

# AMP

AMP INCORPORATED  
HARRISBURG, PA 17105

## AMP\* JAW ASSEMBLY 68257-1 (INSTALLED IN AMP PNEUMATIC TOOL 68068)

REDUCED FOR PACKAGING

# IS 2595

CUSTOMER HOTLINE  
1 800 722-1111

RELEASED  
3-31-89

Section I of this instruction sheet provides application procedures for AMP crimping jaw assemblies.

Section II provides maintenance and inspection procedures for AMP crimping jaw assemblies.

### TOOL NO. 68068 SHOWN

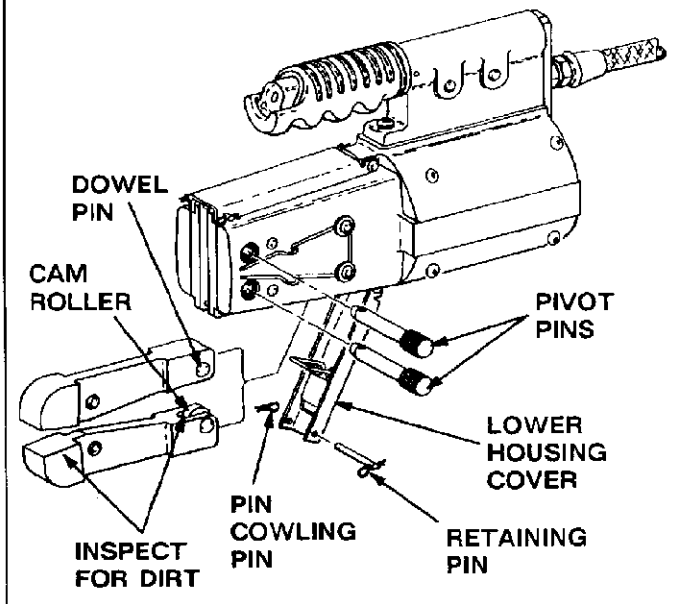


Fig. I-1

## SECTION I APPLICATION

### I-1. INTRODUCTION

AMP Jaw Assembly 68257-1 (Figure I-1) is designed to be installed in AMP Pneumatic Tool 68068- ( ) and terminate AMP TERMI-FOIL\* Double Face Parallel Splice 53612-4 and TERMI-FOIL Double Face End Tap Splice with Barrel 53660-4. The splices are illustrated in Figure I-2. Read these instructions thoroughly before attempting to install the jaw assembly.

#### NOTE

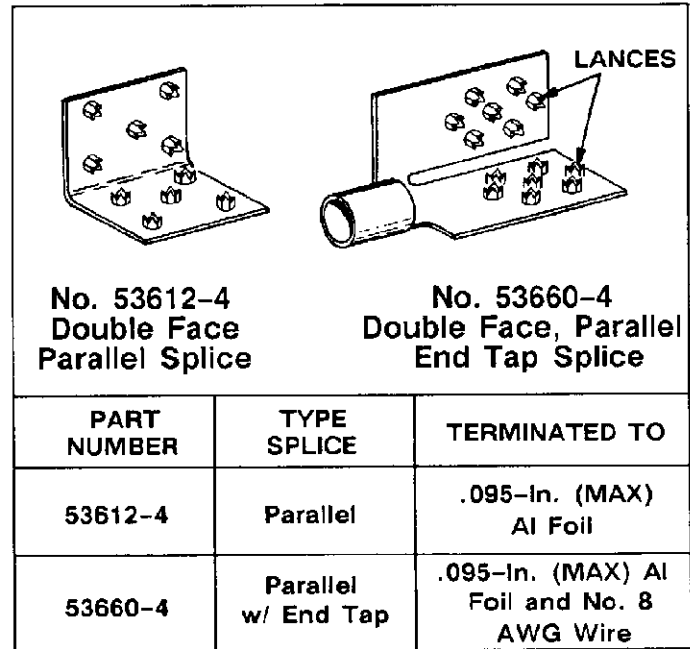
All dimensions on this sheet are in inches.

### I-2. DESCRIPTION

Jaw assembly 68257-1 consists of two identical machined jaws, each with a cam roller and dowel pin.

#### NOTE

If tool 68068 has a jaw assembly installed, proceed to Paragraph I-4; if not, proceed to Paragraph I-3.



