

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.

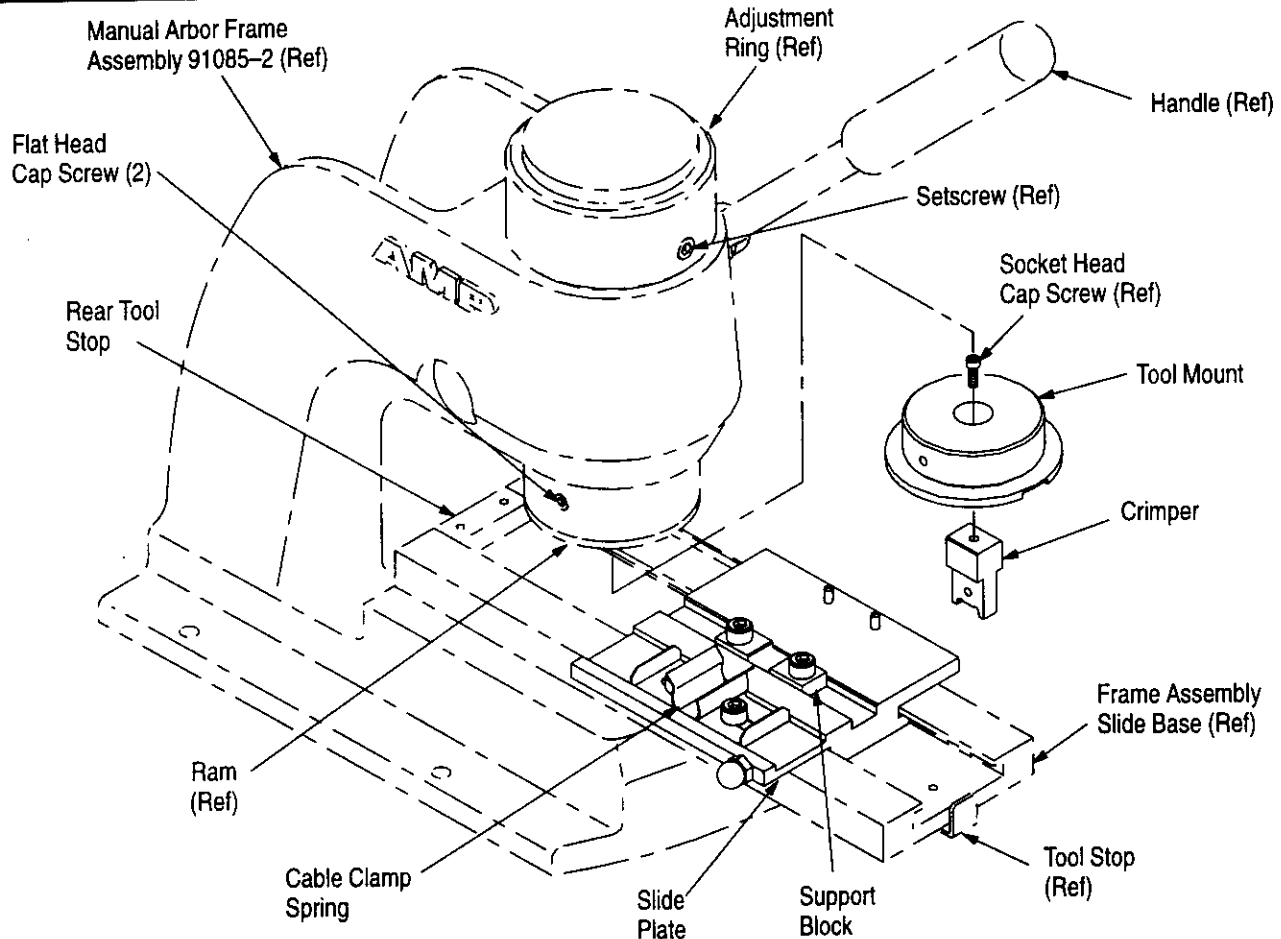


Figure 1

1. INTRODUCTION

The 0.8 mm CHAMP Crimper Assembly is designed for use in AMP Manual Arbor Frame Assembly 91085-2 (shown in Figure 1) and is used to crimp metal backshell assemblies onto 0.8 mm CHAMP connectors. This instruction sheet provides procedures for crimper assembly installation, adjustments, crimping, and maintenance and inspection. Refer to instruction sheet 408-7777 for details concerning the operation and maintenance of the arbor frame assembly. For details concerning product specifications, contact AMP Product Engineering.

