



Micro-MaTch Crimp On Snap In male on wire connector

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1. SCOPE

This specification covers the requirements for the application of AMP MicroMaTch Crimp on Snap in (COSI) connector serie.

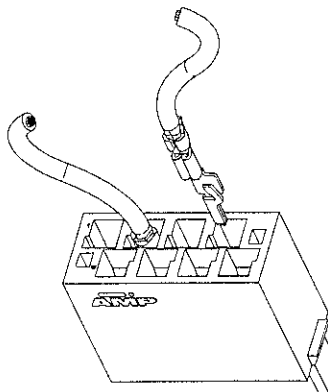


Figure 1

This connector is available with 2 crimp contacts: one for 20-24 AWG and one for 24-28 AWG discrete stranded wires

2. REFERENCED DOCUMENTS

2.1 Customer Drawings

The dimensions and materials of the contacts are shown in de AMP customer drawings C-338096 and C-338097. For the housings C-338095 is available.

2.2 Product Specification

The product specification 108-19052 describes the characteristics of the contact system.

2.3 Informational Material

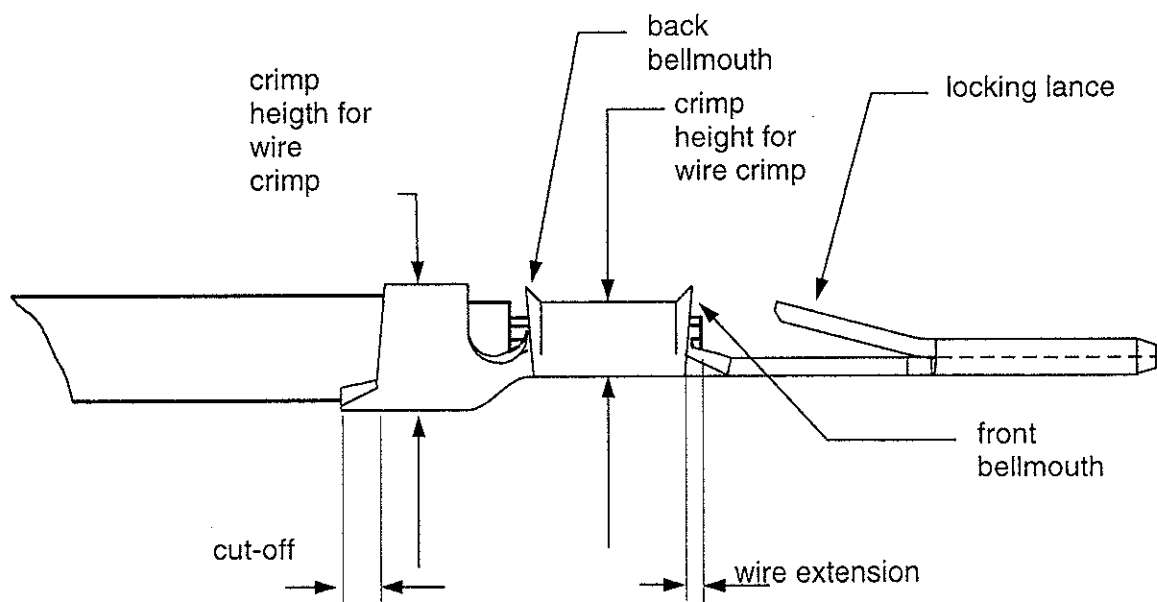
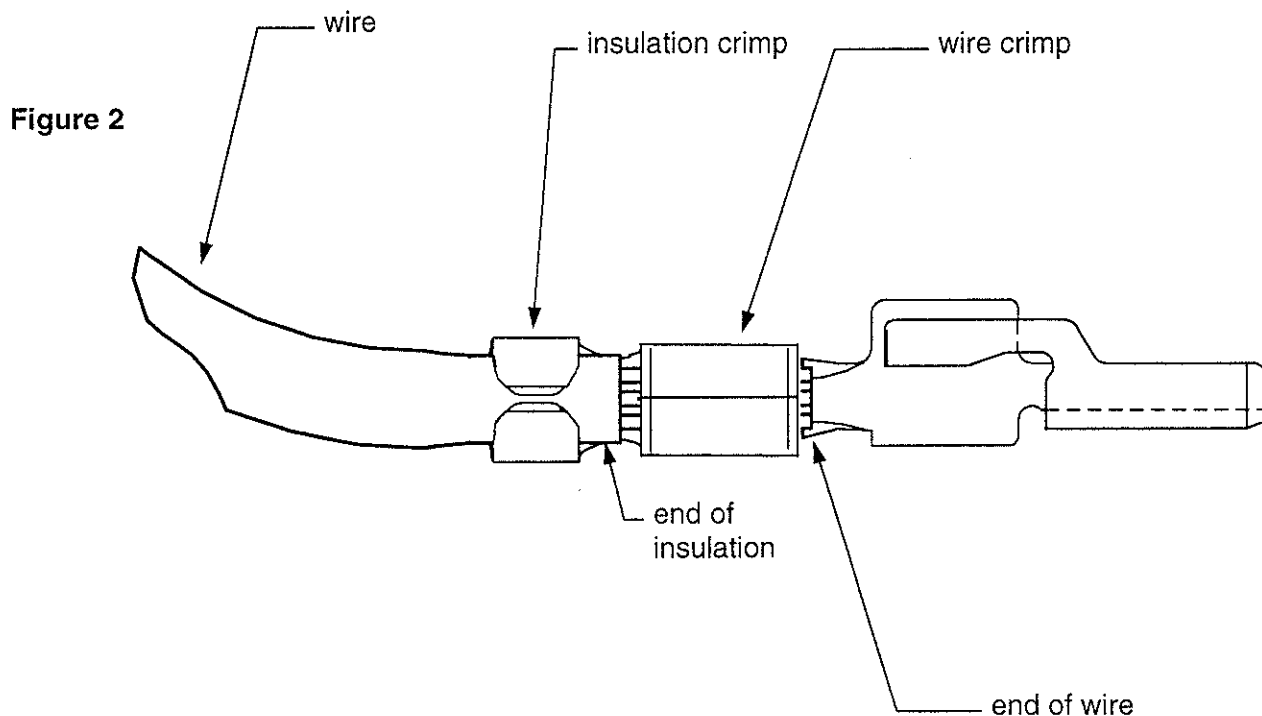
Information about the Kirsten PP3 stripper crimper (PN 872199-1) is available at Kirsten. For the reel fed handtool information see instruction sheet IS 411-19440.

