resilient type PIDG wire pin. | | | | |
| | 1,5-2,5 (16-14 AWG) | | '250' Series PIDG FASTON Receptacle, overlapping barrel type, partnumber 160313-□□ | 6,3mm (1/4") | 7,1mm (9/32") | | |

FIG. 2

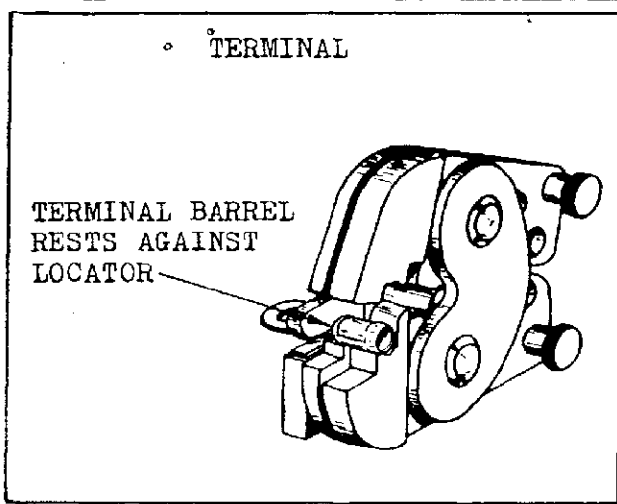


FIG. 3

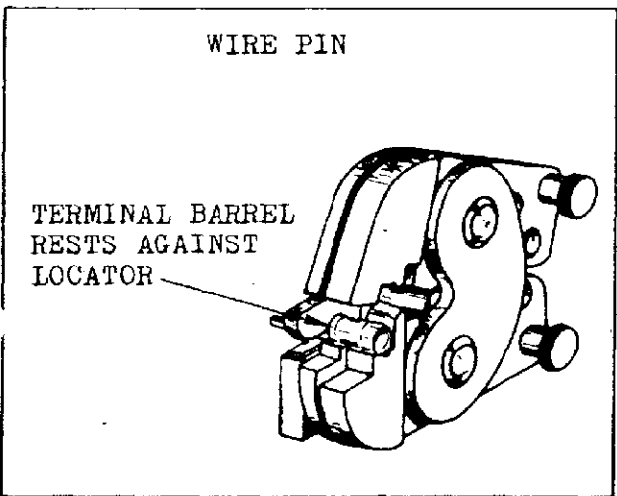


FIG. 4

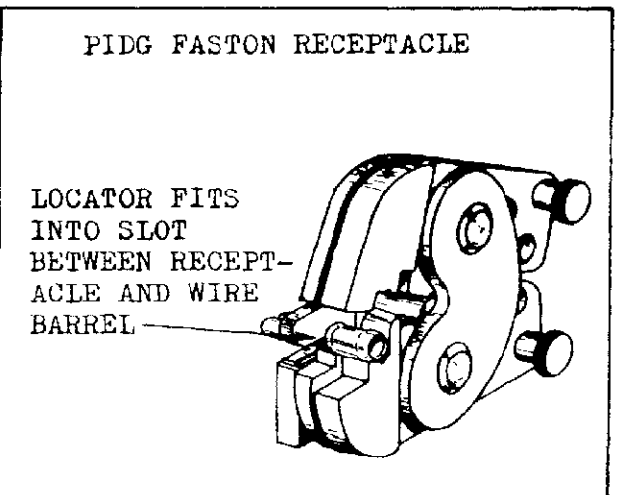


FIG. 5

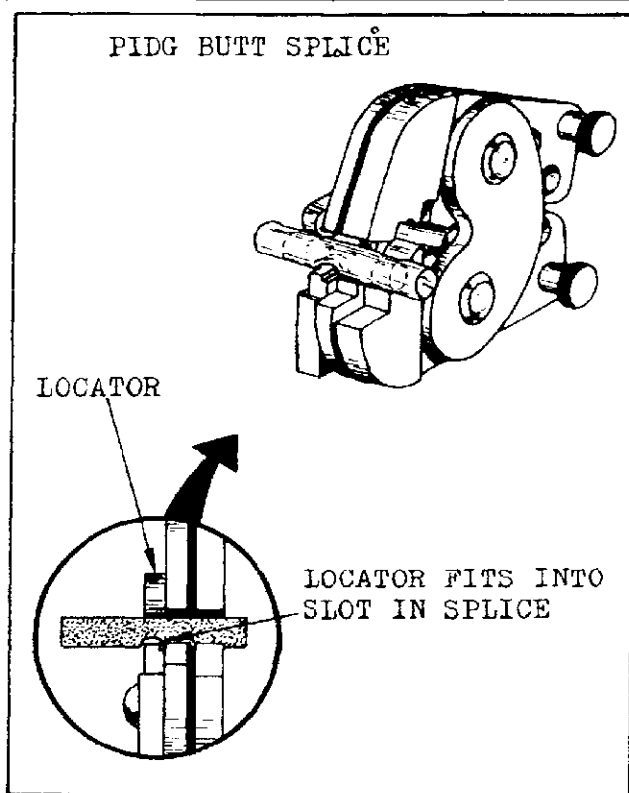


FIG. 6

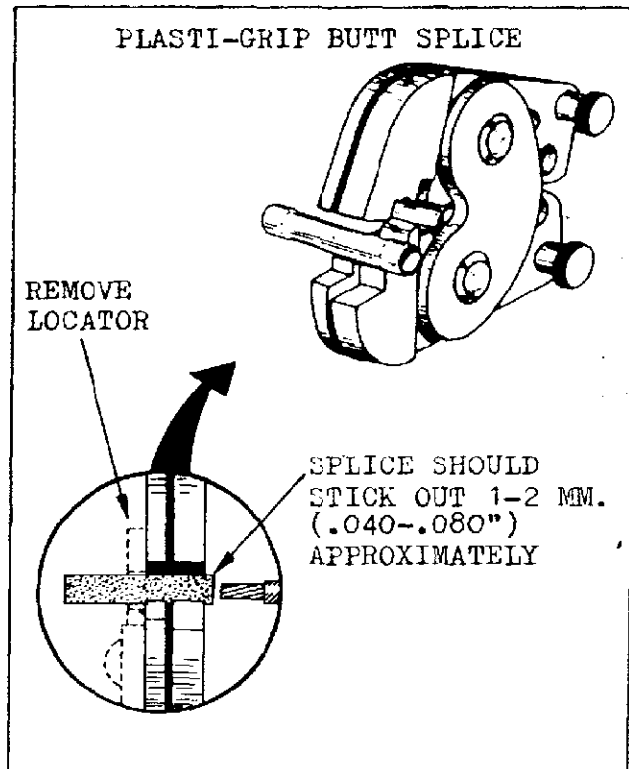


FIG. 7

PLASTI-GRIP terminals and splices.

NOTE: PLASTI-GRIP terminals and splices feature a wire insulation support only. PIDG terminals and splices feature an insulation grip. The insulation crimping section of the hand tool has three positions: 1-tight, 2-medium, 3-loose. See fig. 1. Position nr. 3 is for wire having a large insulation diameter. Position nr. 2 is for wire having a medium insulation diameter. Position nr. 1 is for wire having a small insulation diameter. When making the adjustment, always make certain that both insulation adjustment pins are in the same position. See fig. 1.

4. COLOR AND DOT CODE.

Note that the terminal, splice and tool handle colors are coded for a given wire size as listed in fig. 2. The dot coding will appear on terminals and splices when they are crimped properly in the correct AMP hand tools. See fig. 2.

5. MAINTENANCE/INSPECTION PROCEDURE.

CLEANING.

The tool should be immersed (handles partially closed) in a reliable commercial de-greasing compound to remove accumulated dirt, grease and foreign matter. Make certain that the de-greasing compound does not attack paint or plastic materials. Remove remaining de-greasing compound with a lint free cloth. When de-greasing compounds are not available, tool may be wiped clean with a lint free cloth. Relubricate tool, as instructed below, before placing it back in service.

LUBRICATION.

Lubricate all pins, pivot points and bearing surfaces with a good grade S.A.E. nr. 20 motor oil as follows:
 a) Tools used in daily production - Lubricate daily.
 b) Tools used daily (occasional) - Lubricate weekly.
 c) Tools used weekly - Lubricate monthly.
 Wipe excess oil from tool, particularly from crimping area. Oil transferred from the crimping area onto certain terminations may affect the electrical characteristics of an application.