No. 53612-4  
Double Face  
Parallel Splice

No. 53660-4  
Double Face, Parallel  
End Tap Splice

| PART NUMBER | TYPE SPLICE            | TERMINATED TO                                   |
|-------------|------------------------|-------------------------------------------------|
| 53612-4     | Parallel               | .095-In. (MAX)<br>Al Foil                       |
| 53660-4     | Parallel<br>w/ End Tap | .095-In. (MAX) Al<br>Foil and No. 8<br>AWG Wire |

Fig. I-2

### I-3. INSTALLING JAW ASSEMBLY

The steps which follow are recommended to install jaw assembly in tool 68068. Proceed as follows:

1. Ensure that jaw assembly is compatible with the splice, aluminum foil and/or wire size being used.
2. Inspect the jaw assembly closure surfaces, bottoming surfaces, and cam rollers for deposits of dirt or other foreign particles, and wipe with clean cloth. Refer to Figure I-1. Relubricate cam rollers as instructed in Paragraph II-2, LUBRICATION.

#### NOTE

Be sure cam rollers are not binding.

3. DISCONNECT tool from air supply.
4. Pull one cowling pin and remove retaining pin from lower housing cover. Cover will swing open. See Figure I-1.
5. Remove pivot pins as shown in Figure I-1.
6. Position jaw as shown in Figure I-1.

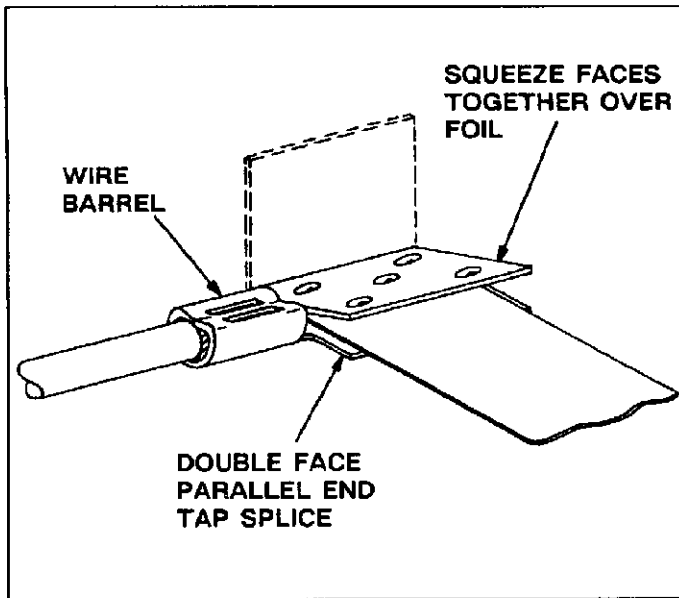


Fig. I-3

7. Position jaw assembly in tool housing, ensuring that cam rollers are properly mated with cam, and pivot pin holes of jaw assembly and tool housing are aligned.
8. Insert pivot pins.
9. Pivot lower housing cover into closed position and replace retaining pin and cowling pin.
10. Connect tool to 80 to 100 psi air supply; tool is now ready for use.

#### I-4. REMOVING JAW ASSEMBLY

To remove jaw assembly, proceed as follows.

1. DISCONNECT tool from air supply
2. Refer to Figure I-1. Pull cowling pin and remove retaining pin from lower housing cover. Cover will swing open.
3. Remove pivot pins and then remove jaw assembly.

#### I-5. CRIMPING PROCEDURE

When sure that the crimping jaw assembly is compatible with the product and wire size being used, proceed as follows:

1. Place foil between faces of splice and press faces together manually. See Figure I-3.
2. Place splice and foil between crimping jaws, as shown in Figure I-4. Make sure that the splice is completely covered by the jaw assembly.
3. Activate tool to squeeze faces together over foil.

