

DIE ASSY PART NO.	WIRE SIZE				TERMINAL		
	mm ²	(AWG)	INS. DIA (Max)		SERIES	PART NO. (STRIP)	HOUSING COLOR
			mm	IN.			
58269-1	0.13 -0.3	26-22	2.54	.100	110	7-520365-2	VIOLET
58269-2	0.3 -0.8	22-18	3.05	.120	110	2-520080-2	RED
	0.3 -0.8	22-18	3.05	.120	110	2-520083-2	RED
	0.3 -0.8	22-18	3.05	.120	110	2-520272-2	RED
	0.3 -0.8	22-18	5.84	.230	110	2-520306-2	RED
	0.3 -0.8	22-18	5.84	.230	110	2-520310-2	RED
	0.3 -0.8	22-18	3.43	.135	187	2-520181-2	RED
	0.3 -0.8	22-18	3.43	.135	187	2-520193-2	RED
	0.3 -0.8	22-18	5.84	.230	187	2-520261-2	RED
	0.3 -0.8	22-18	5.84	.230	187	2-520274-2	RED
	0.3 -0.8	22-18	3.43	.135	250	2-520183-2	RED
	0.3 -0.8	22-18	3.43	.135	250	2-520102-2	RED
	0.3 -0.8	22-18	5.84	.230	250	2-520263-2	RED
58269-3	1.25 -2.0	16-14	6.60	.260	110	3-520370-2	BLUE
	1.25 -2.0	16-14	4.16	.160	187	3-350815-2	BLUE
	1.25 -2.0	16-14	4.16	.160	187	3-520124-2	BLUE
	1.25 -2.0	16-14	6.60	.260	187	3-520150-2	BLUE
	1.25 -2.0	16-14	4.16	.160	250	3-350819-2	BLUE
	1.25 -2.0	16-14	4.16	.160	250	3-520116-2	BLUE
	1.25 -2.0	16-14	4.16	.160	250	3-520106-2	BLUE
	1.25 -2.0	16-14	6.60	.260	250	3-520140-2	BLUE
58269-4	3.0	12	9.14	.320	250	4-520447-2	YELLOW
58269-5	5.0	10	9.14	.320	250	4-520447-2	YELLOW

Fig. 1

85-235, 85-240

1. INTRODUCTION

This instruction sheet (IS) covers the use of AMP Die Assemblies 58269-1 through -5. These dies are

designed for use in the AUTO-PRO* Machine No. 818380-1 and Applicator No. 818058-2 to crimp the Ultra-Fast Fully Insulated FASTON* terminals listed in Figure 1.

This instruction sheet covers terminal and wire specifications, maintenance and inspection procedures, and general performance of the crimping die assemblies.

For information concerning AUTO-PRO Machine, refer to Instruction Sheet IS 9491. For information concerning applicator No. 818058-2, used to terminate Ultra-Fast Fully Insulated FASTON terminals, refer to AI 8092.

NOTE

All dimensions on this document are in metric units [with U. S. customary units in brackets].

2. DESCRIPTION

Each die assembly consists of one stationary die (anvil) and one moving die (crimper). The stationary die features a die holding screw and is marked with the part number of the die assembly. The moving die also contains a die holding screw and is marked with the part number, wire size range, and terminal type markings.

The terminal's translucent insulation is available in four colors: violet, red, blue, or yellow. Each corresponds with a particular wire size range: See Figure 1.

3. DIE INSTALLATION

The anvils and crimpers can be installed and removed from the machine by tightening or loosening the die holding screws.

DANGER

Before installing or removing the dies, MAKE SURE that machine power is disconnected.

Install the die assembly according to instructions given in AI 8092, packaged with the applicator.

4. CRIMPING PROCEDURES

Select the proper die assembly from the chart in Figure 1. Strip the wire to the length indicated in Figure 1. DO NOT cut or nick the wire strands.

Refer to AI 8092 for procedures on crimping the terminal to the wire.

5. MAINTENANCE/INSPECTION

AMP Crimping Die Assemblies shown in Figure 2 were inspected prior to shipment. The following quality control procedures should be followed to insure continued reliability of the AMP Crimping Die Assemblies.

Customer replaceable parts are listed in Figure 2. A complete inventory should be stocked and controlled

to prevent lost time when replacement of parts is necessary.

DANGER

Before performing any maintenance or inspection, MAKE SURE that machine power is disconnected.

