

APPLICATION SPECIFICATION

1. SCOPE

This specification covers the requirements for application of AMP* CIS crimp snap-in receptacle contacts. These requirements are applicable to hand or automatic machine crimping tools. For specific wire and insulation ranges relative to the products covered in this specification see Figures 4 and 5.

2. NOMENCLATURE

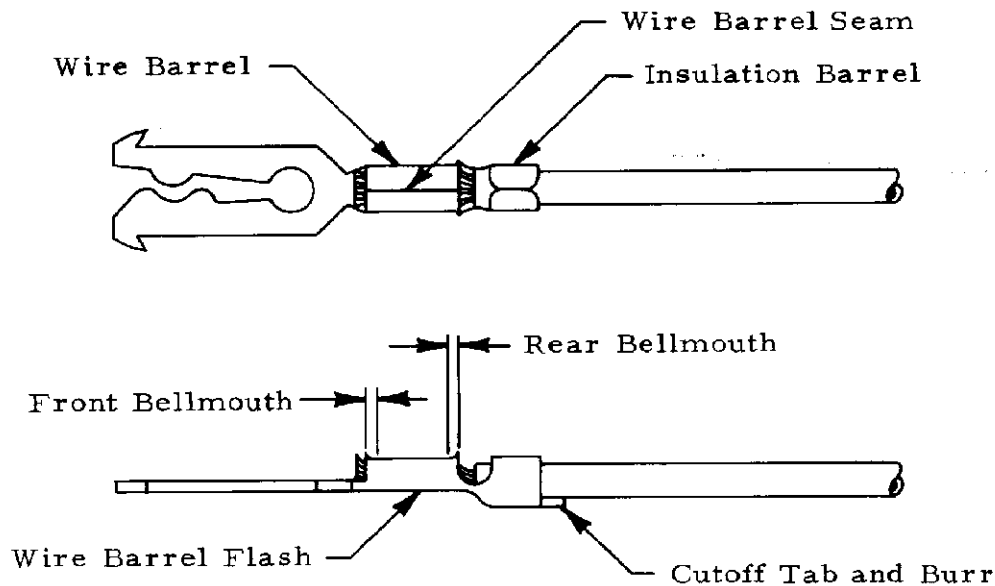


Figure 1

3. CRIMP AND DIMENSIONAL REQUIREMENTS

3.1. Wire Preparation

A. Strip Length

Insulation shall be stripped as indicated in Figures 4 and 5.

B. Workmanship

Reasonable care shall be taken not to nick, scrape or cut any strands or the solid wire during the stripping operation.

*Trademark of AMP Incorporated.

© COPYRIGHT 1977 BY AMP INCORPORATED, HARRISBURG, PA. ALL INTERNATIONAL RIGHTS RESERVED. AMP INCORPORATED PRODUCTS COVERED BY U.S. AND FOREIGN PATENTS AND/OR PATENTS PENDING.

DR	C.E. Feltz 7/14/77		AMP INCORPORATED Harrisburg, Pa.	
CHK	R. L. Schell 7/14/77			
APP	R. L. Schell 7-14-77		LOC	B
			NO	A
			114-1017	
			REV	A
SHEET			NAME	
1 OF 4			CONTACT, RECEPTACLE, CRIMP SNAP-IN, CIS, APPLICATION OF	
DIST	A	Rev Para 3.3.E.	4	4-26-78
LTR	REVISION RECORD		APP	DATE

3.2. Carrier Cutoff Tab and Burr

A. Cutoff Tab

Cutoff tab shall not exceed .010.

B. Burr

Burr on cutoff shall not exceed .005.

3.3. Wire Barrel Crimp

A. Crimp Dimensions and Type

Crimp height, width and type shall be as shown in Figures 4 and 5.

B. Tensile Strength

Crimp tensile strength shall be as shown in Figure 4.

C. Wire Barrel Flash

Wire barrel flash shall not exceed .005.

D. Wire Barrel Seam

Wire barrel seam shall be completely closed and there shall be no evidence of loose wire strands or wire strands visible in the seam.

E. Bellmouth

(1) Rear bellmouth length shall not exceed .020 and be within the requirements of Figure 2. In the event of conflict, the requirements of Figure 2 shall take precedence.

(2) Front bellmouth length shall not exceed .010.

F. Conductor Location

(1) End of the wire shall be flush with the front end of the wire barrel or extend .030 maximum after crimping.

(2) Both insulation and conductor shall be visible between the insulation barrel and wire barrel. Care shall be taken not to allow insulation to be crimped in the wire barrel.

3.4. Insulation Barrel Crimp

A. Crimp Dimensions and Type

Crimp height, width and type shall be as shown in Figures 4 and 5.

B. Workmanship

Reasonable care shall be taken not to cut or break the insulation during the crimping operation.



AMP INCORPORATED
Harrisburg, Pa.

SHEET

2 OF 4

LOC

B

A

NO

114-1017

REV

A

NAME

CONTACT, RECEPTACLE, CRIMP
SNAP-IN, CIS, APPLICATION OF

3.5. Alignment

A. Straightness

- (1) The contact shall be within the limits shown in Figure 2 after crimping.