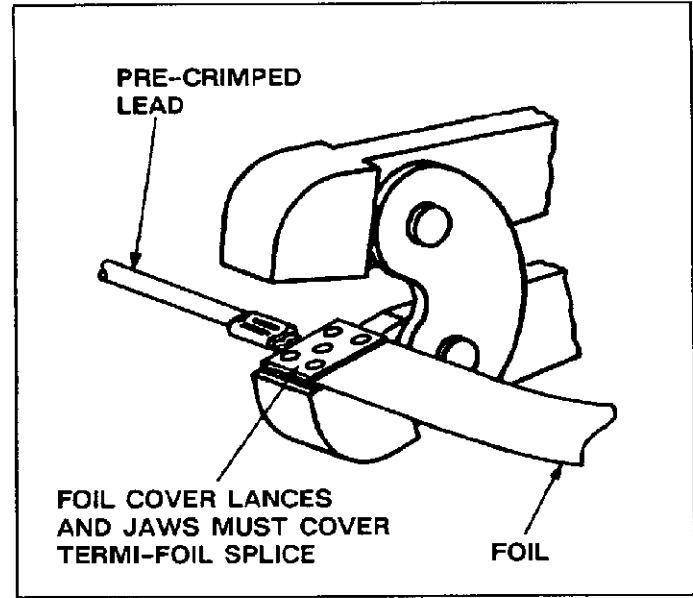


Fig. I-4

#### **DANGER**

*Always keep fingers clear of jaw assembly when operating the tool.*

4. Remove crimped splice from jaw assembly.
5. A crimped TERMI-FOIL splice should appear as shown in Figure I-5.

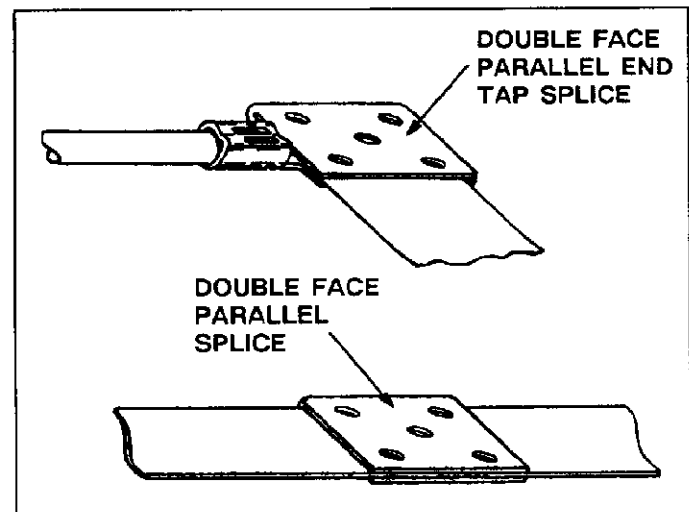


Fig. I-5

#### I-6. DAILY MAINTENANCE

Remove all foreign particles with a clean, soft brush, or a clean, soft, lint-free cloth. If foreign matter cannot be removed easily, return the jaw assembly/tool to your supervisor. Make certain all surfaces of the jaw assembly are protected with a THIN coat of any good SAE No. 20 motor oil. Do NOT oil excessively. When tool is not in use, store in a clean, dry area.

Section I of this instruction sheet provides application procedures for AMP crimping jaw assemblies.

Section II provides maintenance and inspection procedures for AMP crimping jaw assemblies.

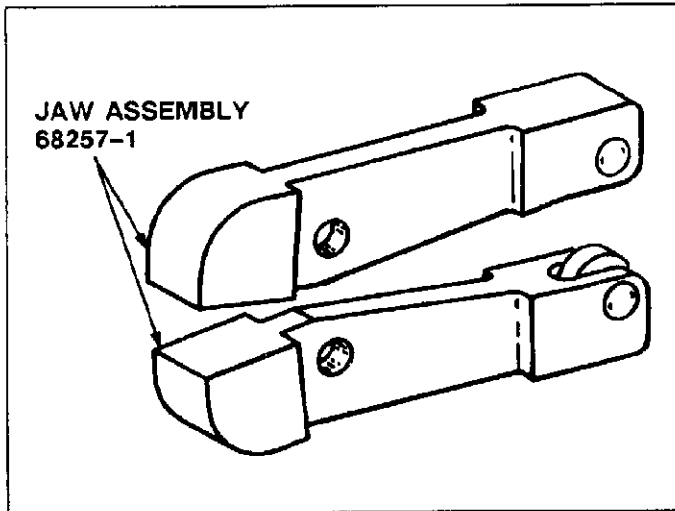


Fig. II-1

## SECTION II MAINTENANCE/INSPECTION

These instructions have been approved by AMP Design, Production, and Quality Control Engineers to provide documented maintenance and inspection procedures in accordance with AMP Corporate Policy No. 3-3. Through AMP test laboratories and the inspection of production assembly, the procedures described herein have been established to ensure quality and reliability of AMP crimping jaw assemblies.