5.1. Daily Maintenance

It is recommended that each operator be aware of -- and responsible for -- the following steps of daily maintenance:

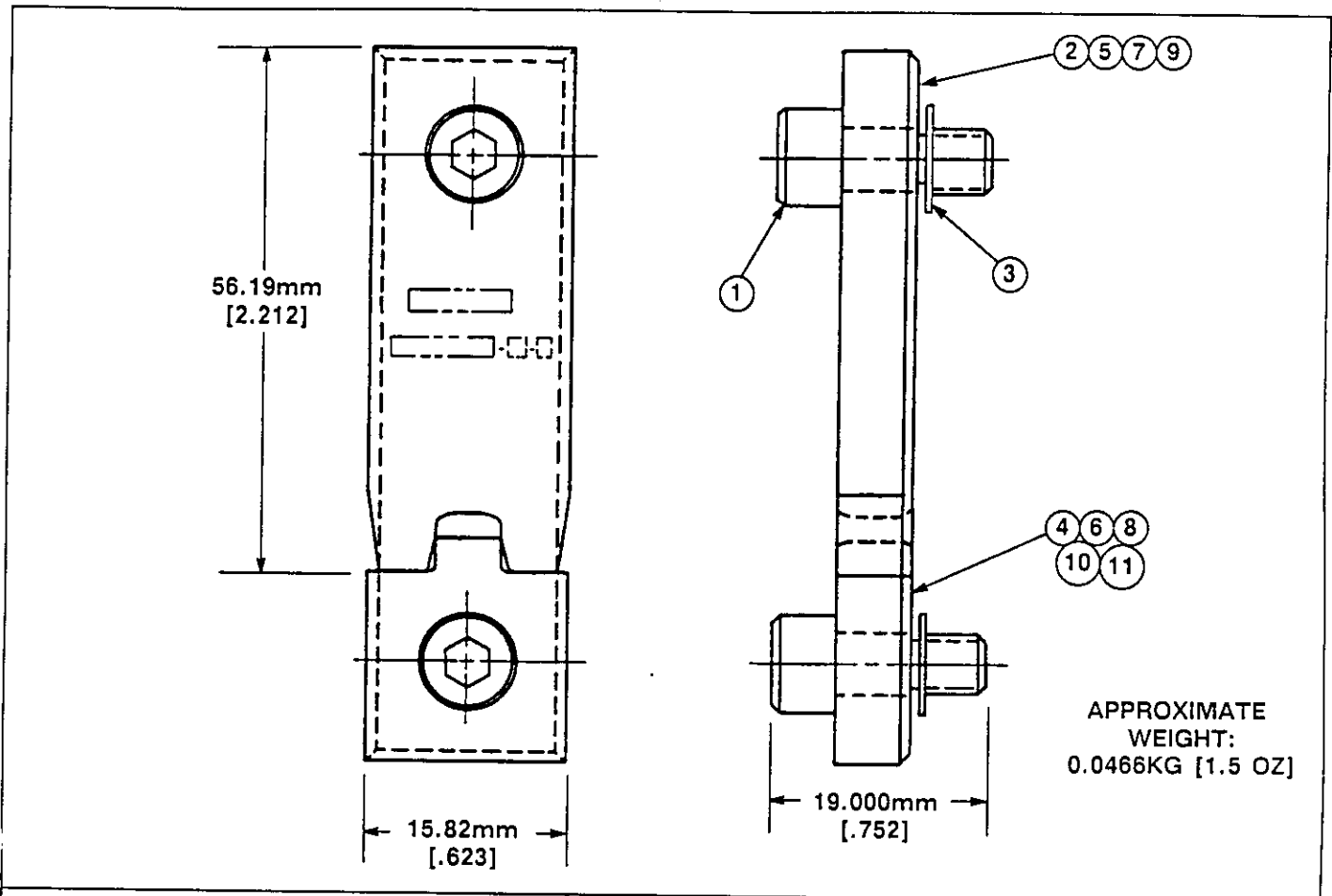
1. Remove dust, moisture, and other contaminants with a clean brush, or with a soft, lint-free cloth. Do NOT use objects that could damage the dies.
2. Make certain the dies are protected with a THIN coat of any good grade SAE No. 20 motor oil. Do NOT oil excessively.
3. Mate and store the dies in a clean, dry area when they are not in use.

5.2. Periodic Inspection

Regular inspections should be performed by quality control personnel. A record of scheduled inspections should remain with the dies and be supplied to supervisory personnel responsible for the dies. Though recommendations call for at least one inspection a month, the inspection frequency should be based on the amount of use, ambient working conditions, operator training and skill, and established company standards. These inspections should be performed in the following sequence:

A. Visual Inspection

1. Remove all lubrication and accumulated film by immersing the dies in a suitable commercial degreaser that will not affect paint or plastic material.
2. Make sure all die holding screws, retaining rings and die components are in place. Refer to the parts listed in Figure 2 if replacements are necessary.
3. Check all parts for wear. Remove and replace worn components.
4. Inspect the crimp area for flattened, chipped, cracked, worn, or broken areas. If damage is evident, the dies must be repaired before returning them to service (see Paragraph 6, REPAIR).



