



6,3mm Positiv Lock Contact

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1. INTRODUCTION

This specification covers the special guidelines for the application of the 6,3mm Positive Lock Contacts. The instructions are intended primarily for automatic or semiautomatic application of all versions, but may also be applied, if agreed, to hand tools. The various contact types are listed in table.1 sorted by their usage, wire ranges and crimp data.

2. ADDITIONAL DOCUMENTS

2.1 Customer Drawings

There is a customer drawing showing the dimensions and materials for each part number. In the case of a conflict between this document and a customer drawing, the customer drawing takes precedence.

2.2 Product Specifications

The Product Specification 108-18120-1 describe the characteristics of these contacts, together with the electrical and mechanical requirements.

2.3 Application Specifications

The general guidelines laid down in Application Specification 114-18022 also apply to the crimp quality.

2.4 Customer Information

CM 5128..... Contains information about crimping machines for MQC crimping tool.
AI 8025. Describes the Miniature-Quick-Change crimping tool.
IS 6764. Instruction Sheet for the AMP CERTI-LOK hand crimping tool.
IS 7424. Instruction sheet which explains how to measure the crimp height.

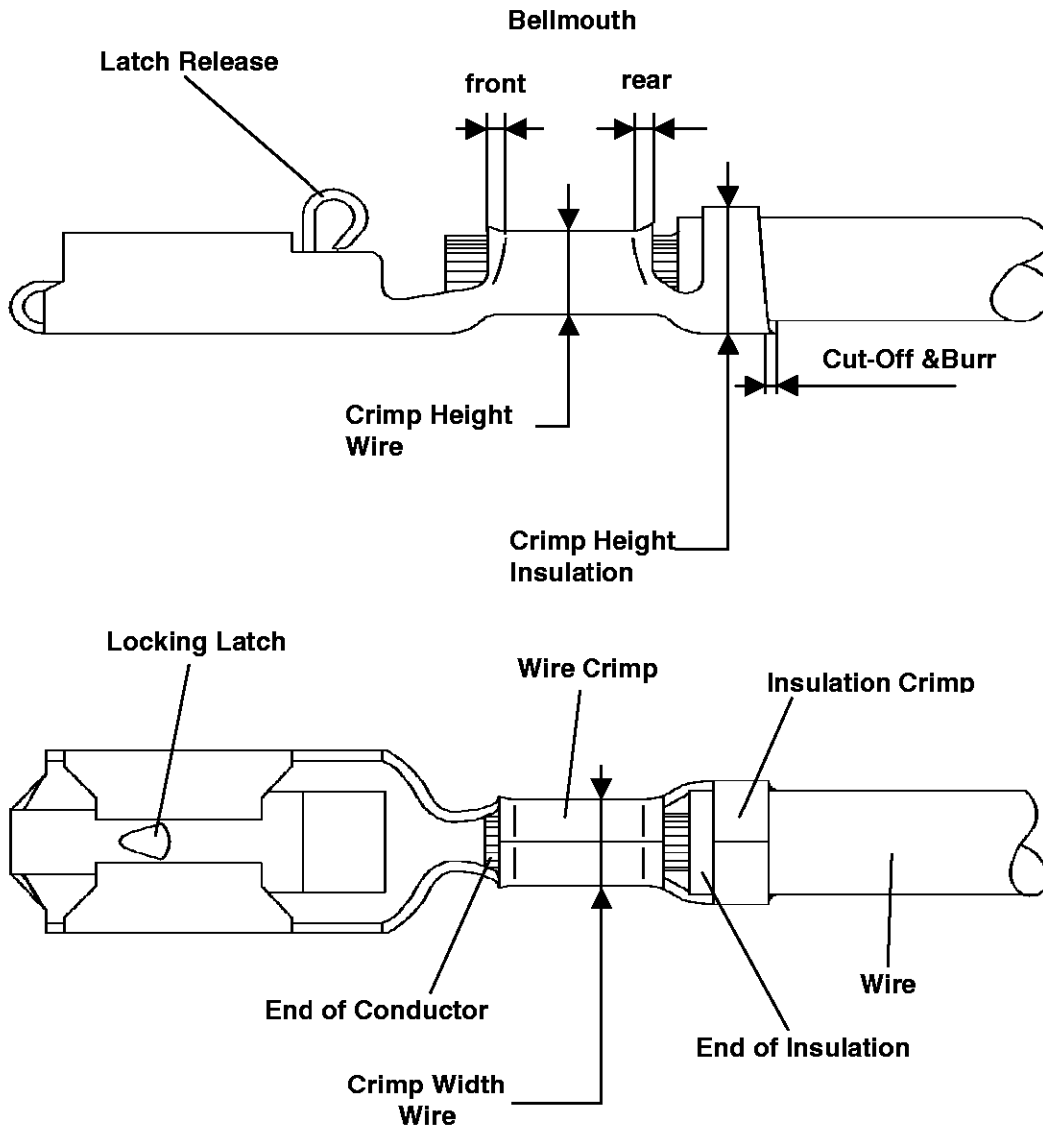
2.5 National / International Standards

DIN 72 551 T5/05.92.....Unscreened Low Tension Cables (FLR)
DIN 72 551 T6/01.92Unscreened Low Tension Cables (FLR)
DIN ISO 6722 T1/04.85Unscreened Low Tension Cables (FLK)
DIN ISO 6722 T2/04.84Unscreened Low Tension Cables (FLK)
DIN ISO 6722 T3/08.87.....Unscreened Low Tension Cables (FLK)
DIN IEC 352 T2/04.92.....Solderless Crimped Connections

3. DESCRIPTION

The terms shown below are used in the specification.

3.1 Contacts with Insulation Crimp (Figure 1)



4. REQUIREMENTS

