OPERATING INSTRUCTIONS FOR AMPHENOL® PRESS TYPE CRIMPING TOOLS

GENERAL

This instruction sheet contains descriptions of crimping tools used to crimp size 0, 4 and 8 AN/MS and Type F contacts. It also includes instructions for use of the tools in crimping these contacts.

DESCRIPTION

In order to minimize contact wirewell deformation in crimping size 0, 4 and 8 contacts, it is necessary to use multi-indentor crimping tools which usually require power applications. A series of dies and kits have been established for use with available commercial equipment. Descriptions of these dies and kits and their applications follow.

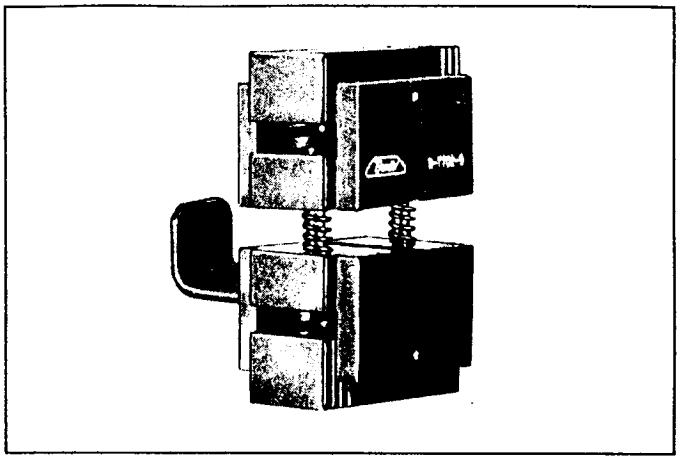

Figure I. 11-8447 Die and Locator Assembly

11-8447 DIE AND LOCATOR ASSEMBLY

This assembly may be used with an hydraulic pump incorporating a Thomas and Betts swivel head as shown in Figures I and II. See Table I for applications.

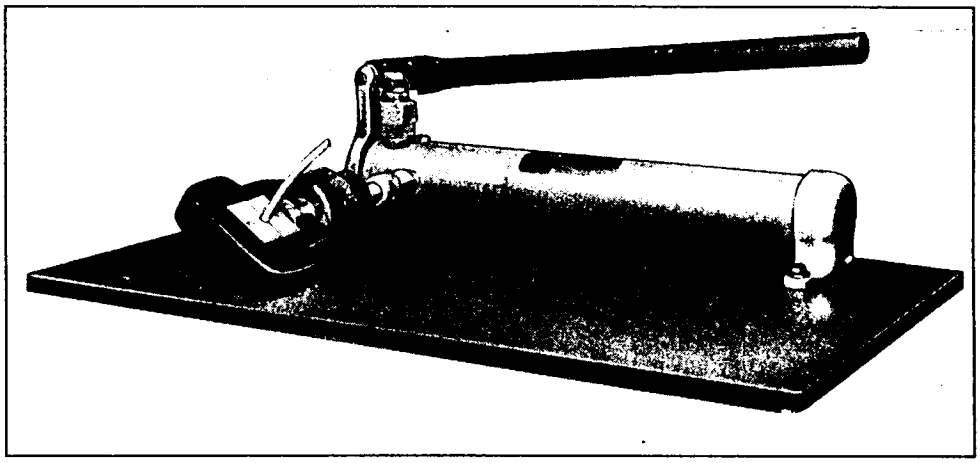

Figure II. 11-8447 Die and Locator Assembly in Thomas and Betts Swivel Head with Thomas and Betts Hydraulic Pump**

TABLE I: Applications for 11-8447 Die and Locator Assembly

Die and Locator Assembly	Die Assembly	Locator	Contact		Pin Part Number	Socket Part Number
			Size	Type		
11-8447-4	11-7702-4	11-7740-1	0	F	10-305126-1X	10-305127-1X
11-8447-5	11-7702-5	11-7740-2	4	F	10-305126-4X	10-304127-4X
11-8447-6	11-7702-6	11-7740-3	8	F	10-305126-8X	10-305127-8X
11-8447-7	11-7702-7	11-7740-4	0	AN	10-40562	10-40563
11-8447-8	11-7702-8	11-7740-5	4	AN	10-40564	10-40565
11-8447-9	11-7702-9	11-7740-5	8	AN	10-40792	10-40793

* These parts may be purchased from the Thomas & Betts Company, 2838 Butler Street, Elizabeth, NJ.
Swivel Head is Thomas & Betts catalog number 13642
Hydraulic Pump is Thomas & Betts catalog number 13584

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INSTRUCTIONS FOR USE OF THE CRIMPING TOOLS

PREPARATION OF WIRE

Cut wire to length and strip insulation appropriate distance from the end according to contact type and size. See Table IV. Hot wire stripping methods are recommended where possible. If other methods are employed, use extreme care to avoid nicking or cutting wire strands.

TABLE IV: Stripping Dimensions

Contact Size	Contact Type	Stripping Dimension
0	AN	0.563
4	AN	0.563
8	AN	0.563
0	F	0.125
4	F	0.875
8	F	0.688

Make certain strands are not separated. If necessary, reform by lightly twisting the strands together.

CRIMPING

Insert stripped end of wire into the contact wirewell. Apply a slight pressure to wire to ensure that it is fully bottomed in wirewell. Make certain that the strands are visible in the inspection hole provided in wirewell.

Insert contact and wire into the tool as far as possible. Make certain contact is adjacent to locator. Close crimping dies fully to form a uniform two indent crimp. The side rail will show when dies are completely closed. (Refer to Figure IV).

NOTE: The nut on the 11-7739 holder assembly of the 11-7838 crimping tool can be pre-set and locked into position while the dies are in fully closed position. When nut is pre-set and locked, it acts as an additional gage during crimping operations for determining when the dies are completely closed.

Make certain that contacts are properly crimped and wire is visible in the inspection hole in contact wirewell.

GAGING

To determine whether a tool is crimping within the crimp depth range for a given contact size, follow this procedure:
Use gage pins for checking the "GO", "NO-GO" limits for contact size 8, 4 and 0. See Table V below.

TABLE V: Crimp Depth Range

Contact Size	When using a "GO" Gage	When using a "NO-GO" Gage
8 and 4	0.125	0.140
0	0.165	0.180

"GO" Gaging Instructions

Insert the "GO" gage into the crimping dies in the same manner as a contact. The gage shall pass between the indenters.

"NO-GO" Gaging Instructions

Insert the "NO-GO" gage in the same manner. The gage pin shall not move between the indenters. If the gage pin passes between the indenters, the tool has exceeded the crimp depth range (Table V) and must be replaced. Failure to replace the tool will result in crimped joints which will not meet the minimum tensile strength requirements recommended by Amphenol. See Table VI for these recommended tensile strengths.

TABLE VI: Tensile Strength

Contact Size	Tensile Strength (lbs. min.)
8	185
4	450
0	800

For further information consult:

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