

**IS 7902 IS SUPERSEDED BY IS 9433**



**APPLICATION AND MAINTENANCE FOR AMP\* CRIMPING DIE ASSEMBLY 90367-1**

Instruction Sheet  
**IS 7902**  
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REDUCED FOR PACKAGING

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

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

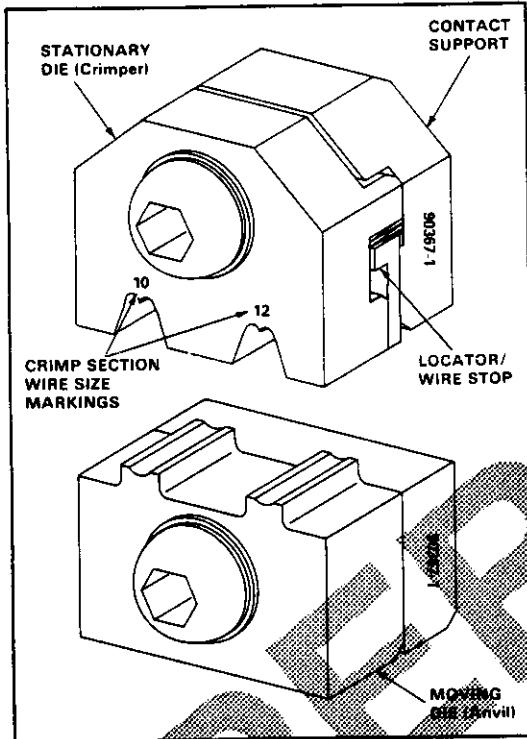


Fig. I-1

**SECTION I APPLICATION**

**I-1. INTRODUCTION**

AMP Crimping Die Assembly 90367-1 is designed for use in the AMPORTAPOWER\* Pneumatic Tool 69303 or the AMP Hand Crimping Tool 69710 to crimp the AMP MATE-N-LOK\* loose piece contacts listed in Figure I-2.

This instruction sheet provides specific information concerning the die assembly and applicable contacts. Refer to AMP Customer Manual CM 1983, packaged with the pneumatic tool, or AMP Instruction Sheet IS 2095, packaged with the hand tool, for information concerning die insertion, contact crimping, and general performance of the tool.

**NOTE**

All dimensions presented on this instruction sheet are in inches, unless otherwise stated.

**I-2. DESCRIPTION (see Figure I-1)**

The die assembly features a stationary die (crimper), a movable die (anvil), a contact locator/wire stop and a contact support.

The stationary die has chamfered corners and features the wire size marked above each crimp section. The moving die has square corners.

The locator/wire stop has two functions. First, it positions the contact in the crimping die, and second, it aids in inserting the wire in the contact. In use, it rests in the contact locator slot (see Figures I-2 and I-3).

The contact support prevents the contact from bending during the crimping operation.

**I-3. CRIMPING PROCEDURE**

Insert the die according to the instructions packaged with the tool.

Refer to the chart in Figure I-2 and select wire of the specified size. Strip the wire to the length indicated - do NOT cut or nick the wire strands.

WIRE SIZE (AWG)	STRIP LENGTH	CONTACT			CRIMP SECT WIRE SIZE MARKING
		TYPE	LOOSE PIECE	STRIP	
12	1/4 (.250)	Pin	640309-3	350922-3	12
		Skt	640310-3	350923-3	
10	1/4 (.250)	Pin	640309-3	350922-3	10
		Skt	640310-3	350923-3	

Fig. I-2

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