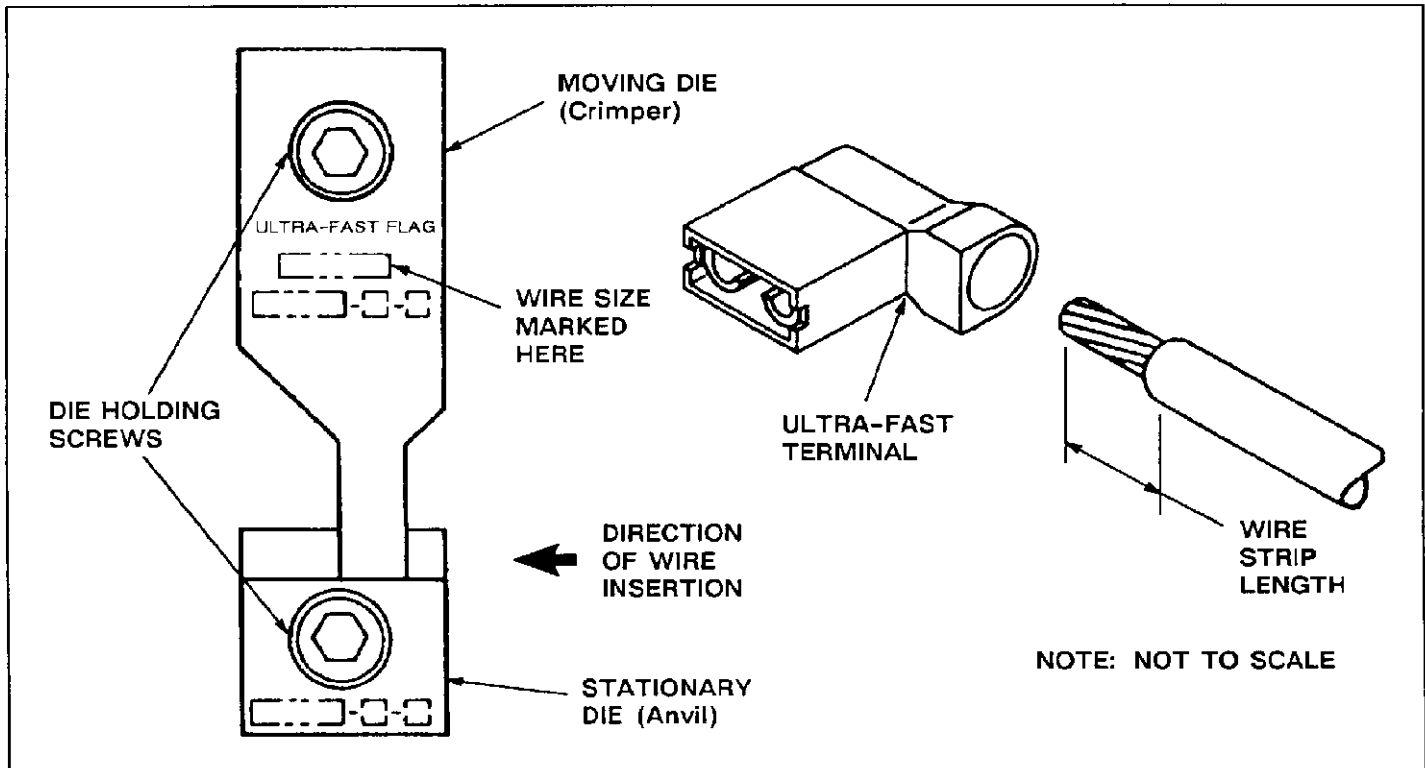


**AMP**AMP INCORPORATED  
HARRISBURG, PA 17105APPLICATION AND MAINTENANCE  
FOR AMP\* CRIMPING DIE ASSEMBLIES

REDUCED FOR PACKAGING

**IS 9296**CUSTOMER HOTLINE  
1 800 722-1111

58308-1 AND 58308-2

RELEASED  
8-2-90

DIE ASSY PART NUMBER	WIRE			SERIES	TERMINAL		HOUSING COLOR
	SIZE (AWG)	INSUL DIA (Max)	STRIP LENGTH†		PART NUMBERS		
					STRIP	LOOSE-PIECE	
58308-1	22-18	.165	.281	187	2-520334-2	2-520335-2	Red
				250	2-520336-2	2-520337-2	
		250	.230	.281	2-520128-2	2-520129-2	
58308-2	16-14	.185	.281	187	3-520338-2	3-520339-2	Blue
				250	3-520340-2	---	
				250	3-520132-2	3-520133-2	

† When crimping two wires, strip length is .312.

