AMP SPECIAL INDUSTRIES

AMP★ CERTI-CRIMP★ RATCHET P/N 604220-1 INSTALLATION PROCEDURE

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REVISED	

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

1. INTRODUCTION

The CERTI-CRIMP ratchet ensures that tool exerts full crimp pressure on the terminal or splice.

The ratchet can be installed on all tools listed in Figure 1.

1.1 TOOLS NEEDED TO INSTALL RATCHET

3/16" Allen Wrench
5/32" Allen Wrench
1/2" Wrench
7/16" Wrench } or Adjustable Wrench
Hammer
1/4" Dia. Drive Punch

2. INSTALLATION

(a) Rotate dies to storage position indicated in Figure 1, or on die setting chart on tool.

(b) Orient tool so that bolt heads are "UP", then open handles as far as they will go.

(c) Turn both lock (LOCK) screws (see Figure 1) counter-clockwise approximately 1/2 to 3/4 turn, using a 3/16" Allen Wrench.

(d) Remove and discard left spring pin (see Figure 1) using 1/4" dia. drive punch.

(e) Remove 1/4" nut from 5/16" dia. shoulder screw in guard assembly. Do not remove shoulder screw from guard assembly. Refer to Figure 2A.

(f) With guard assembly (guard, pawl, spring and bushing) mounted on shoulder screw, insert screw through hole in left handle as shown in Figure 2A. Turn 1/4" nut onto screw, finger tight.
NOTE: *Be sure bushing is inside pawl. See Figure 2A, and items 3 and 4 of Figure 4.*

(g) Remove and discard existing center shoulder screw and nut, then align hole of guard assembly with center hole of tool. See Figure 2A.

(h) Orient rack with tool as shown in Figure 2.

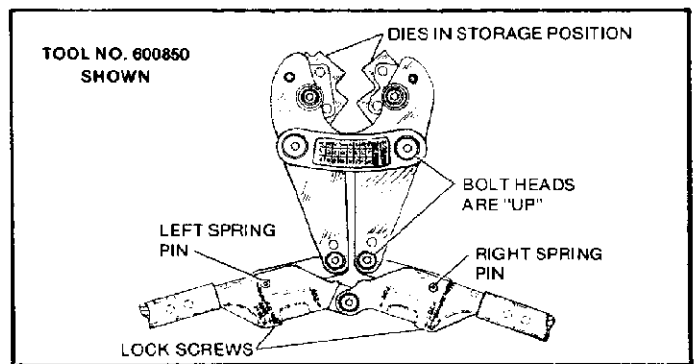
(i) Slide round center hole of rack between guard and handle. See Figure 2. DO NOT ENGAGE RACK WITH PAWL.

(j) Slide nylon anti-friction washer between guard and rack. See Figure 2A.

(k) Insert new 3/8" dia. center shoulder screw through guard, nylon washer, rack and tool handles as shown in Figure 2A. Turn 5/16" nut onto screw, finger tight.

(l) Remove and discard right spring pin (see Figure 1) using 1/4" drive punch.

(m) Insert 5/16" dia. shoulder screw through elongated hole in rack and hole in right handle as shown in Figure 2A. Turn 1/4" nut onto screw, finger tight.



