

IS 7070 IS SUPERSEDED BY IS 6615



APPLICATION AND MAINTENANCE
FOR AMP* HAND CRIMPING TOOLS
90066, 90066-2, 90066-4, 90067,
90067-2, and 90208-1



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.

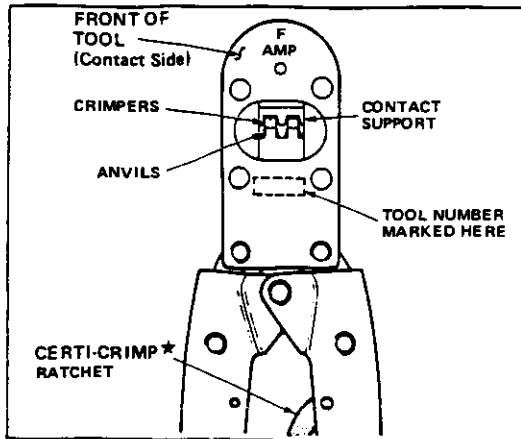


Fig. I-1

SECTION I APPLICATION

I-1. INTRODUCTION

This instruction sheet covers the use of the AMP Hand Crimping Tools which crimp the AMP Type III(+) and Type VI loose-piece pin and socket contacts listed in Figure I-3. 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 (Figure I-1 and I-4)

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 each crimp section.

Each tool features two fixed dies (crimpers), two movable dies (anvils), two crimp sections with applicable wire size markings and color code dots, a contact support, a locator/insulation stop, an ejector, and a CERTI-CRIMP ratchet.

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.

Type III(+) contacts have a color dot located on the contact spring. Type VI contacts have the applicable wire size stamped on the underside of the insulation barrel.

I-3. CRIMPING PROCEDURE

Refer to Figure I-2 and to the chart in Figure I-3 and check the selected wire, contact, and crimping tool for compatibility.

Wire size and insulation diameter must be within the specified range for the contact. Strip the wire to the length indicated — do NOT cut or nick the wire strands.

The hand crimping tool must be the one designed for crimping the wire and contact. Identify the appropriate crimp section (according to the color dot and/or wire size markings on the BACK of the tool). The color dot, or wire size markings on the contact, must match the color dot or wire size marking above the appropriate crimp section.

Refer to Figure I-4 and proceed as follows:

1. Hold tool so BACK (wire side) is facing you.
2. Make sure ratchet is released by squeezing the tool handles and allowing them to open FULLY.
3. Looking straight into BACK of appropriate crimp section, insert contact (insulation barrel first) into FRONT of crimp section. Position contact in crimpers so locator enters locator slot in contact.

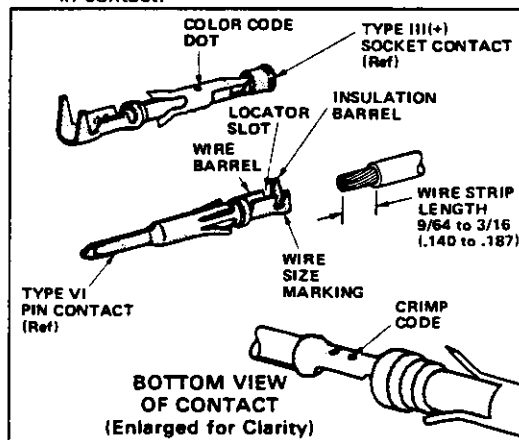


Fig. I-2

Copyright 1980, 85, 73, 78 by AMP Incorporated, Harrisburg, Pa. All rights reserved. AMP incorporated products covered by U.S. and foreign patents and/or patents pending.