

**PROPER USE GUIDELINES**

Cumulative Trauma Disorders can result from the prolonged use of manually powered hand tools. AMP hand tools are intended for occasional use and low volume applications. AMP offers a wide selection of powered application equipment for extended-use, production operations.

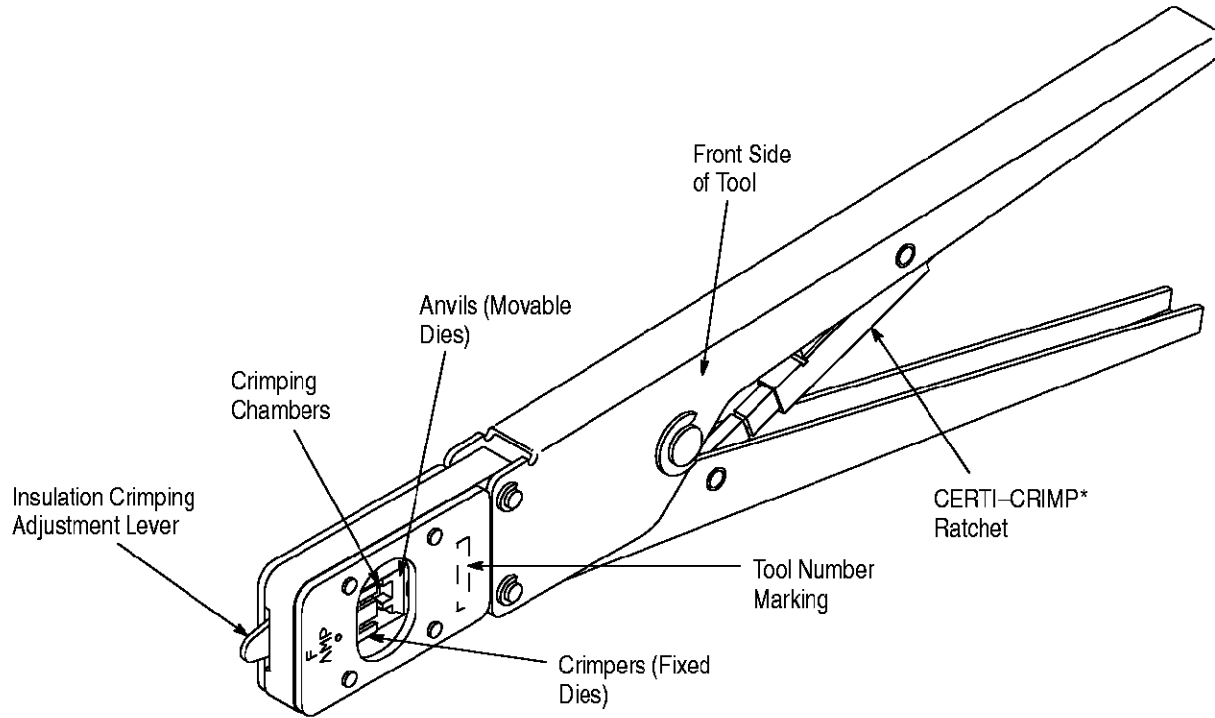


Figure 1

**1. INTRODUCTION**

AMP\* Straight Action Hand Tool 90717-2 is designed to crimp .062 Diameter Pin Contacts 794018-1 and Socket Contacts 794019-1 onto wire sizes 30 through 24 AWG with a maximum insulation diameter of 1.52 mm [.060 in.].

For additional information on the contacts, refer to AMP Catalog 82181. Read these instructions thoroughly before using the hand tool.

**NOTE** *Dimensions on this sheet are in metric units [with U.S. customary equivalents in brackets].*

Reasons for reissue of this instruction sheet can be found in Section 7, REVISION SUMMARY.

**2. DESCRIPTION**

The hand tool features a head with two crimpers (fixed dies), two anvils (movable dies), an insulation crimping adjustment lever, a contact support, a locator/wire stop, an ejector, and a CERTI-CRIMP ratchet. The FRONT side of the tool, into which the contact is inserted, has the tool number marked on it.

The wire is inserted from the BACK side of the tool which is marked above each crimping chamber with the wire size range. See Figure 1.

The insulation crimping adjustment lever is used to regulate the crimp height of the contact insulation barrel. The contact support prevents the contact from bending during the crimping procedure.

The locator/wire stop positions the contact between the dies and aids in locating the wire in the contact. In use, it rests in the contact locator slot. The ejector pulls the locator down and ejects the crimped contact when the tool handles are fully opened.

The CERTI-CRIMP ratchet ensures full crimping of the contact. Once engaged, the ratchet will not release until the tool handles have been FULLY closed.