REPLACEMENT PARTS

ITEM	PART NO.	DESCRIPTION	NUMBER REQUIRED PER DIE ASSEMBLY				
			58269-1	58269-2	58269-3	58269-4	58269-5
1	3-59781-5	SCREW, Die Holding	2	2	2	2	2
2	313359-1	CRIMPER, Wire	1	--	--	--	--
3	1-21046-3	RING, Retaining	2	2	2	2	2
4	313360-1	ANVIL, Wire	1	--	--	--	--
5	313359-2	CRIMPER, Wire	--	1	--	--	--
6	313360-2	ANVIL, Wire	--	1	--	--	--
7	313359-3	CRIMPER, Wire	--	--	1	--	--
8	313360-3	ANVIL, Wire	--	--	1	--	--
9	313359-4	CRIMPER, Wire	--	--	--	1	1
10	313360-4	ANVIL, Wire	--	--	--	1	--
11	313360-5	ANVIL, Wire	--	--	--	--	1

Fig. 2

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B. Gaging the Crimping Chamber

This inspection requires the use of a plug gage conforming to the diameters shown in Figure 3. AMP does not manufacture or market these gages.

Proceed as follows:

1. Mate the dies until they have bottomed. Hold the dies in this position.

2. Align the GO element with the crimping chamber. Push element straight into the crimping chamber without using force. The GO element must pass completely through the chamber as shown in Figure 3.

3. Align the NO-GO element and try to insert it into the same chamber. The NO-GO element may start entry, but must not pass completely through the chamber. See Figure 3.

If the crimping chamber conforms to the gage inspection, the dies are considered dimensionally correct and should be lubricated with a thin coat of SAE No. 20 motor oil. If not, the dies must be repaired before returning them to service (see Paragraph 6, REPAIR).

6. REPAIR

The parts listed in Figure 2 are customer-replaceable. A complete inventory should be stocked and controlled to prevent lost time when replacement of parts is necessary. Replacement parts can be ordered from:

CUSTOMER SERVICE (38-35)
AMP INCORPORATED
P. O. BOX 3608
HARRISBURG, PA 17102-1604

Dies may be returned (along with a written description of the problem) to AMP for evaluation and repair. Ship dies to:

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

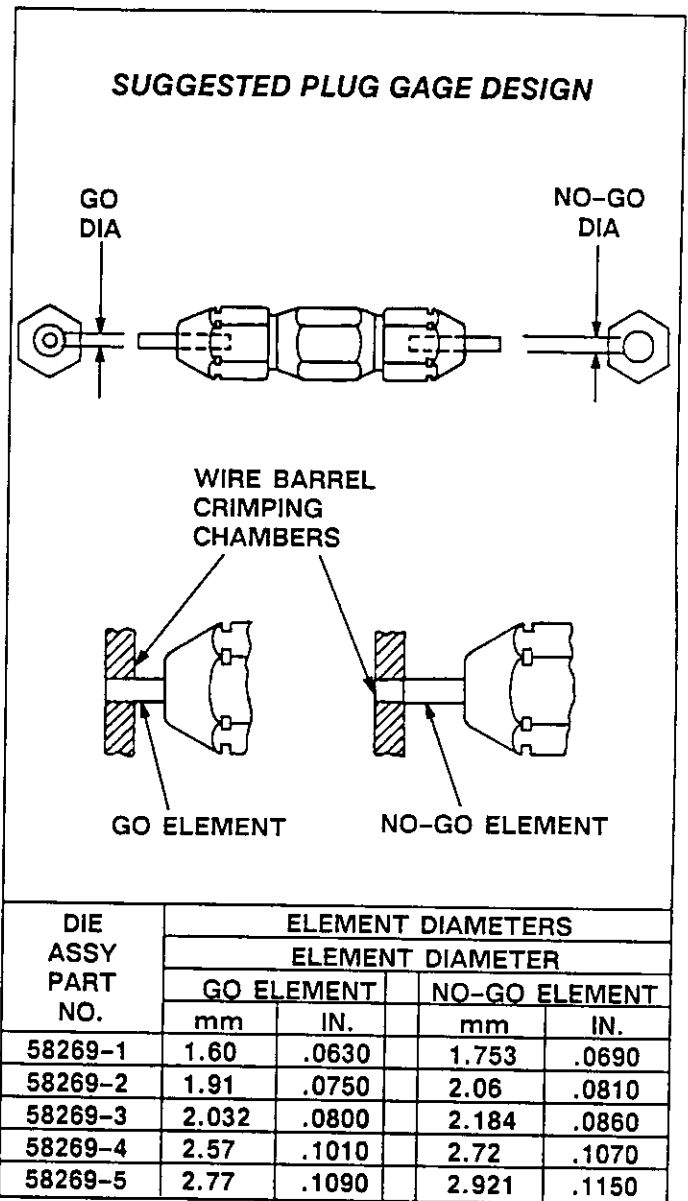


Fig. 3

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