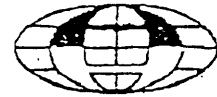
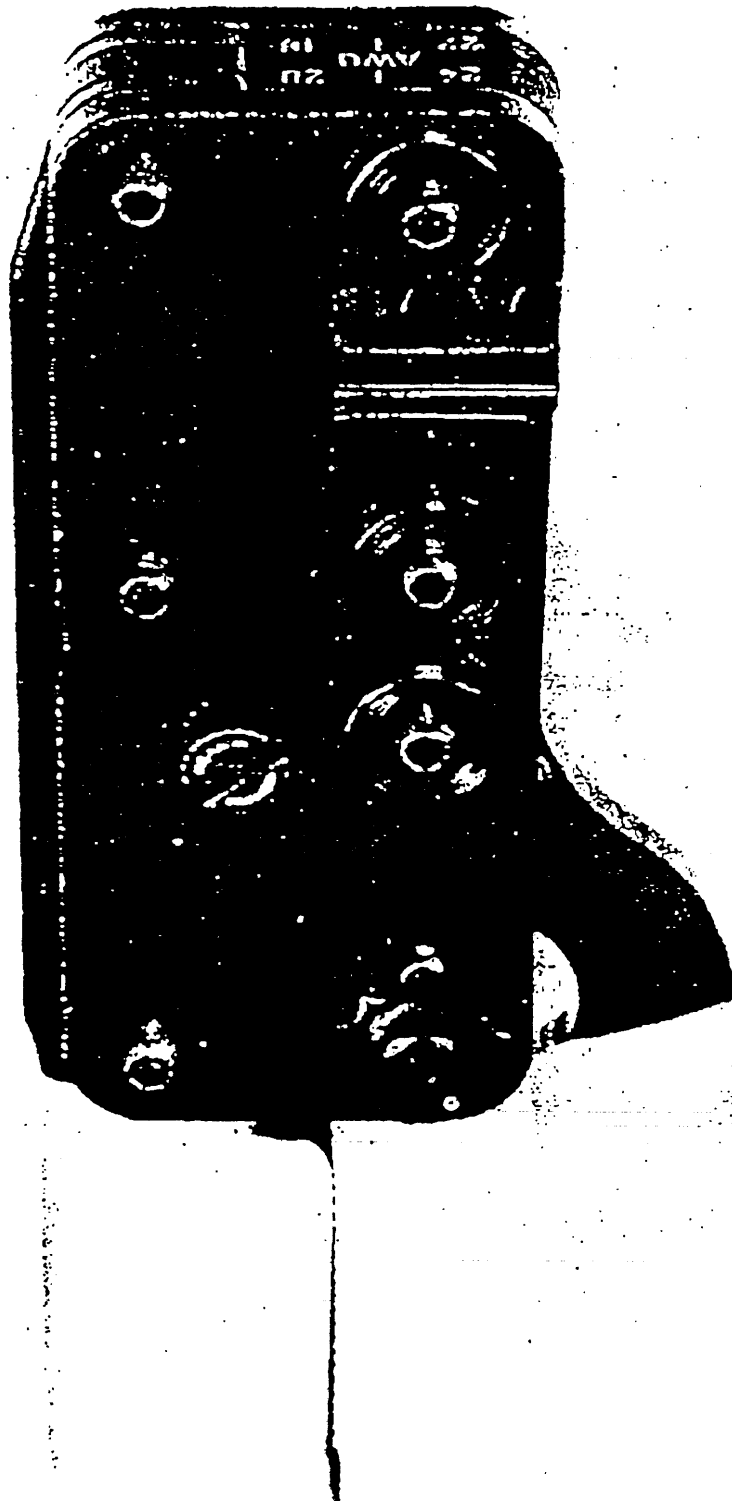