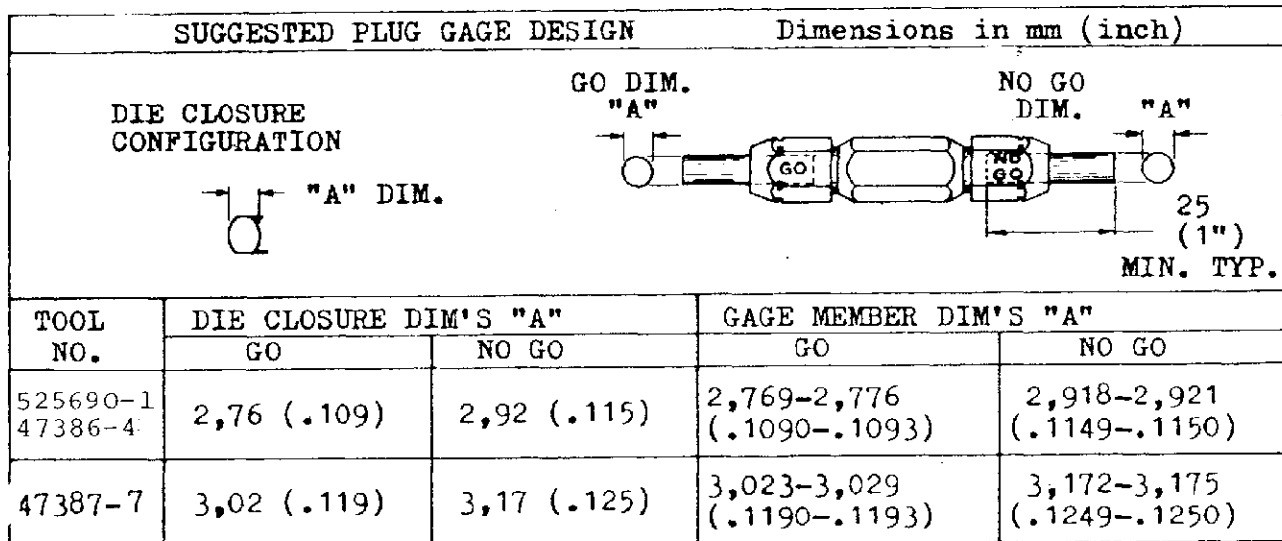
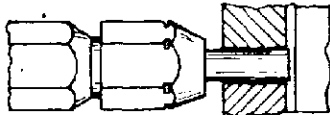
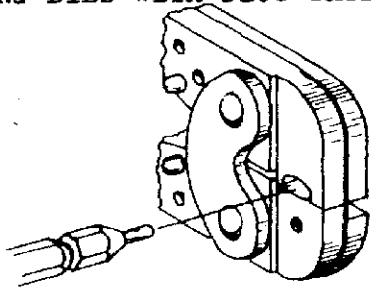
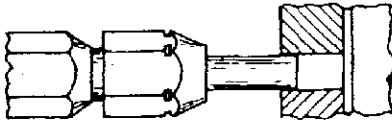


FIG. 8

INSPECTION OF WIRE BARREL -
CRIMPING BIES WITH PLUG GAGE.



"GO" gage must pass completely through the die closure.



"NO GO" gage may enter partially, but must not pass completely through the die closure.

FIG. 9

Close handles of tool until crimping jaws are bottomed. Do not apply additional pressure to tool handles. With crimping jaws bottomed, use plug gage to check the die closure. Hold gage in straight alignment with the tool and carefully try to insert, without forcing, the GO element, and then the NO-GO element. See fig. 9. The GO element must pass completely through the die closure. The NO-GO element may enter partially, but must not pass completely through the die closure. Reinstall locator assembly. If the wire barrel crimping dies meet the GO NO-GO gage conditions, the tool may be considered dimensionally correct. If you find that the tool crimping dies do not conform with the GO NO-GO gage conditions, return to AMP for repair.

DIE CLOSURE INSPECTION.

Every AMP hand tool is inspected and tested for proper die (jaw) closure before being shipped from the factory. An inspection should, however, be performed periodically to measure the tool die closure. The tool die closure inspection is accomplished using GO-NO-GO plug gages. AMP neither manufactures nor sells plug gages, however, suggested plug gage design is shown in fig. 8. The GO NO-GO dimensions of the plug gage are also listed in fig. 8. The following procedure is recommended for measuring the tool die closures.

Remove traces of oil or dirt from tool crimping area and plug gage. Reinstall locator assembly. NOTE: Do not use spring in locator assembly.