AMP INCORPORATED
Harrisburg, Pa. 17105

AMP * AMPLIVERSAL * CRIMPING
TOOL NO. 825508-5

IS 2746	
RELEASED	10—10—80
REVISED	

1. INTRODUCTION

This tool, shown in Figure 1, is used to crimp:

- PIDG * terminals and butt splices on stranded copper wire sizes 22 thru 10 AWG.

- PLASTI-GRIP * terminals and butt splices on solid or stranded copper wire sizes 22 thru 10 AWG.

2. CUT WIRE

Insert wire in cutter, close handles briskly.

3. GAGE WIRE

Determine wire size by inserting unstripped wire into the smallest color coded gage ring that will accept the wire. See Figure 2. After stripping, use the adjacent crimp closure to crimp terminal or splice on wire.

4. STRIP WIRE

Partially open handles and insert wire in correct notch of wire stripping blades. End of wire must butt against strip length locator (controls strip length). See Figure 3.

Close handles fully and rotate tool part way around the wire. Pull wire from tool.

NOTE: *Be sure there are no cut or missing conductor strands.*

5. COLOR CODE

Select the correct color coded terminal or splice for the wire size being used.

Red = AWG 22-16 (0.25—1.5mm²)
Blue = AWG 16-14 (1.5—2.5mm²)
Yellow = AWG 12-10 (4—6mm²)

6. CRIMP TERMINAL OR SPLICE

(a) Insert color coded terminal or splice in crimp closure adjacent to the matching color coded wire gage ring.

(b) Position terminal or splice in crimp closure as shown in Figure 4 or 5.

(c) Partially close handles to hold terminal or splice firmly in die closure.

(d) Insert stripped wire into terminal until end of conductor is at least flush with or extended slightly beyond end of terminal wire barrel.

Insert stripped wire into splice until end of conductor butts against splice wire stop.

NOTE: *Do not use wires with nicked or missing conductor strands.*

(e) Close handles fully, then open handles by depressing release lever.

(f) To crimp other half of splice, remove it and reposition uncrimped half in tool as shown in Figure 5. Follow same procedure used to crimp first half of splice. If splice cannot be turned, turn tool around.

(g) Refer to Figure 6 for terminal or splice crimp inspection procedure.
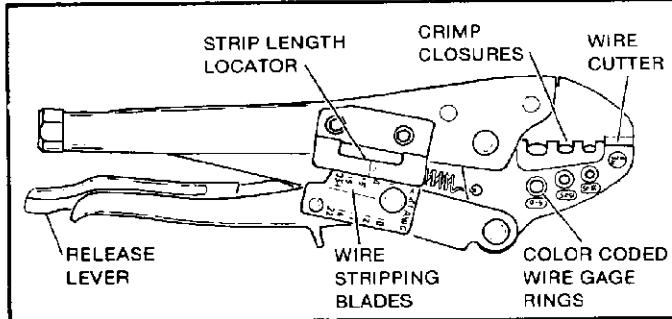

Figure 1
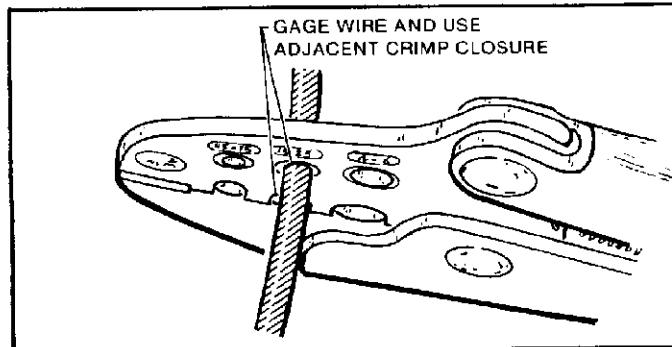
Figure 2
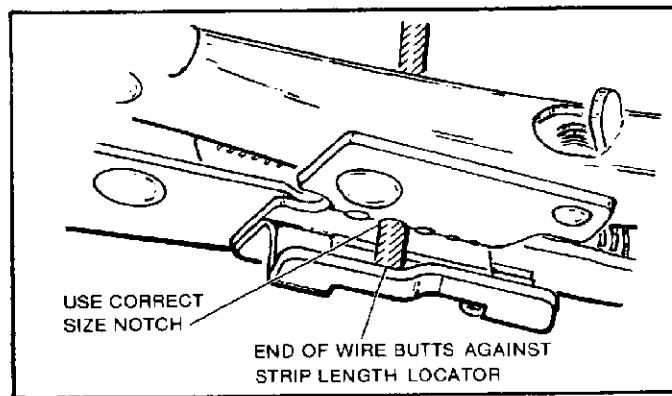
Figure 3
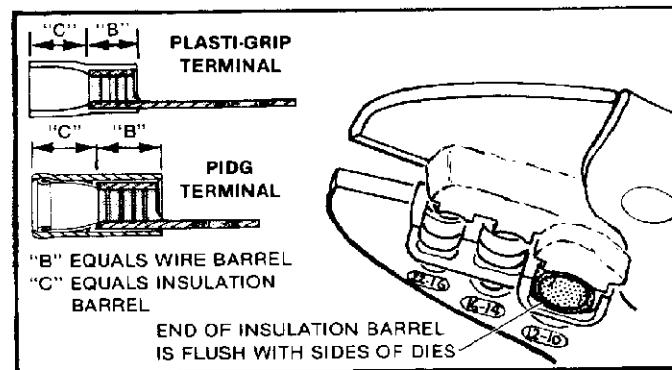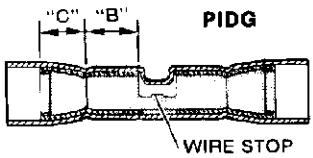
"B" EQUALS WIRE BARREL
"C" EQUALS INSULATION BARREL