Fig. 1

**1. INTRODUCTION**

This instruction sheet (IS) covers the use of AMP Die Assemblies 58308-1 and 58308-2, which are used in Applicator No. 818058-3 to crimp the Ultra-Fast Fully Insulated FASTON\* Flag Terminals listed in Figure 1. The dies crimp strip-mounted terminals only. Loose-piece part numbers are included for reference.

**NOTE**

All dimensions on this sheet are in inches. Figures and illustrations are for identification only and are not drawn to scale.

This sheet provides information on terminal and wire specifications, maintenance and inspection procedures, and general performance of crimping die assemblies. Read AMP Instruction Sheet IS 9491, packaged with the AUTO-PRO\* Machine, for information on machine installation and preventive maintenance.

**2. DESCRIPTION**

Each die assembly consists of one stationary die (anvil) and one moving die (crimper). Both dies use a die-holding screw for attachment to the applicator.

Each die is marked with the assembly part number, and the moving die is also stamped with the wire size.

The color of the terminal's insulation determines the correct wire size range for that terminal: red insulation indicates that the range is 22-18 AWG and blue indicates that the range is 16-14 AWG.

### 3. DIE INSTALLATION

The anvil and crimper are installed on the applicator with the die-holding screws. Refer to AMP Applicator Instruction Sheet AI 8093, packaged with the applicator, for detailed information on die installation and adjustment.

**DANGER**

*Make sure that ALL power to the machine is disconnected BEFORE installing, removing, or adjusting the dies.*

### 4. CRIMPING PROCEDURES

From the table in Figure 1, make sure that the proper die assembly is installed, and that the proper wire size and strip-form terminal combination is being used.

Strip the wire to the length shown in Figure 1. Be careful to avoid nicking or cutting any wire strands.

Refer to AI 8093 for detailed information on crimping the terminals to the wire.

### 5. MAINTENANCE/INSPECTION

#### 5.1. Daily Maintenance

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

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

#### 5.2. 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 Figure 3 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. Refer to Section 6, REPAIR.

### 5.3. Gaging the Crimping Chamber

This inspection requires the use of a plug gage conforming to the dimensions provided in Figure 2. AMP does not manufacture or market these gages. To gage the crimping chamber:

1. Mate the dies until it is evident that they have bottomed. Hold the dies in this position.
2. Align the gage's GO element with the appropriate crimping chamber. Push the element straight into the crimping chamber without using excessive force. The GO element must pass completely through the crimping chamber, as shown in Figure 2.
3. Align the gage's NO-GO element with the crimping chamber and try to insert the element straight into the crimping chamber. The element may start entry, but must not pass completely through the chamber, as shown in Figure 2.

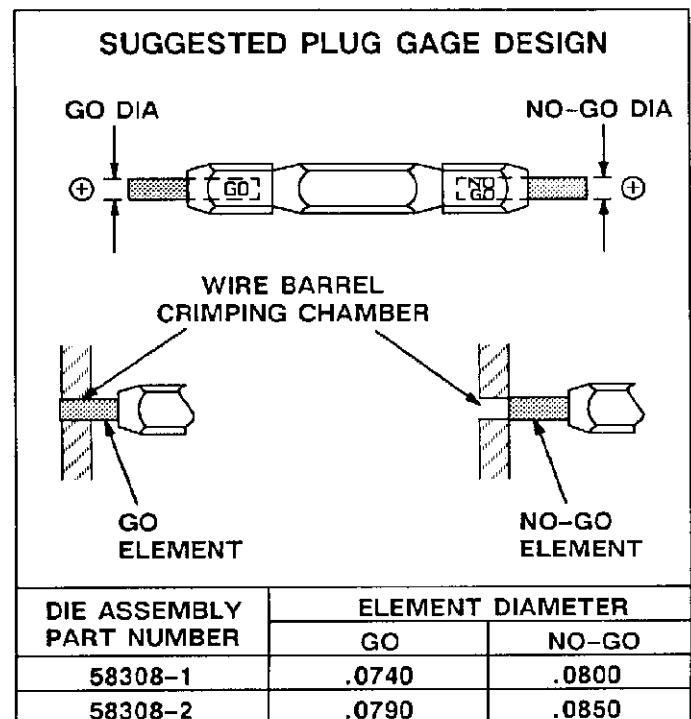


Fig. 2

If the crimping chamber conforms to the gage inspection, the dies are considered dimensionally correct, and should be lubricated with a THIN coat of any good SAE No. 20 motor oil. If the dies do not conform to the inspection, they must be repaired before returning them to service. Refer to Section 6, REPAIR.