**CAUTION** *The crimping dies bottom before the CERTI-CRIMP ratchet releases. This design feature ensures maximum electrical and tensile performance of the crimp. Do NOT re-adjust the ratchet.*

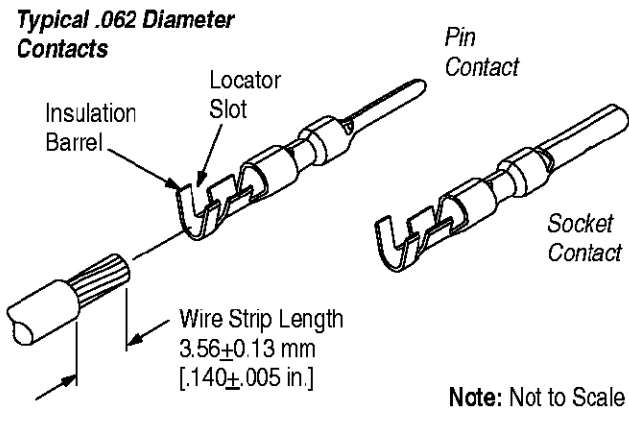


Figure 2

**3. CRIMPING PROCEDURE**

Select the appropriate wire size and contact for the hand tool. The wire size and insulation diameter must be within the specified range for the contact.

Strip the wire to the length indicated in Figure 2. Do NOT nick or cut the wire strands. Proceed as follows:

1. Hold tool so that the BACK side is facing you.
2. Close the tool handles together until the CERTI-CRIMP ratchet releases, then allow the handles to open fully.
3. Insert the contact insulation barrel from the FRONT side of the tool into the appropriate crimping chamber. Position the contact on the anvils so that the locator/wire stop enters the

contact locator slot. Make sure that it is flush with the edge of the die. See Figure 3.

4. Holding the contact in place, squeeze the tool handles together just enough to hold the contact in the crimping chamber.

**NOTE** Do NOT deform the contact insulation barrel or wire barrel.

5. Insert stripped wire through the locator and into the contact wire barrel. The wire should extend slightly beyond the end of the wire barrel and the wire insulation should butt against the locator/wire stop.

6. Holding the wire in place, squeeze tool handles together until CERTI-CRIMP ratchet releases.

7. Allow tool handles to open FULLY and remove crimped contact from tool.

**NOTE** For information on inspection of crimped contact, refer to Application Specification 114-1013.

**4. INSULATION CRIMPING ADJUSTMENT**

The hand tool has three insulation crimping adjustment positions to adjust the wire insulation grip: 1—Tight, 2—Medium, and 3—Loose. To determine the proper insulation crimp setting, proceed as follows:

1. Slide the insulation crimping adjustment lever to Position 3 (marked on the back side of the tool). Refer to Figure 3.

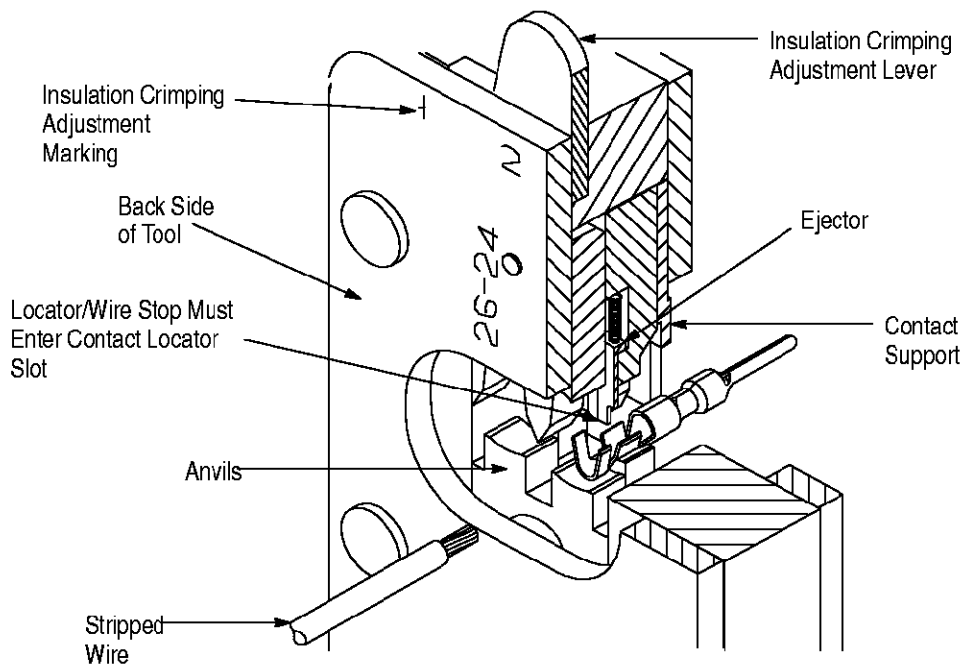


Figure 3



Proceed as follows:

1. Select a contact and *maximum* size wire for the crimping chamber.
2. Refer to Section 3, CRIMPING PROCEDURE, and crimp contact accordingly.
3. Using a crimp height comparator, measure the wire barrel crimp height as shown in Figure 4. If the crimp height conforms to that height, the tool is considered dimensionally correct. If not, the tool must be returned to AMP for evaluation and repair. See Section 6, REPLACEMENT AND REPAIR.

