

**1. INTRODUCTION**

This instruction sheet provides "Instructions" on product application and a "Maintenance and Inspection Procedure" for:

**SOLISTRAND ★ CRIMPING DIES**  
**68338-1**  
 (Used in Open-Closed Barrel AMPOMATOR ★  
 Machine, Model IV B, with Applicator No. 687658-□)

These dies are used to crimp:

- SOLISTRAND terminals on wire range 12 thru 10.
- Instructions on die insertion and removal, crimping procedure, etc., are provided in instruction material packaged with the machine and applicator. Section 3 of this instruction sheet features a terminal "Crimp Inspection" procedure. Section 4 contains a "Maintenance and Inspection Procedure" required to establish and maintain a *die certification program*.

Dies are coated with preservative to prevent rust and corrosion. Wipe preservative from dies, particularly from crimping surfaces.

**NOTE:** For low volume applications, these dies may be used in crimping machine Nos. 69875 and 68075.

**2. INSTRUCTIONS**

**WARNING:** AVOID PERSONAL INJURY. ALWAYS KEEP GUARDS AND COVERS IN PLACE WHEN ACTIVATING MACHINE.

**2.1 WIRE STRIPPING**

Machine adjustments for wire strip lengths are provided in manual package with the machine. Refer to Figure 1 for correct strip length for wire size being used.

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

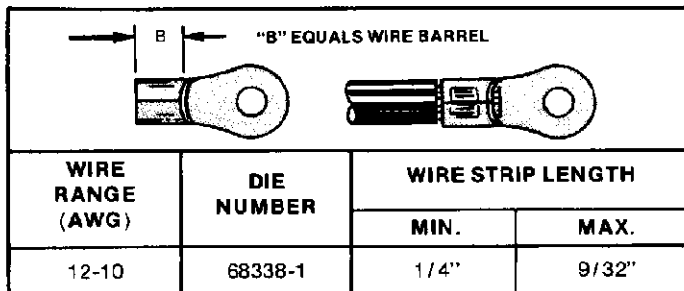


Figure 1

**3. CRIMP INSPECTION**

Inspect the crimped terminals by checking the features described in Figure 2. Use only the terminals that meet the conditions shown in the "ACCEPT" column. "REJECT" terminals can be avoided through careful use of machine/applicator operating and adjustment instructions and by performing regular die maintenance as instructed in Section 4 of this instruction sheet.