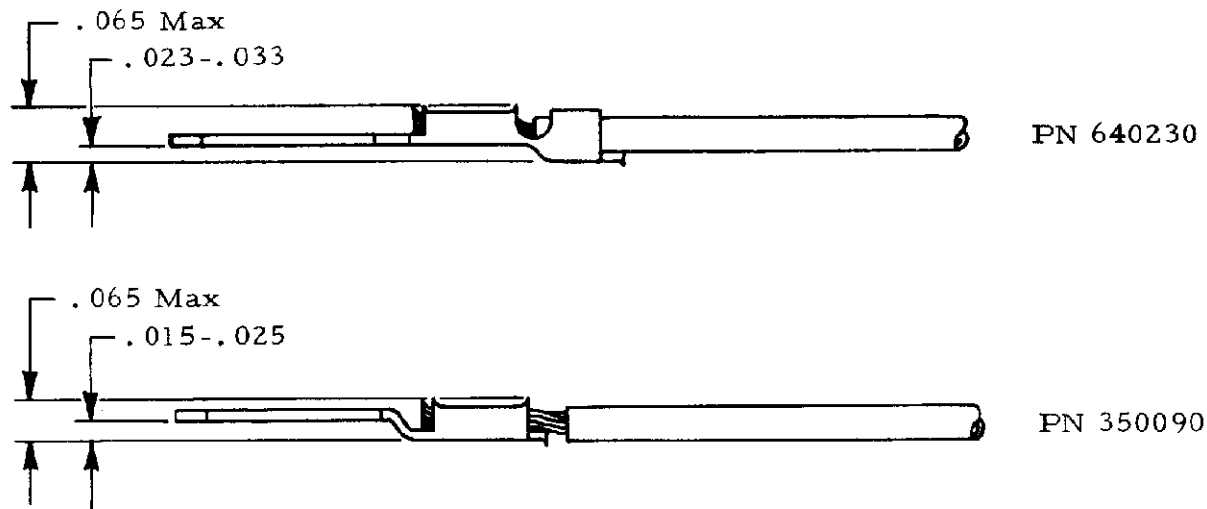


Figure 2

- (2) The side to side bending of the contact shall not exceed the limits specified in Figure 3.

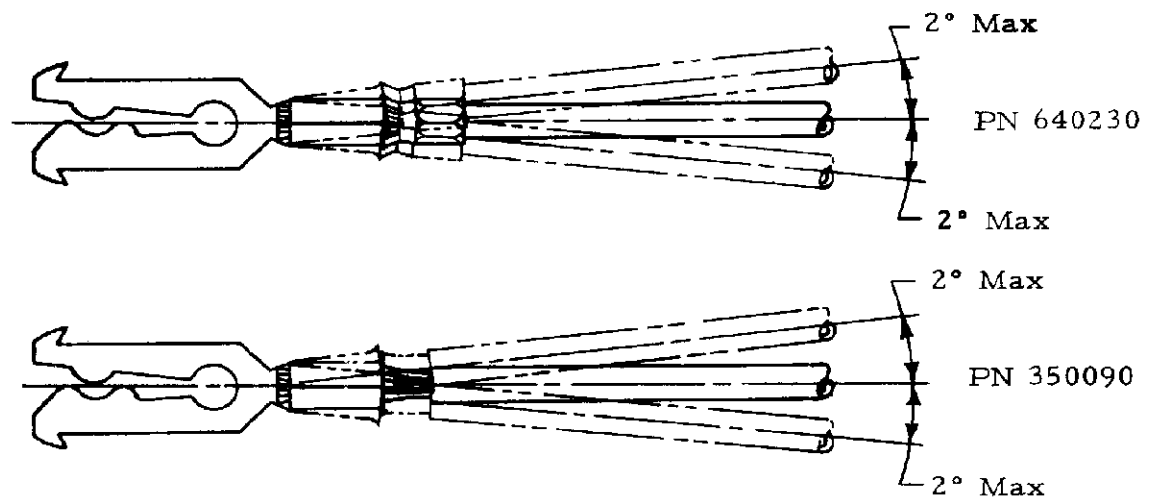


Figure 3

B. Twist or Roll

There shall be no twist or roll in crimped portion that will impair usage of the contact.

SHEET

3 OF 4



AMP INCORPORATED
Harrisburg, Pa.

LOC
B

A

NO

114-1017

REV
A

NAME

CONTACT, RECEPTACLE, CRIMP
SNAP-IN, CIS, APPLICATION OF



LOC B A NO 114-1017 REV A

NAME

CONTACT, RECEPTACLE, CRIMP
SNAP-IN, CIS, APPLICATION OF

SHEET
4 OF 4

Part No	Wires		Insulation Diameter	Strip Length $\pm .015$	Wire Barrel Crimp				Insulation Barrel Crimp		
	No	Size			Width	Height $\pm .002$	Type Crimper	Tensile Strength, lb min	width	Height, max	Type Crimper
350090	1	22	.070 max	.150	.090	.055	F	10	None	None	None
		20				.058		20			
		18				.062		40			
640230	1	26	.035-.060	.130	.070	.038	F	5	.080	.065	O
		24				.038		8			
		22				.042		10			
		20				.045		20			

Figure 4

Automatic Machine Wire Crimp Dimensions

Part No	Wires		Insulation Diameter	Strip Length $\pm .015$	Wire Barrel Crimp			Insulation Barrel Crimp			Hand Tool Part No
	No	Size			Width	Height $\pm .002$	Type Crimper	Width	Height, max	Type Crimper	
350556	1	22	.070 max	.150	—	—	—	None	None	None	90062 (a)
		20									
		18									
640276	1	26	.035-.060	.130	.062	.040	F	.062	.065	O	90339-1
		24				.040					
		22				.044					
		20				.044					

(a) Listed tool is best available.

Figure 5

Hand Tool Wire Crimp Dimensions