Customer-replaceable parts are shown in Figure II-1. A complete inventory should be stocked and controlled to prevent lost time when replacement of parts is necessary. When parts are needed, order by part number and description.

### II-1. INSPECTION PROCEDURES

#### A. Daily Maintenance

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

1. Do not allow deposits of dirt, grease, or foreign matter to accumulate on the jaw bottoming surfaces. These deposits may cause excessive wear, thereby affecting the quality of the crimp.
2. Immerse the jaw assembly in a degreasing compound to remove accumulated dirt, grease, and other foreign matter. Remove remaining degreasing compound with lint free cloth. (When degreasing compounds are not available, jaws may be wiped clean with lint free cloth.)

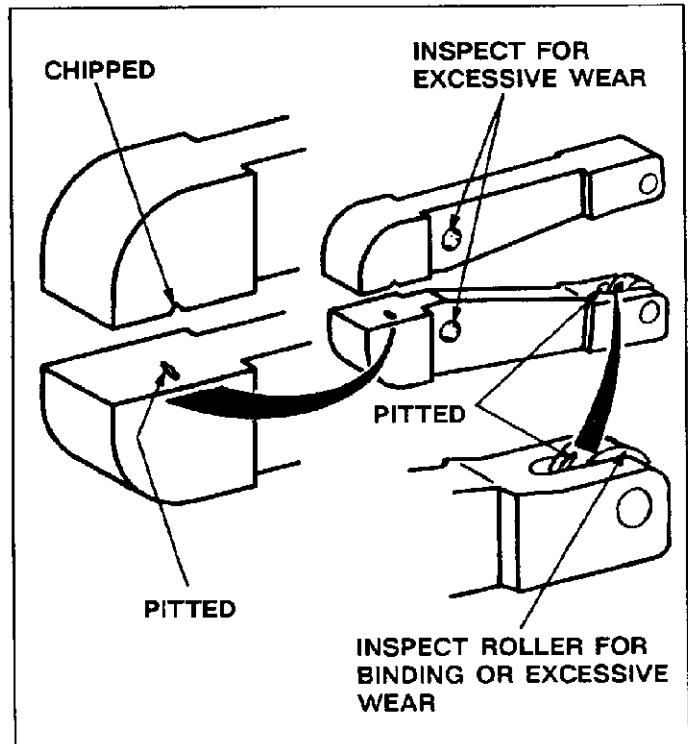


Fig. II-2

3. Relubricate jaw assembly as instructed in II-2, LUBRICATION before placing it back in service.
4. When the jaw assembly is not being used, store in a clean, dry area.

#### B. Periodic Inspection

Regular inspections should be performed by quality control personnel. A record of scheduled inspections should remain with the jaw assembly and/or be supplied to supervisory personnel responsible for them. 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 include a visual inspection.

#### C. Visual Inspection

Visually inspect the die closure surfaces for pitted, broken, or chipped conditions. Although the jaw assembly may gage within permissible limits, worn or damaged die closure surfaces are objectionable and can affect the quality of the crimp. Examples of die damage are shown in Figure II-2. If damage is evident, the jaw assembly must be replaced (see Paragraph II-3, REPLACEMENT).

## II-2. LUBRICATION

Lubricate cam rollers, pivot pins, and pivot pin holes with CMD Anti-Scouring Extreme Pressure Lubricant No. 3† or equivalent. Lubricate cam roller pins with SAE No. 20 non-detergent motor oil. Wipe excess lubricant from jaws, particularly from crimping surfaces. Lubricant transferred from the crimping surfaces onto terminations may affect the electrical characteristics of an application.

Lubricate as follows:

- Jaws used in daily production—Lubricate daily.
- Jaws used daily (occasionally)—Lubricate weekly.
- Jaws used weekly—Lubricate monthly.

## II-3. JAW ASSEMBLY REPLACEMENT

When replacement parts are needed, order by part number and description.

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

or a wholly owned subsidiary of AMP Incorporated.

† Chicago Manufacturing & Distributing Division,  
Evans Products Company  
P.O. Box 41209  
Woodstock, IL 60098