2.4 Information Sheets

IS 7424 explains how to measure the crimp

3. DESCRIPTION

The following terms are used in this specification.



4. REQUIREMENTS

4.1 Wire

4.1.1 Selection

For contact 338096 stranded wires are approved from 24-28 AWG ($0,08^2 - 0,22^2$) with non-twisted conductors. Maximum allowed insulation diameter is $\varnothing 1,02$ mm. Minimum allowed insulation diameter is $\varnothing 0,76$ mm.

For contact 338097 stranded wires are approved from 20-24 AWG ($0,20^2 - 0,56^2$) with non-twisted conductors. Maximum allowed insulation diameter is $\varnothing 1,52$ mm. Minimum allowed insulation diameter is $\varnothing 1,27$ mm.

Other wires require approval from the responsible engineer.
Only single termination per contact is permitted.

4.1.2 Preparation

The wire insulation must be stripped to 2.5 mm, taking care that the individual strands are neither bent or cut off.

4.2 Cutoff

The cutoff must be visible after crimping. Its length may not exceed 0.25 mm.

4.3 Wire Crimp

4.3.1 Wire position

After crimping the end of the wire must flush or extend to 0.5 mm beyond the front edge of the wire crimp. In no case may the end of the insulation be crimped under the wire crimp.

4.3.2 Crimping data

The shape, height and width of the crimp, and the wire range, are shown in table 1.

Note: measure the crimp height in accordance with operating instructions IS 7424 with a crimp height micrometer, AMP Order No. 675836-0. The crimp width is a tool related dimension and is defined as the distance between the two tangential points of the rolling radii and the edges of the crimp. It is not possible to test the crimp-width for production monitoring purposes.

partnumber	wire size	wire crimp barrel		isolation crimp barrel	
		width	height ±.002"	width	height (range)
338096	24 AWG	.042"	.031"	.053" - .062"	.025" - .076"
	26 AWG		.029"		
	28 AWG		.026"		
338097	20 AWG	.055"	.030"	.053" - .062"	.045" - .076"
	22 AWG				
	24 AWG				

4.3.3 Extraction forces

The crimp extraction forces must comply with the requirements of product spec 108-19052.

4.3.4 Crimp bellmouth

In a contrast to the general guidelines, the size of the rear bellmouth must be visible. A missing of the front bellmouth is permitted.

4.3.5 Burr of the crimp.

Any flare on the base of the crimp may not exceed 0.1 mm.

4.4 Insulation Crimp

4.4.1 Position of the insulation

The end of the insulation must be visible in the transition the wire crimp and the insulation crimp. In no case may the end of the insulation be crimped in the wire crimp; conversely, the insulation must extend at least to the front edge of the insulation crimp.

4.4.2 Crimping data for insulation crimp

The shape, width and height of the crimp are shown in table 1

4.5 Contact Area

After crimping, the locking lance may not be bent or deformed

4.6 Contact insertion

Terminated contacts are inserted into the back of the connector housing, and snap in place. From the first and second cavity row the first cavities are numbered for your convenience.

Note: After inserting a contact into the housing, pull back slightly on the wire to make sure the contact is fully seated.

For correct inserting the contacts into the housing the contact locking spring must be positioned corresponding with the outside of the housing. See also Fig 3

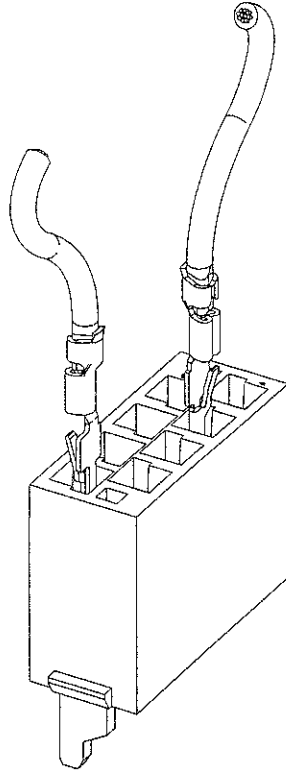


Figure 3

4.7 Repair

Use AMP extraction tool 734873-1 to remove individual contacts from housing for replacement or for relocation to another housing cavity. Damaged or worn contacts may be replaced provided there is sufficient slack, after restripping the wire, to insert the new contact.