



# DOUBLE ACTION HAND TOOL

DOUBLE 'F' CRIMP

PART NO. 525681

IS1095 G.B.	
RELEASED	3-1-77
REVISED	12-4-77

## INTRODUCTION

This tool has two crimping stations A and B. For wire ranges see FIG.1. It also features a Certi-Crimp Ratchet and three insulation crimp settings.

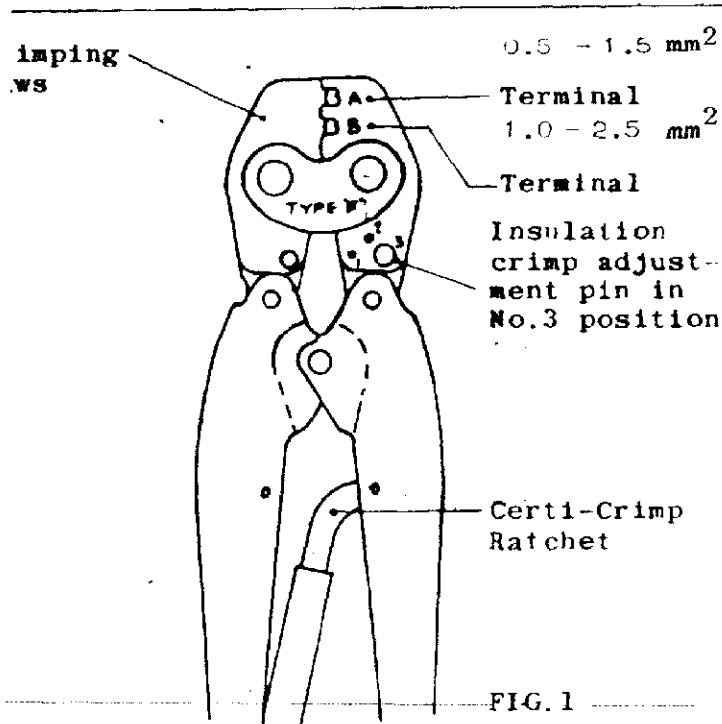


FIG. 1

## INSULATION CRIMPING ADJUSTMENT

The insulation crimping jaw has three adjustment holes marking insulation diameters i.e. 1 (small) 2 (medium) 3 (large). To alter adjustment pull pin in and reposition.

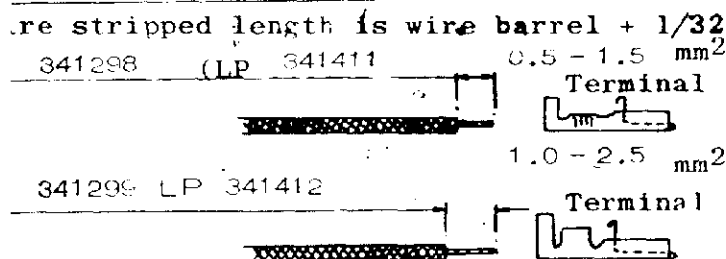


FIG. 2

## 3. CRIMPING PROCEDURE

The Certi-Crimp Ratchet ensures a complete crimp of the terminal. When you squeeze the tool handles the ratchet engages and will not release until crimp jaws are fully closed. Select correct terminal and crimp it as follows:-

1. Open the tool handles and position the terminal in the correct station with the centre of the terminal wire barrel in line with the centre of the wire barrel crimping jaw. Close handles until terminal is held in place. **DO NOT DEFORM THE WIRE BARREL OR INSULATION BARREL.**

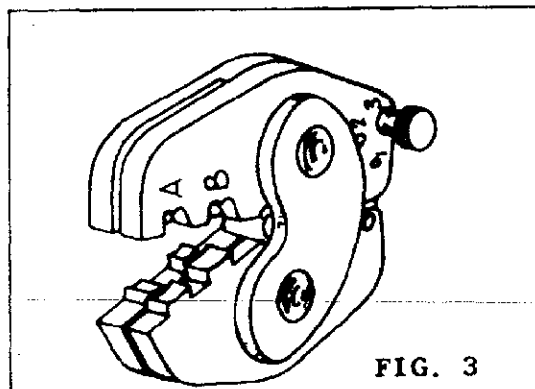


FIG. 3

2. Strip wire as shown in FIG. 2. Insert stripped wire into the terminal.
3. While you hold the wire in place squeeze the tool handles until the ratchet releases. Your crimp is finished. Open handles and remove the crimped terminal from the tool.

## SECTION 2. MAINTENANCE PROCEDURES

### 2.1 TOOL CERTIFICATION

These instructions have been approved by AMP Design, Production and Quality Control Engineers to provide you with documented maintenance and inspection procedures in accordance with AMP Corporate Policy Number 3.3. We have, through our test laboratories and inspection of production assembly, established the procedures described herein to ensure quality and reliability of AMP Hand Crimping Tools.

The parts listed on Customer Drawing are customer replaceable parts. A complete inventory should be stocked and controlled to prevent lost time when replacement of parts is deemed necessary.

### 2.2 INSPECTION PROCEDURES

#### A. Daily Maintenance

The importance of daily maintenance cannot be over emphasized, as this can easily and efficiently be performed after each shift, ensuring satisfactory performance and continuous production. We recommend the following.

1. Remove dust, moisture and other contaminants with a clean brush or soft lint-free cloth. Do not use objects that could damage the tool.
2. Make sure the proper retaining pins are in place and secured with the proper retaining rings.
3. Make certain all pins, pivot points and bearing surfaces are protected with a THIN coat of oil. If necessary, oil with any good S.A.E. No. 20 Motor Oil. DO NOT OIL EXCESSIVELY.
4. When the tool is not in use, keep the handles closed to prevent objects from becoming lodged in the crimping dies and store the tool in a clean dry area.

#### B. Periodic Inspection

Regular inspections should be performed and recorded by your Quality Control Department with a record of scheduled inspections remaining with the tool or supplied to supervisory personnel responsible for the tool. We recommend at least one inspection a month, however, frequency of inspection will depend on the amount of use, ambient working conditions, operator training and skill and your own established standards. These inspections should be performed in the following sequence.

##### 1. Visual Inspection

Remove all lubrication and accumulated film by immersing the tool (handles partially closed) in a suitable commercial de-greaser that will not effect paint or plastic material.

Make certain all retaining pins are in place and secured with retaining rings. Refer to customer drawing (-525681

Close the tool handles until the ratchet releases then allow handles to open freely. If they do not open quickly and fully, the spring is defective and must be replaced.

Inspect the head assembly, giving special attention to the dies for flattened, chipped, cracked, worn or broken areas. If damage to any part of the head assembly is evident, return the tool to AMP for evaluation and repair.

# Mouser Electronics

Authorized Distributor

Click to View Pricing, Inventory, Delivery & Lifecycle Information:

[TE Connectivity:](#)

[525681](#)