TOOL NUMBER	STORAGE POSITION	
	LEFT DIE	RIGHT DIE
600850	E	A
601075	4	4
601129-1		
601260		
601999-1	H	J

Figure 1

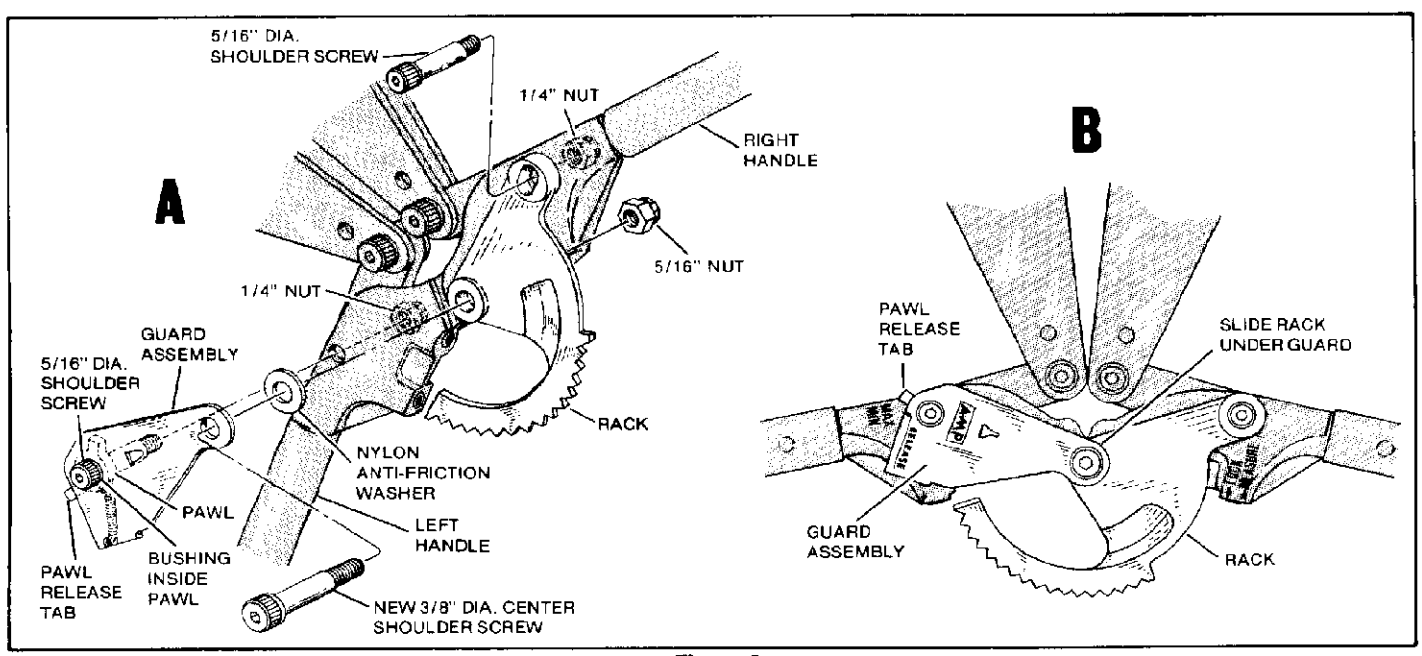


Figure 2

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(n) Tighten center shoulder screw nut against handle, then back off 1/4 turn.
(o) Tighten both 1/4" nuts against handles, then back off 1/4 turn.
(p) With handles fully open, tighten both lock (LOCK) screws that were loosened in step (c).
(q) Slowly close handles. BE SURE RACK SLIDES UNDER GUARD AND ENGAGES PAWL.
(r) Observe pawl release tab protruding from under guard assembly. See Figure 2. When it is necessary to open a partially closed tool, squeeze handles together slightly (to release pressure on pawl of release tab) then, push tab towards guard and hold, thereby disengaging ratchet.

3. HANDLE ADJUSTMENT INSPECTION

The handle adjustment should be checked to ensure that dies are bottoming fully. The handle adjustment feature is provided to compensate for normal tool wear.

To check handle adjustment:

(a) Open handles all the way.
(b) Rotate dies into storage position. See chart in Figure 3.
(c) Close handles until dies are bottomed but not under pressure.
(d) Measure distance between handles as shown in Figure 3. See chart in Figure 3 for MIN. and MAX. dimensions.

Adjustment is too tight if measurement exceeds MAX. dim.

