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

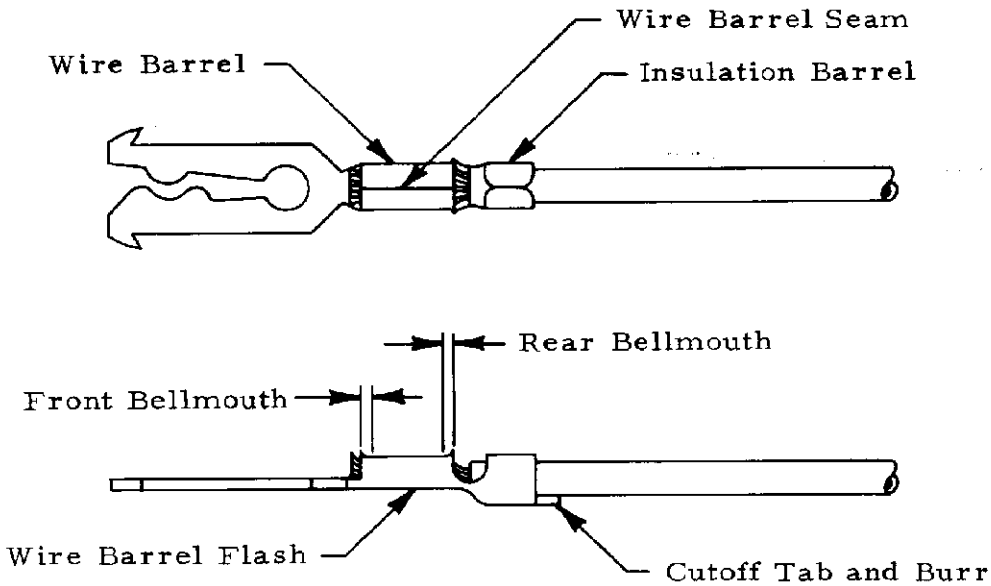

Figure 1

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.

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LTR	REVISION RECORD	APP	DATE
A	Rev Para 3.3.E.	[illegible]	4-26-78

DIST 1

DR C.E. Fritz 7/14/77
CHK H.K. Schelle 7/14/77
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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.

3.5. Alignment

A. Straightness

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

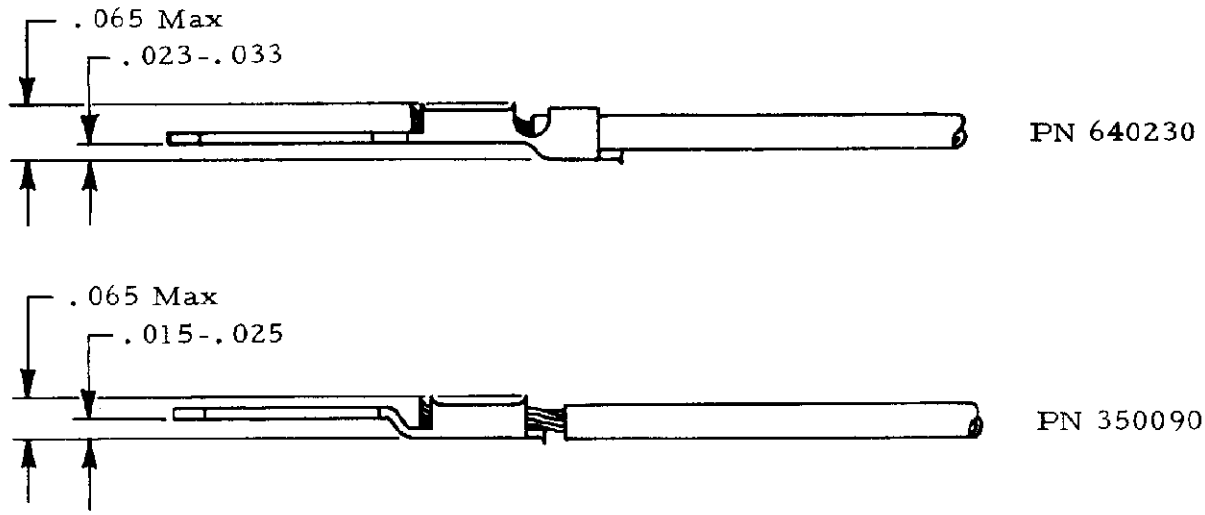

Figure 2

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

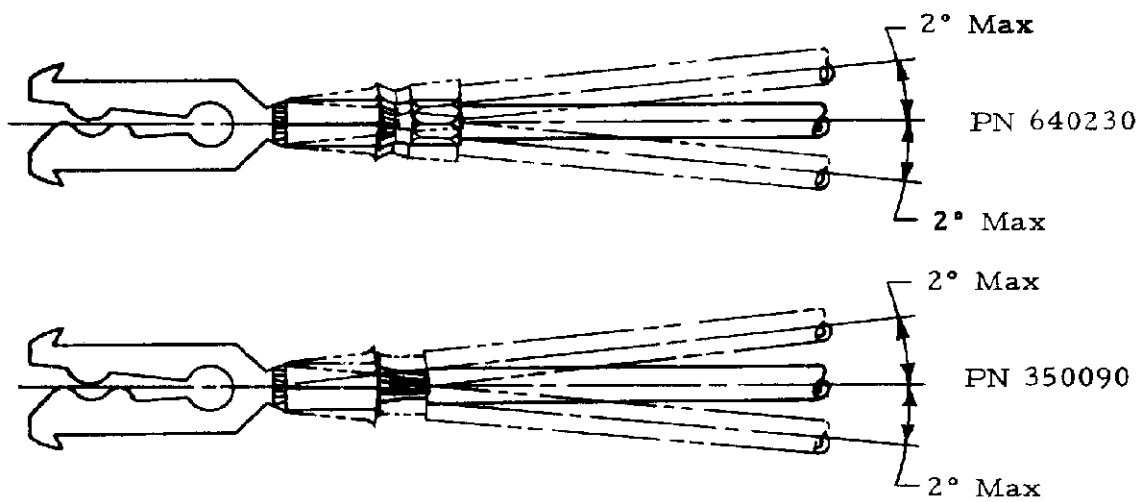

Figure 3

B. Twist or Roll

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

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Part No	Wires		Insulation Diameter	Strip Length ±.015	Wire Barrel Crimp				Insulation Barrel Crimp		
	No	Size			Width	Height ±.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 ±.015	Wire Barrel Crimp			Insulation Barrel Crimp			Hand Tool Part No
	No	Size			Width	Height ±.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