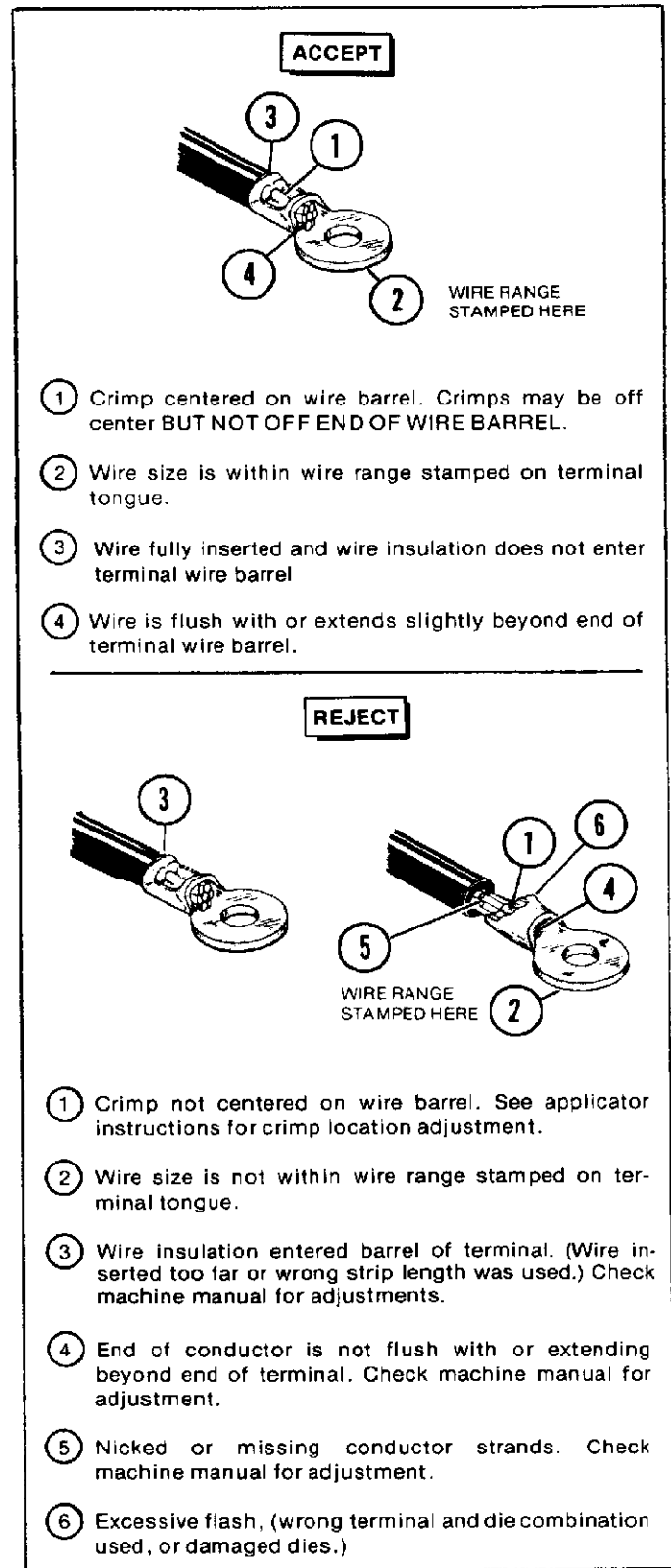


Figure 2

All illustrations and information contained in this instruction sheet are based on the latest product information available at the time of publication.

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**4. MAINTENANCE/INSPECTION PROCEDURE**

AMP recommends that a maintenance/inspection program be performed periodically to ensure dependable and uniform terminations. Inspect dies at least once a month. Frequency of inspection may be adjusted to suit requirements through experience. Frequency of inspection is dependent upon:

1. The care, amount of use, and handling of the dies.
2. The type and size of the products crimped.
3. The degree of operator skill.
4. The presence of abnormal amounts of dust and dirt.
5. Established standards.

All dies are thoroughly inspected before packaging. Since there is a possibility of die damage in shipment, inspect new dies in accordance with the following instructions when received in the plant. Die parts may be interchanged if they are of the same wire size.

**4.1 CLEANING**

Do not allow deposits of dirt, grease and foreign matter to accumulate on the die closure surfaces and bottoming surfaces. These deposits may cause excessive wear and prevent dies from bottoming fully, thereby affecting the quality of the crimp. The dies should be wiped clean frequently with a clean cloth.

**4.2 VISUAL INSPECTION**

Visually inspect the die closure surfaces for broken, pitted, or chipped areas. Although dies may gage within permissible limits, worn or damaged die closure surfaces are objectionable and can affect the quality of the crimp. Examples of possible damaged die closure surfaces are shown in Figure 3.

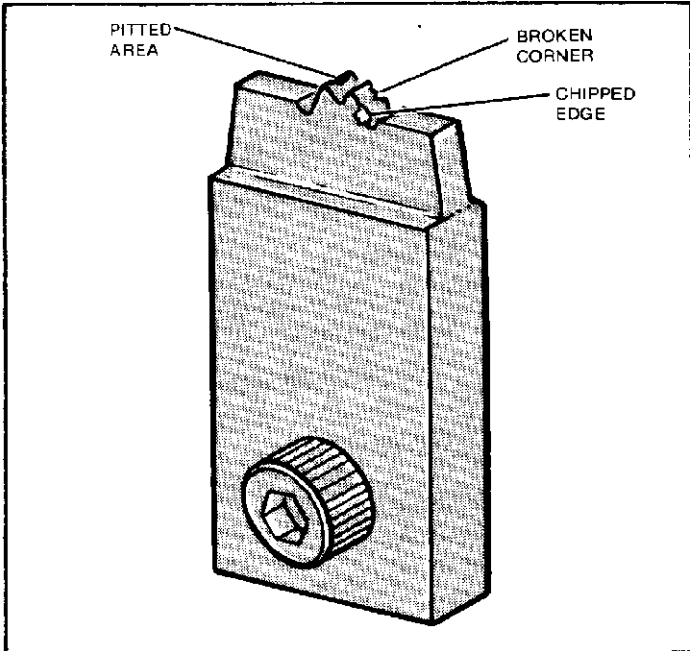


Figure 3

**4.3 DIE CLOSURE INSPECTION**

Every die set is inspected and tested for proper die closure before packaging. Periodically inspect the die closure for excessive wear. The die closure inspection is accomplished using the GO NO-GO plug gages. AMP neither manufactures nor sells plug gages. Suggested plug gage design and the GO NO-GO dimensions of the plug gage members are given in Figure 4.

The following procedure is recommended for inspecting the die closure.

- (a) Clean oil or dirt from die closure surfaces, bottoming surfaces and plug gage members.
- (b) Assemble dies so they are bottomed but not under pressure. See Figure 5.
- (c) With dies bottomed, inspect the die closure using the proper plug gage. Hold gage in straight alignment with die closure and carefully try to insert without forcing, the GO member. See Figure 5. The GO member must pass completely through the die closure.
- (d) Try to insert the NO-GO member. The NO-GO member may enter partially but must not pass completely through the crimp closure. See Figure 5.

If die closure meets the GO NO-GO gage conditions the dies may be considered dimensionally correct.

If you find that die closure does not conform with the GO NO-GO gage conditions, contact your local AMP field representative.