4.1 Wires

A. Selection

The contacts are designed for FLR conductors to DIN 72 551 Part 5 and Part 6 or FLK conductors to DIN ISO 6722 Part 1, Part 2 and Part 3. Other wires require the approval of the Engineering Department. Single termination is preferred. Double termination within the wire range is possible only with restrictions.

B. Preparation

The wire must be stripped to the lengths shown in Table 1. Take care that the individual strands of the wire are not bent or cut off. The insulation must be clean and free of contamination.

4.2 Cut-Off and Burr

The cut-off must be visible after crimping. The maximum length of the cut-off is 0,5mm. Any burrs at the shearing point may not exceed 0.08mm.

4.3 Wire Crimp

A. Wire position

After crimping, the end of the wire must extend 0,1 ... 0,5mm beyond the front end of the wire crimp.

B. Crimp data

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

C. Extraction forces

The crimp extraction forces must fulfill the requirements of DIN IEC 352 Part 2.

D. Crimp bellmouth

The size of the rear bellmouth depends on the wire range:

0,20 - 0,50mm ² :	0,25 ±0,15mm
0,50 - 2,50mm ² :	0,40 ±0,20mm
2,50 - 6,00mm ² :	0,60 ±0,30mm

A front bellmouth is permissib

4.4 Insulation Crimp / Crimp for Single-Wire-Seal

A . Position of the end of the insulation

In the case of contacts for crimping on wires, the end of the insulation must be visible in the transition between the wire crimp and the insulation crimp. In no case may the insulation be crimped in the wire crimp; conversely, the insulation must extend at least to the front edge of the insulation crimp.

B. Crimp data for wires

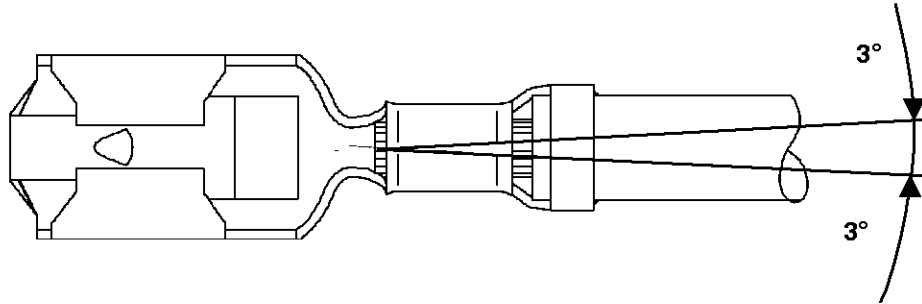
The shape and width of the crimp and the insulation diameter are shown in Table 1. The crimp height is adjusted either after the bending test to DIN 41611 Part 3 or after the roll test DIN IEC 352.2.