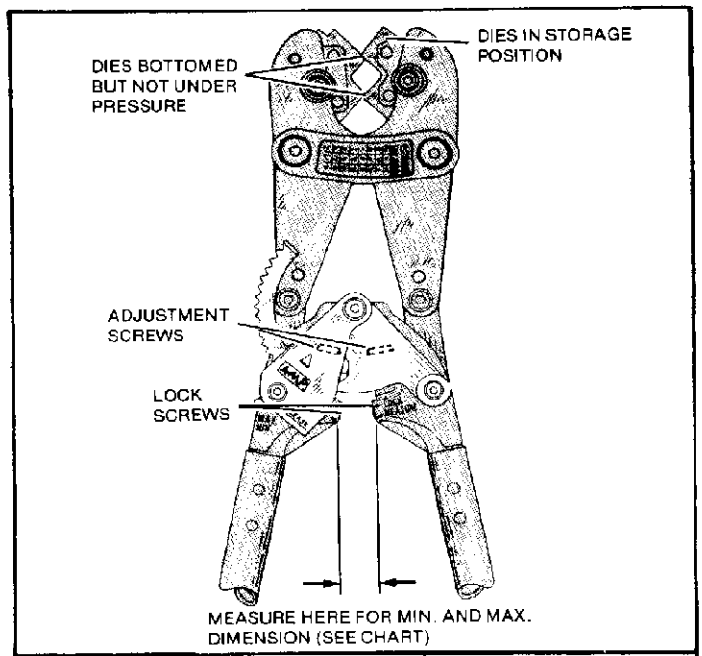
Adjustment is too loose if measurement is less than MIN. dim.

(e) To loosen adjustment, (if measurement exceeds MAX. dim., perform the following steps:
1. Turn both adjustment (ADJ.) screws counterclockwise approximately 1/2 to 3/4 turn.
2. Break both lock (LOCK) screws by turning counterclockwise.
3. Flex tool by opening and closing the handles.
4. Tighten both (LOCK) screws.
5. Close handles until dies are bottomed but not under pressure. Check measurement between handles and repeat adjustment procedure if necessary.

(f) To tighten adjustment (if measurement is less than MIN dim., perform the following steps:
1. Turn both lock (LOCK) screws counterclockwise approximately 1/2 to 3/4 turn.
2. Turn both adjustment (ADJ.) screws clockwise approximately 1/2 to 3/4 turn.
3. Flex tool by opening and closing handles.
4. Tighten both lock (LOCK) screws.
5. Close handles until dies are bottomed but not under pressure. Check measurement between handles and repeat adjustment procedure if necessary.

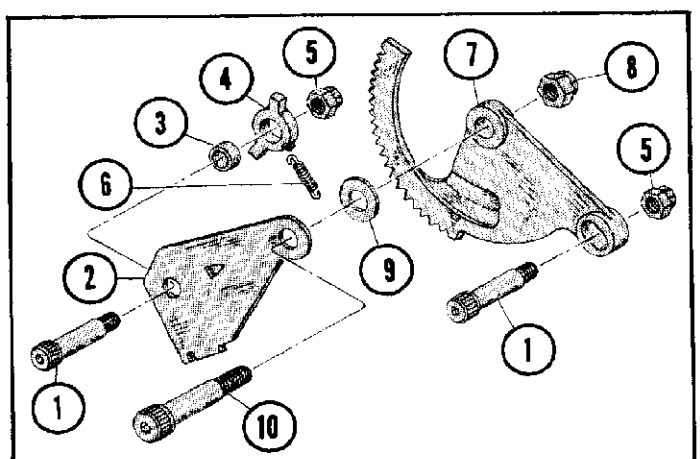
4. REPLACEMENT PARTS (Refer to Figure 4)

In the event of damage or wear to the ratchet assembly, customer replaceable parts can be purchased from AMP SPECIAL INDUSTRIES, Valley Forge, Pa. 19482.



TOOL NUMBER	DIE STORAGE POSITION		HANDLE ADJUSTMENT DIMENSION	
	LEFT DIE	RIGHT DIE	MIN.	MAX.
600850	E	A	1-3/8"	1-5/8"
601075	4	4	1-1/8"	1-3/8"
601129-1	4	4	1-3/8"	1-5/8"
601260	4	4	1-1/8"	1-3/8"
601999-1	H	J	1-1/8"	1-3/8"

Figure 3



ITEM NO.	PART NO.	QTY.	DESCRIPTION
1	604226-1	2	5/16" DIA. SHOULDER SCREW
2	604222-1	1	GUARD
3	604224-1	1	BUSHING
4	604223-1	1	PAWL
5	604227-1	2	1/4" NUT
6	604225-1	1	SPRING
7	604228-1	1	RACK
8	604231-1	1	5/16" NUT
9	604229-1	1	NYLON WASHER
10	604230-1	1	3/8" DIA. SHOULDER SCREW

Figure 4