Read these instructions thoroughly before crimping any connectors.

Refer to Section 8 for Revision Summary.

NOTE

Dimensions on this sheet are in millimeters [with inches in brackets].

2. DESCRIPTION

The crimper assembly (shown in Figure 1) consists of an upper and lower tooling assembly. The upper tooling assembly features a tool mount and a crimper. The crimper is secured to the tool mount, which is mounted to the ram of the arbor frame assembly with the socket head cap screws supplied with the crimper assembly.

The lower tooling assembly consists of a slide plate, a support block, and a cable clamp spring. The assembly mates with the slide base of the arbor frame assembly.

3. INSTALLATION OF CRIMPER ASSEMBLY

To install the crimper assembly, refer to Figure 1 and proceed as follows:

NOTE

The frame assembly must be secured to a work bench to ensure stability during operation.

3.1. Lower Tooling Assembly

1. Remove the tool stop from the slide base of the arbor frame assembly.
2. Slide lower tooling assembly into the tracks of the frame assembly slide base. The cable clamp spring must be oriented to the left side of the slide base, as shown in Figure 1.
3. Re-install tool stop and secure it with the socket head cap screw.

3.2. Upper Tooling Assembly

1. Remove the upper tool mount (supplied with the arbor frame assembly) by removing the two flat head cap screws. Do not discard this tool mount.
2. Install the tool mount (supplied with the crimper assembly) to the ram of the arbor frame assembly and secure it with the flat head cap screws.
3. Position the crimper in the tool mount with the longer offset to the right (as shown in Figure 1). Secure crimper to tool mount with the socket head cap screw.

4. TOOLING ADJUSTMENTS

The following adjustments are required during the initial setup of the crimper assembly and when changing cable size.

4.1. Cable Clamp Springs

The cable clamp springs can be adjusted for various cable diameters by loosening the socket head cap screws and repositioning the cable clamp springs.

4.2. Crimp Height

To check crimp height, a test crimp should be made (refer to Section 5, CRIMPING PROCEDURE) then the crimp height of the backshell ferrule should be measured. Refer to the appropriate application specification (114-series) for crimp height. If the actual crimp height does not conform to this dimension, adjust the ring on the frame assembly. Loosen setscrew on adjustment ring. Turn ring **CLOCKWISE** to increase crimp height or **COUNTERCLOCKWISE** to decrease crimp height. Re-tighten setscrew after ring is properly adjusted.

5. CRIMPING PROCEDURE

Refer to Figure 2 and proceed as follows:

1. Using the ball handle, slide lower tooling assembly out from under ram of arbor frame assembly.
2. Position the CHAMP connector backshell assembly in the support block.
3. Secure cable in cable clamp spring.
4. Slide lower tooling assembly back against rear tool stop of arbor frame assembly.
5. To crimp metal backshell onto cable, lower ram with handle until adjustment ring is flush with the top of the arbor frame assembly.
6. After connector is crimped, use handle to raise ram; then slide lower tooling assembly out from under ram. Remove the connector.

6. MAINTENANCE AND INSPECTION PROCEDURE

AMP recommends that a maintenance and inspection program be performed periodically to ensure dependable and uniform terminations. Frequency of inspection depends on:

1. The care, amount of use, and handling of the crimper assembly.
2. The presence of abnormal amounts of dust and dirt.
3. The degree of operator skill.
4. Your own established standards.

The crimper assembly is inspected before being shipped; however, AMP recommends that the assembly be inspected immediately upon its arrival at your facility to ensure that it has not been damaged during shipment. Due to the precision design, it is important that no parts of the crimper assembly be interchanged except those replacement parts listed in Figure 3.

See instruction sheet 408-7777 for information on the care of the Manual Arbor Frame Assembly.

6.1. Daily Maintenance

1. Remove dust, moisture, and other contaminants with a clean brush, or a soft, lint-free cloth. Do NOT use objects that could damage the crimper assembly.
2. Make certain that upper and lower subassemblies and cable clamp springs are in place and properly secured.
3. When the assembly is not in use, store it in a clean, dry area.