For additional information concerning the use of the crimp height comparator, refer to AMP Instruction Sheet 408-7424.

#### D. CERTI-CRIMP Ratchet Inspection

The CERTI-CRIMP ratchet feature on AMP hand tools should be checked to ensure that the ratchet does not release prematurely, allowing the dies to open before they have fully bottomed. Obtain a 0.025-mm [.001-in.] shim that is suitable for checking the clearance between the bottoming surfaces of the crimping dies and proceed as follows:

1. Select a contact and *maximum* size wire for the hand tool.
2. Position the contact and wire between the crimping dies, as described in Section 3, CRIMPING PROCEDURE.
3. Holding the wire in place, squeeze the handles until the CERTI-CRIMP ratchet releases. Hold the handles in this position, maintaining just enough tension to keep the dies closed.

4. Check the clearance between the bottoming surfaces of the crimping dies. If the clearance is 0.025 mm [.001 in.] or less, the ratchet is satisfactory. If clearance exceeds 0.025 mm [.001 in.], the ratchet is out of adjustment and must be repaired. See Section 6, REPLACEMENT AND REPAIR.

#### 6. REPLACEMENT AND REPAIR

The parts listed in Figure 5 are customer-replaceable. A complete inventory can be stocked and controlled to prevent lost time when replacement of parts is necessary. Order replacement parts through your AMP representative, or call 1-800-526-5142, or send a facsimile of your purchase order to 717-986-7605, or write to:

CUSTOMER SERVICE (38-35)  
AMP INCORPORATED  
PO BOX 3608  
HARRISBURG PA 17105-3608

Parts other than those specified in Figure 5 must be replaced by AMP to ensure reliability of the tool.

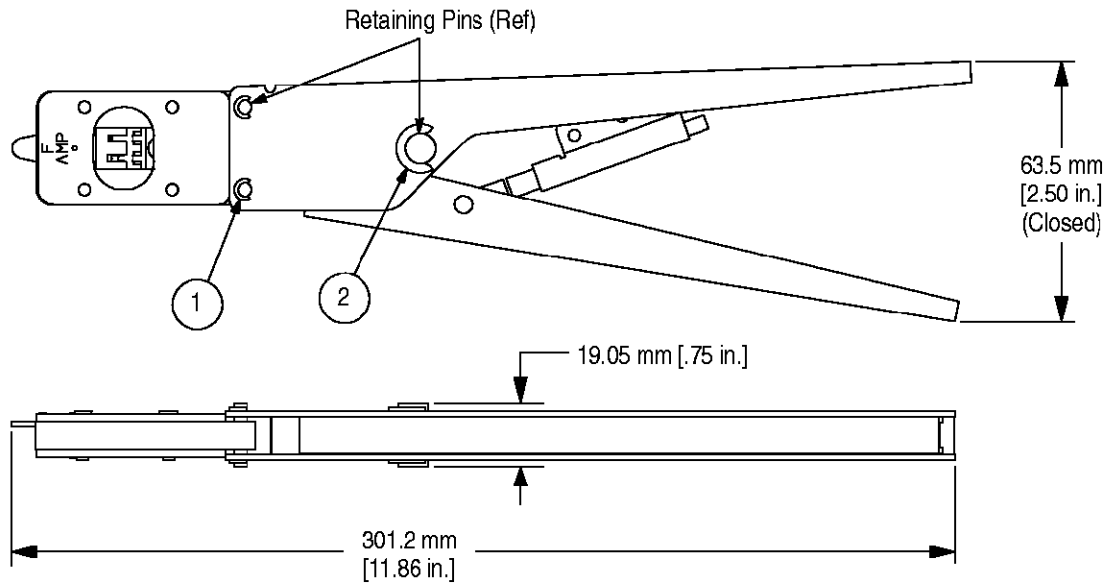
Tools may be returned to AMP for evaluation and repair. For tool repair service, contact an AMP representative at 1-800-526-5136.

#### 7. REVISION SUMMARY

The following changes were made since the previous release of this instruction sheet:

Per EC 0990-0808-99

- Changed tool repair service information in Section 6, REPLACEMENT AND REPAIR
- Updated document format



Weight: 539 g [1 lb 4 oz]

**REPLACEMENT PARTS**

ITEM	PART NUMBER	DESCRIPTION	QTY PER TOOL
1	21045-3	RING, Retaining	4
2	21045-6	RING, Retaining	2

Figure 5