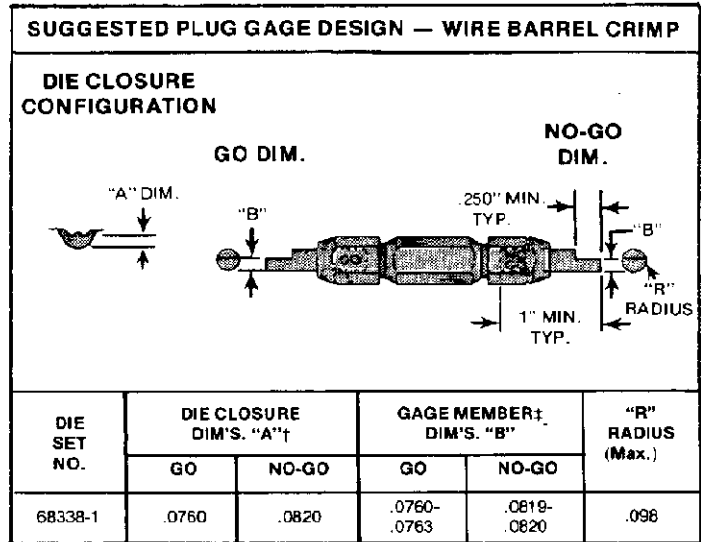


Figure 4

† Die closure dimensions apply when dies are bottomed but not under pressure.  
‡ Material — Tool Steel

**4.4 REPLACEMENT PARTS**

It may be advantageous to stock certain replaceable parts to prevent loss of production time. Figure 6 lists the customer replaceable parts that can be purchased from AMP Incorporated, Harrisburg, Pa. 17105, or a wholly owned subsidiary of AMP Incorporated.

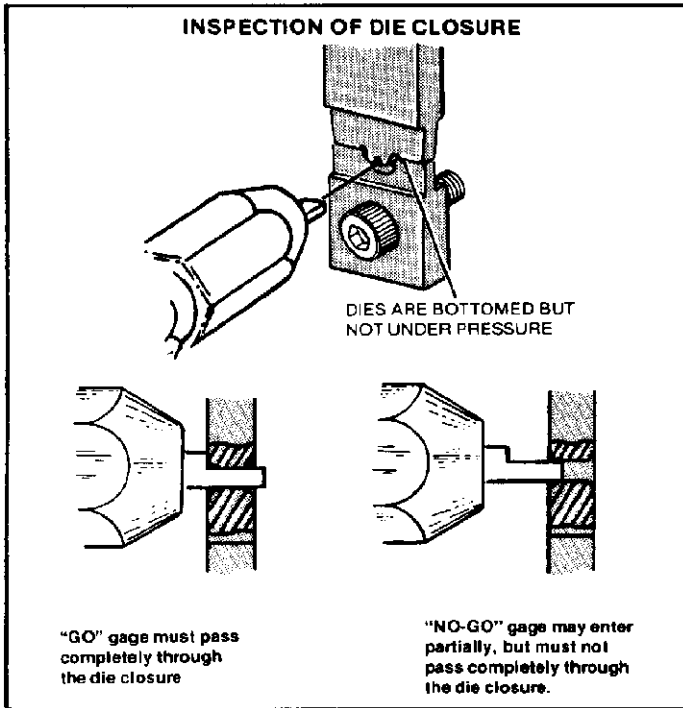


Figure 5

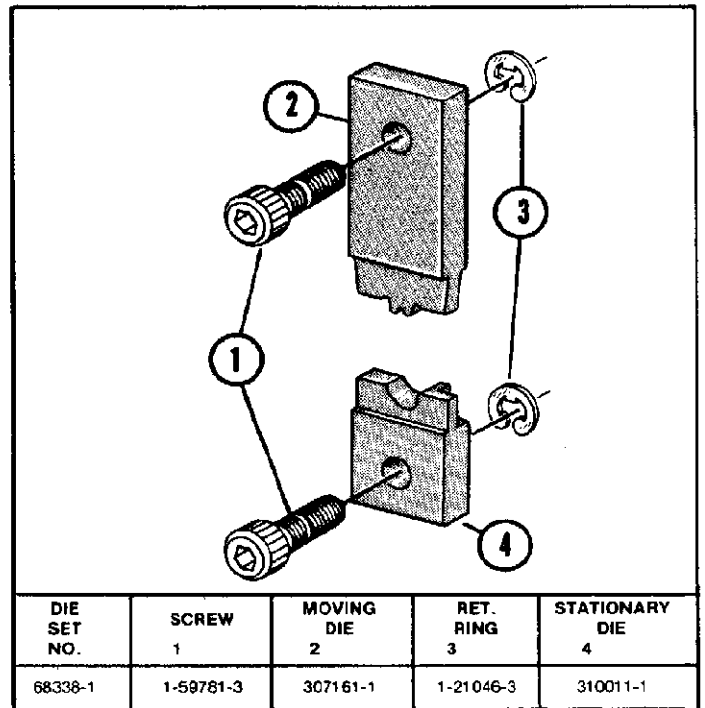


Figure 6

REL. DATE	REV. DATE	APPROVALS	
6-2-80		ENG. <i>Lloyd H. Broslaw</i>	PUB. <i>Paul Felty</i>