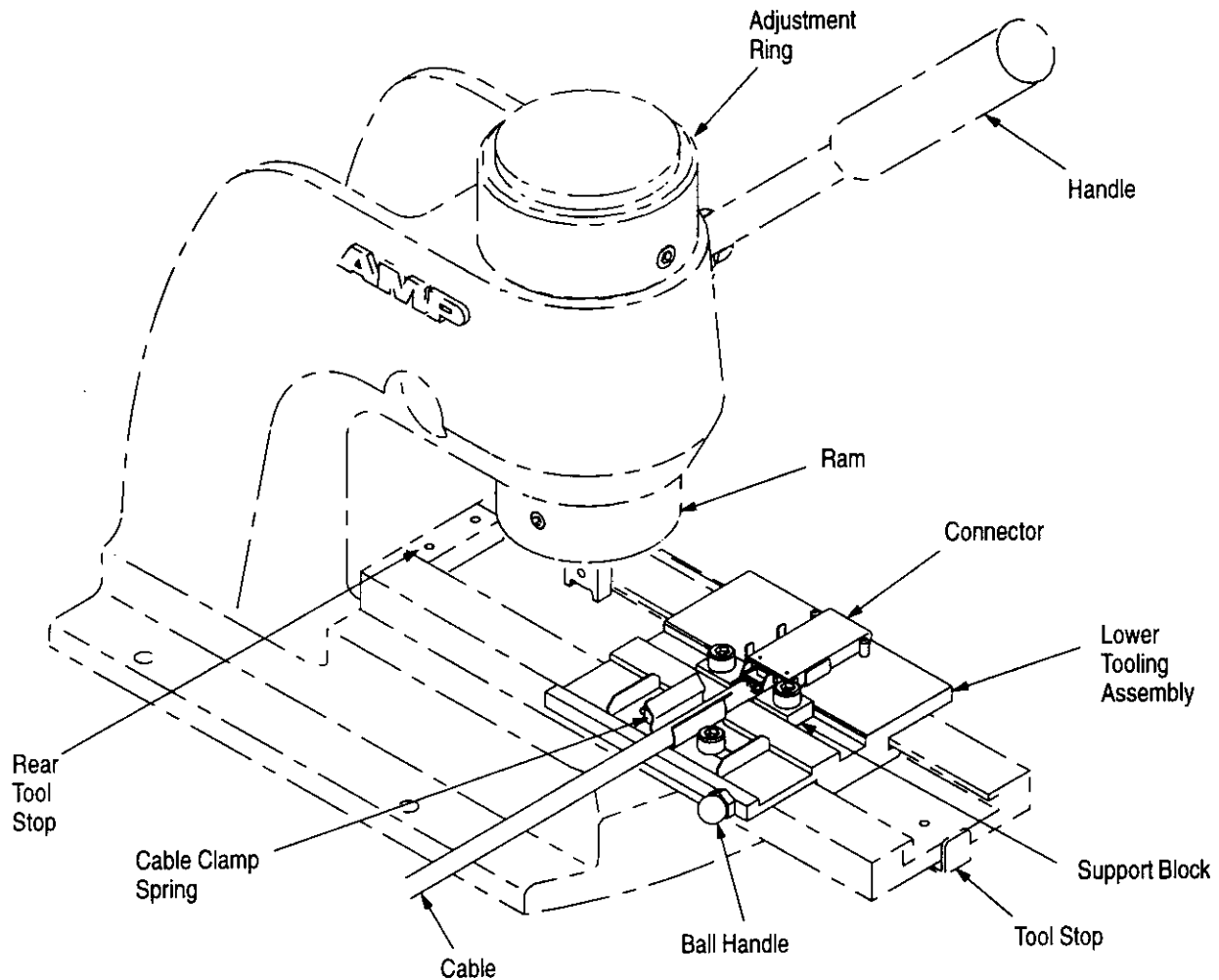


Figure 2

6.2. Periodic Inspection

1. Remove all lubrication and accumulated film with a suitable commercial degreaser that will not affect paint or plastic material.
2. Make certain that all assembly components are in place. If replacements are necessary, refer to Section 7, REPLACEMENT AND REPAIR.
3. Inspect crimper assembly for worn, cracked, chipped, or broken areas. If damage is evident, return the assembly to AMP for evaluation and repair. See Section 7, REPLACEMENT AND REPAIR.