Figure 4

* Trademark of AMP Incorporated

BUTT SPLICES

PIDG

"C" "B"

WIRE STOP

PLASTI-GRIP

"C" "B"

WIRE STOP

"B" EQUALS WIRE BARREL
"C" EQUALS INSULATION BARREL

AWG

END OF INSULATION
BARREL IS FLUSH
WITH SIDES OF DIES

END OF INSULATION
BARREL IS FLUSH
WITH SIDES OF DIES

Figure 5

ACCEPT

REJECT

PIDG &
PLASTI-GRIP
TERMINALS

② WIRE RANGE
STAMPED HERE

② WIRE RANGE
STAMPED HERE

WIRE STOP
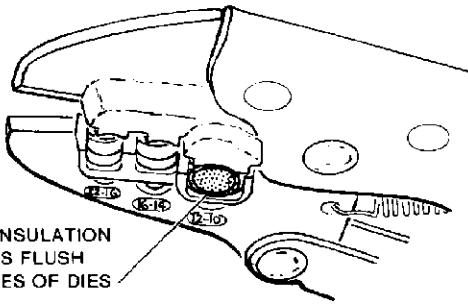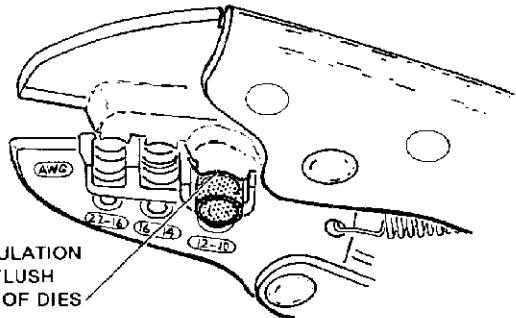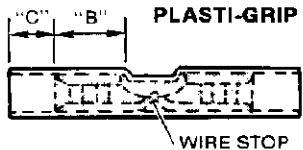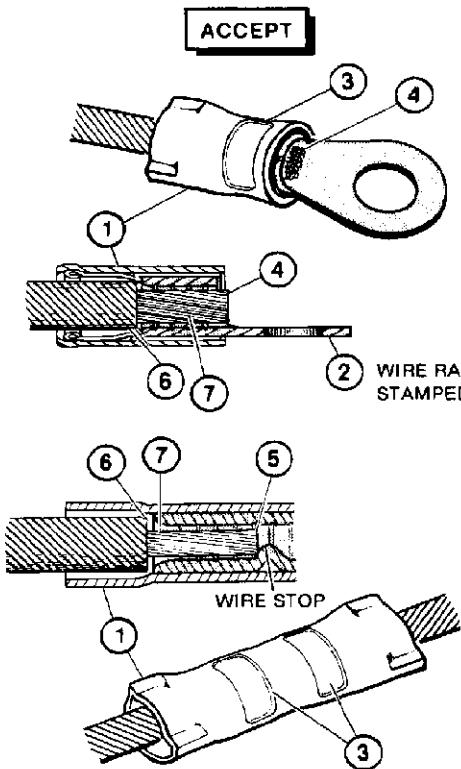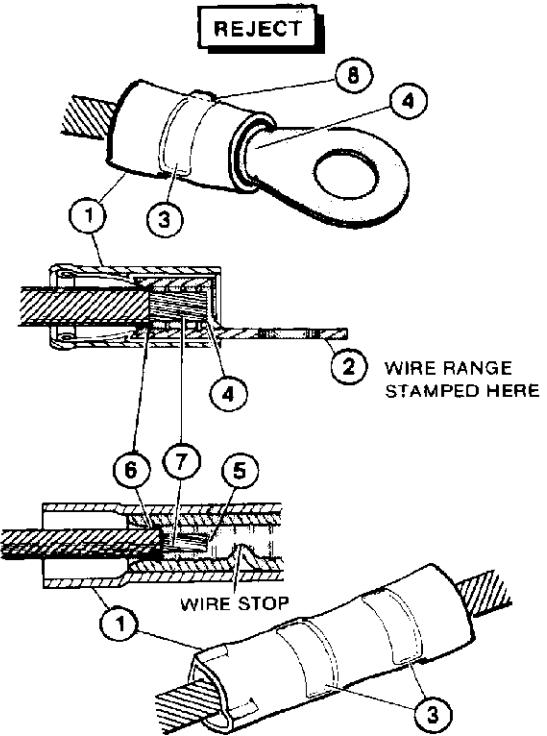
PIDG &
PLASTI-GRIP
BUTT SPLICES

WIRE STOP

① Correct insulation color code, and die closure combination.

② Wire size is within wire range stamped under terminal tongue or on center of PIDG splice.

③ Crimp centered on wire barrel.

④ End of conductor is flush with, or extends beyond end of terminal wire barrel.

⑤ End of conductor against wire stop of splice.

⑥ Wire insulation does not enter wire barrel.

⑦ No nicked or missing conductor strands.

① Wrong insulation color code and die combination. See paragraph 6, step (a).

② Wire size is not within wire range stamped on terminal tongue or PIDG splice.

③ Crimp not centered on wire barrel. (End of terminal or splice was not flush with side of dies). See Figure 4 or 5.

④ End of conductor is not flush with or extending beyond end of terminal wire barrel (Check for correct strip length).

⑤ End of conductor not against wire stop of splice.

⑥ Wire insulation entered wire barrel.

⑦ Nicked or missing conductor strands.

⑧ Excessive flash or extruded insulation, (wrong die closure, terminal or splice combination, or damaged dies).

Figure 6