4.5 Contact Area

After crimping, neither the latch release, the protective line nor the contact body may be bent or deformed.

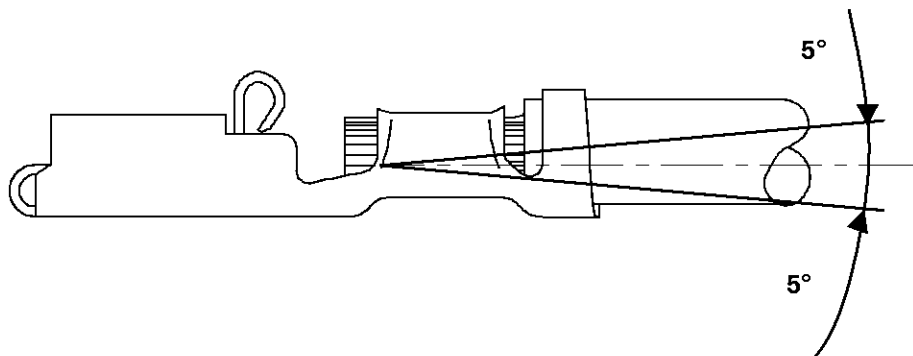
4.6 Requirements to the crimped Contact

A. Horizontal Angular Displacement of the Longitudinal Axis (Figure 2)



The horizontal angular displacement of the longitudinal axis in the crimping area may not exceed 3° in either direction.

B. Vertical Angular displacement of the Longitudinal Axis (Figure 3)



The vertical angular displacement of the longitudinal axis in the crimping area may not exceed 5° in either direction.

Crimp Data of Contacts with Insulation Crimp

Part-No.		Wire Sizes [mm ²]	Wire Type	InsulationØ [mm]	Stripped Length [mm] ± 0,3	Wire Crimp			Ins. N Crimp		Crimp Tool	Die for Hand Crimp Tool
Strip	Loose Piece					Width [mm]	Height [mm] ± 0,05	Shape	Width [mm]	Shape		
928909	928907	0,20	FLR	1,0-1,6	4,5	1,80	1,13	F	2,30	F	878185	*539744-2
		0,25					1,15					
		0,35					1,19					
		0,50					1,26					
927852	927853	0,50	FLR	1,4-2,3	6,0	2,05	1,43	F	2,80	OV	872094	*539743-2
		0,75					1,52					
		1,00					1,61					
927867	927868	0,50	FLK	2,0-3,3	6,0	2,05	1,43	F	3,30	F	872145	734372-1 mit Matriz 734469-0
		0,75					1,52					
		1,00					1,61					
927881	927882	1,50	FLK	2,7-3,7	6,0	2,80	1,76	F	3,95	F	878045	*734372-1 mit Matriz 734384-1
		2,00					1,90					
		2,50					2,04					
927854	927855	1,50	FLR	2,1-3,1	6,0	2,80	1,76	F	3,55	OV	872095	*539743-2
		2,00					1,90					
		2,50					2,04					
928958	928959	3,00	FLK	3,3-4,7	6,0	3,30	2,16	F	4,55	OV	878375	*539745-2
		3,50					2,27					
		4,00					2,38					
928960	928961	5,00	FLK	4-5,3	5,8	4,05	2,39	F	5,35	OV	878374	*539745-2
		5,50					2,48					
		6,00					2,58					

*PN of Die for ERGOCRIMP Base Hand Crimp Tool 539635-1

Table 1