7. REPLACEMENT AND REPAIR

Replacement parts are listed in Figure 3. Parts other than those listed in Figure 3 should be replaced by AMP to ensure quality and reliability of the tool. Order replacement parts through your AMP representative, or call 1-800-526-5142, or send a facsimile of your purchase order to 1-717-986-7605, or write to:

CUSTOMER SERVICE (38-35)
AMP INCORPORATED
P.O. BOX 3608
HARRISBURG, PA 17105-3608

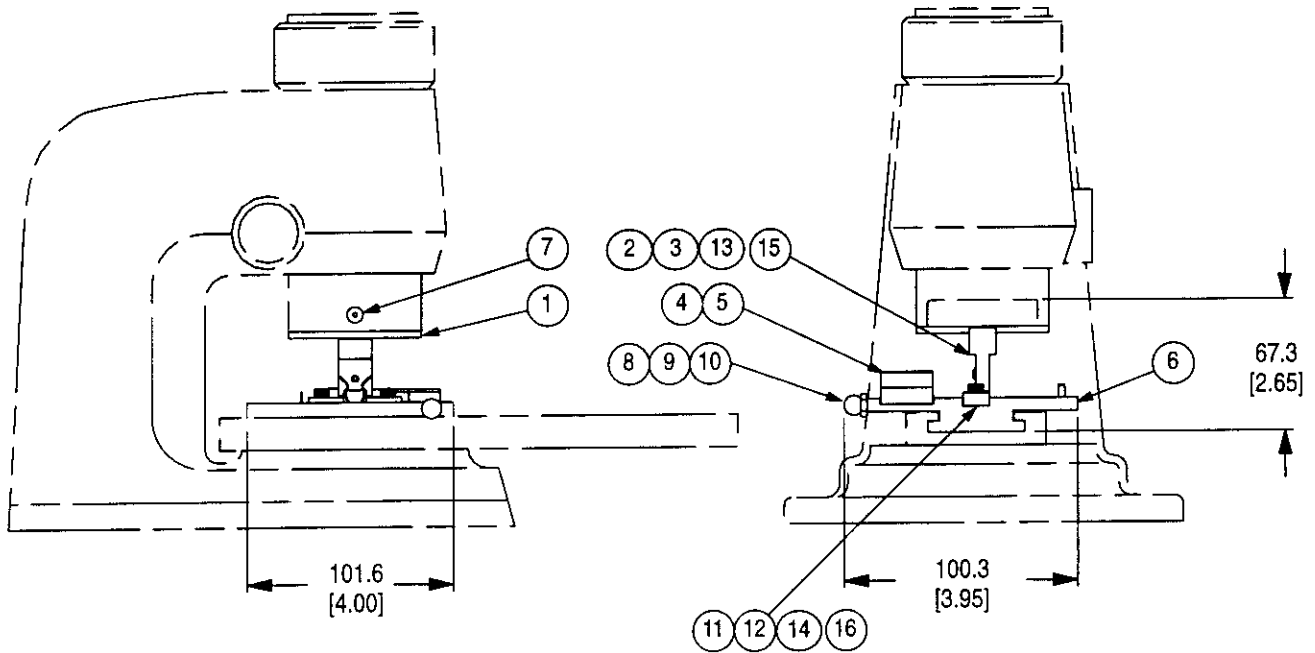
For repair service, return the assembly, with a written description of the problem, to:

CUSTOMER REPAIR (01-12)
AMP INCORPORATED
1523 NORTH 4TH STREET
HARRISBURG, PA 17102-1604

8. REVISION SUMMARY

Revisions to this document are per EC-0150-3365-95:

- Added 122842-2 and 122842-3 to document title
- Added 189544-1, 189544-2, 89543-1, and 189543-2 to Figure 3.



WEIGHT: 1.36 kg [3.0 lbs.]

REPLACEMENT PARTS

ITEM	PART NUMBER	DESCRIPTION	QTY PER ASSY		
			122842-1	122842-2	122842-3
1	527246-1	TOOL MOUNT	1	1	1
2	122839-1	CRIMPER, 50 Posn	1	—	—
3	2-21000-6	SCREW, SHC 8-32 x .38	1	1	1
4	543156-1	SPRING, Cable Clamp	2	2	2
5	2-21000-5	SCREW, SHC 8-32 x .25	2	2	2
6	856593-1	SLIDE	1	1	1
7	1-21003-9	SCREW, FHC 6-32 x .32	2	2	2
8	23673-1	HANDLE, Ball	1	1	1
9	21018-7	NUT, Hex 10-32	1	1	1
10	5-21012-4	SCREW, Set 10-32 x .50	1	1	1
11	122841-1	BLOCK, Support, 50 Posn	1	—	—
12	2-21000-7	SCREW, SHC 8-32 x .50	1	1	1
13	189544-1	CRIMPER, 68 Posn	—	1	—
14	189543-1	BLOCK, Support, 68 Posn	—	1	—
15	189544-2	CRIMPER, 36 Posn	—	—	1
16	189543-2	BLOCK, Support, 36 Posn	—	—	1

Figure 3