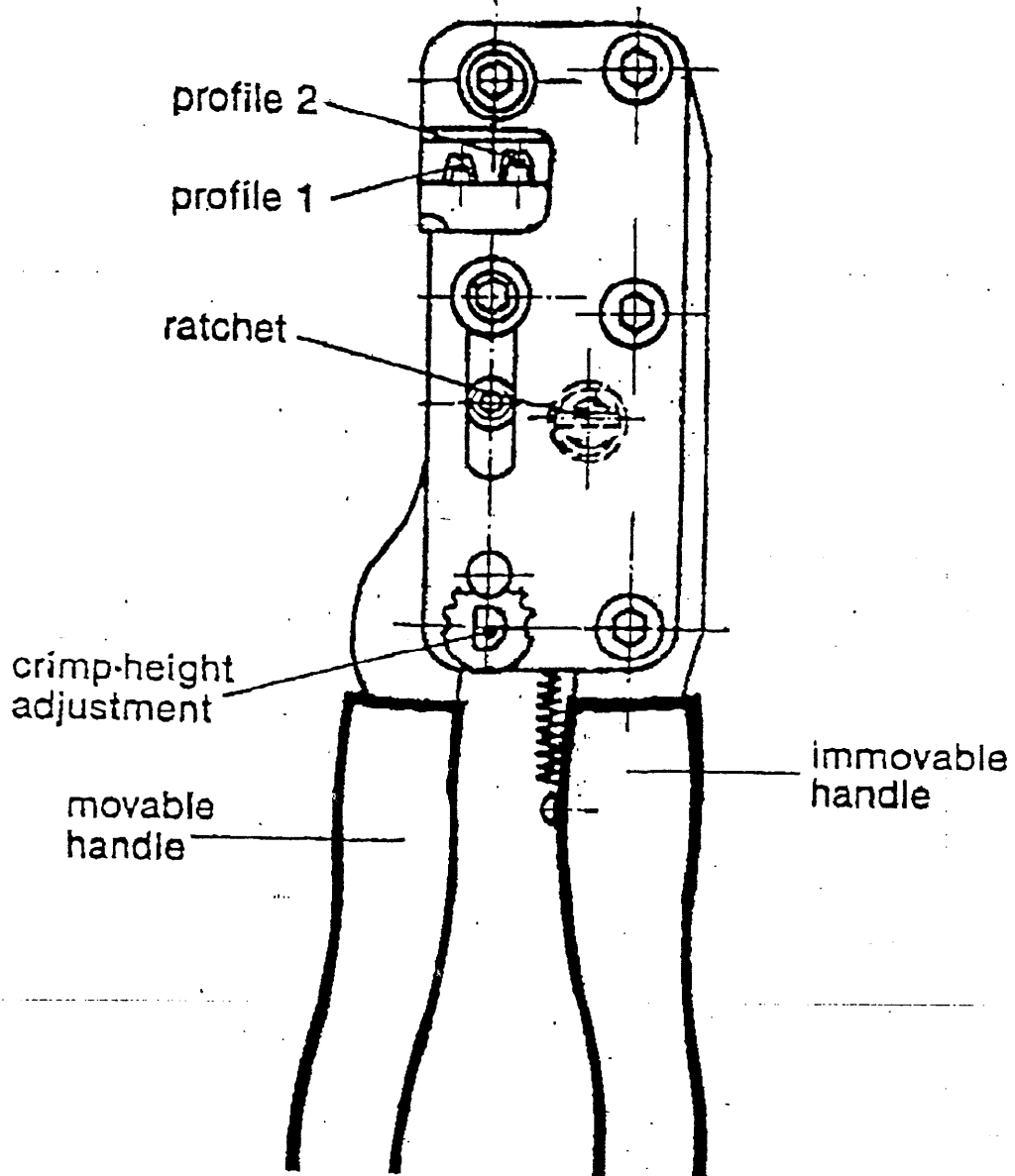
285-420

Manual for AMP handtools P.N.  
654148-1 and 654149-1 for use  
with Universal MATE-N-LOK  
terminals



**AMP**  
DEUTSCHLAND GmbH





#### Note

- The handtool is supplied with a stop that has five positions
- It is impossible to close the handtool before having first opened it completely
- Premature opening of the handtool is prevented, so that an identical crimp is always obtained.
- It is possible, however, to eliminate the stop, for example when crimping is incorrect
- Elimination of the stop is achieved by turning the ratchet at the back of the tool in the direction indicated by the two yellow arrows. During this operation it is necessary to keep the movable handle under light pressure.

## 1. Introduction

These handtools have been designed for crimping Universal MATE-N-LOK pin and socket contacts. The following contacts can be terminated with these tools.

handtool	profile	contacts (loose piece)	wire-size
654 148 - 1	1	350 690	0,2 - 0,35 mm <sup>2</sup>
		350 689	
	2	350 690	0,5 - 0,82 mm <sup>2</sup>
		350 689	
654 149 - 1	1	350 550	0,5 - 0,82 mm <sup>2</sup>
		350 547	
	2	350 550	1,3 - 2,1 mm <sup>2</sup>
		350 547	

OTHER CONTACTS US  
926894-3  
926894-1  
926893-3  
926893-1

## 2. Strip length

Before terminating, wires must be stripped at a length of 4,5 mm.

## 3. Operation

### 3.1 Starting position: handtool is completely opened.

Note: If necessary, the handles must be depressed until the ratchet releases the handles.

### 3.2 Place the handtool in your left hand, so that the movable handle may be actuated by your thumb.

### 3.3 Place terminal as far as possible on to the positioner with U-shape facing the crimper. Depress handles until the terminal is held in position.

### 3.4 Place the wire with its stripped end into the barrel of the terminal so that the isolation ends between wire and isolation barrel.

### 3.5 Close handtool by moving the handle while wire is held in position.

### 3.6 When the handtool is completely closed, the movable handle may be returned to its starting position.

#### 4. Adjusting height of the crimp

If there tends to be some play in the tool hinges the height of the crimp must be readjusted.

The correct crimp-heights are:

Handtool	profile	crimp-height
654 148-1	1	0,98 $\pm$ 0,05 mm
	2	1,13 $\pm$ 0,05 mm
654 148-1	1	1,22 $\pm$ 0,05 mm
	2	1,56 $\pm$ 0,05 mm

Use the enclosed hollow-head screw wrench number 2 and the special wrench with blue grip to adjust height of the crimp.

Note: The hollow-head screw wrench number 2,5 is used for replacing crimp tooling only.

After removing the two button-head cap screws it is possible to turn the stop ring. Turn the eccentric pin with special wrench one position in clockwise direction. Check height of the crimp. If the height is correct, remount the two button-head cap screws. If the crimp is still incorrect, turn the eccentric pin one position further.

#### 5. Maintenance

Crimper and anvil must be regularly checked for possible agold build-up. If necessary, these parts may be cleaned. Damaged parts must be replaced immediately. Movable parts should be lightly oiled with the enclosed oil.



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