**6. REPAIR**

The parts listed in Figure 3 are customer-replaceable parts. A complete inventory should be stocked and controlled to prevent lost time when replacement of parts is necessary. The dies can also be returned to

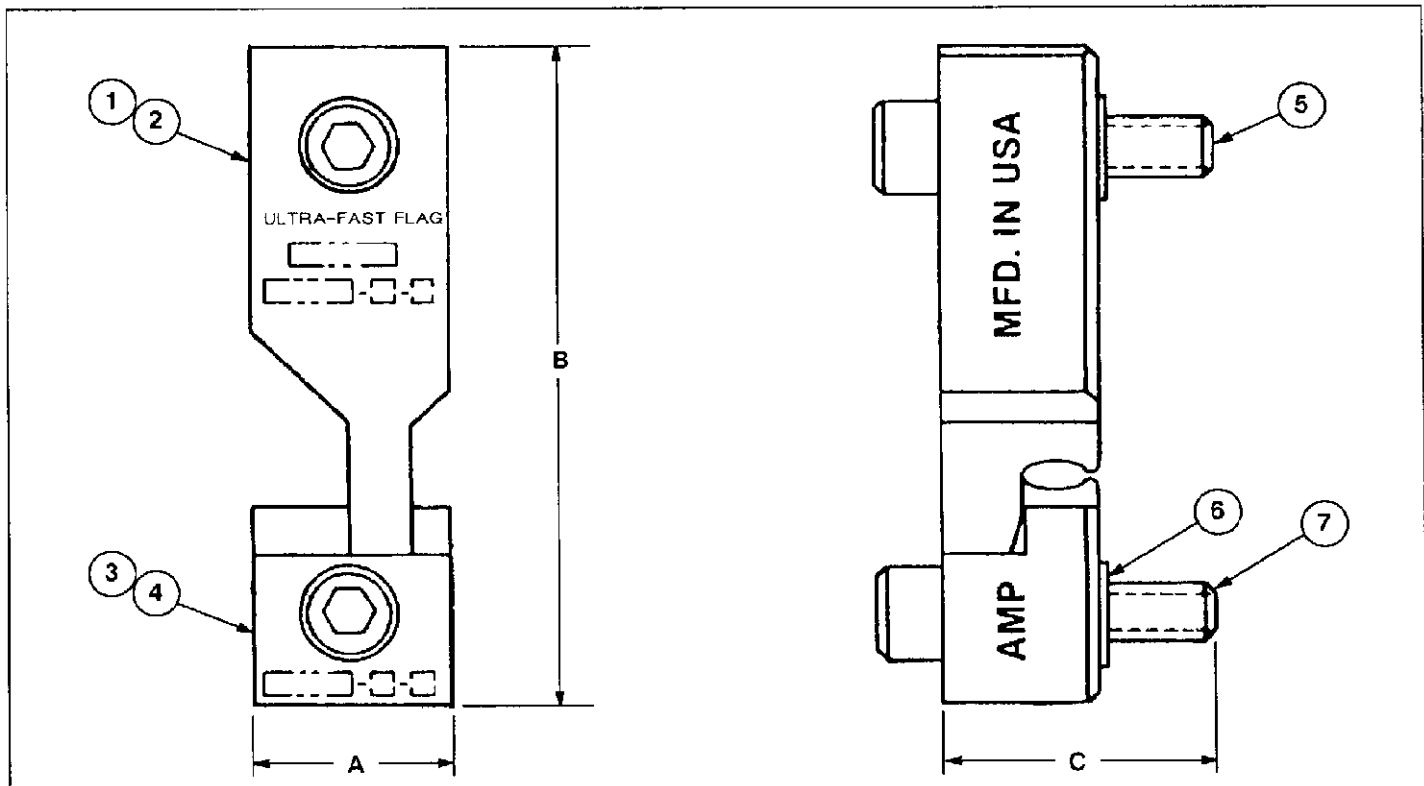
AMP for evaluation and repair. Send the dies, with a written description of the problem to:

AMP Incorporated  
 Customer Repair  
 1523 North 4th Street  
 Harrisburg, PA 17102-1604

Replacement parts may be ordered from:

AMP Incorporated  
 P.O. Box 3608  
 Harrisburg, PA 17105-3608

or a wholly owned subsidiary of AMP Incorporated.



ITEM	PART NUMBER	DESCRIPTION	QUANTITY/ASSEMBLY		DIMENSIONS	
			58308-1	58308-2		
1	313588-1	Crimper	1	---	A	.6242
2	313588-2	Crimper	---	1	B	2.212
3	313589-1	Anvil	---	1	C	.750
4	313590-1	Anvil	1	---	WEIGHT (Approx)  1.5 oz	
5	1-59781-9	Die Holding Screw	1	1		
6	1-21046-3	Retaining Ring	2	2		
7	3-59781-6	Die Holding Screw	1	1		

Fig. 3