

AMP MODU\* Mod.II Interconnection System, Receptacle Contact

1. SCOPE

1.1 Content

This specification covers the requirements for application of AMP MODU\* Mod.II 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 Figure 5.

1.2 Reference Specification

For applicable performance requirements, see AMP Specification 108-20025.

2. NOMENCLATURE

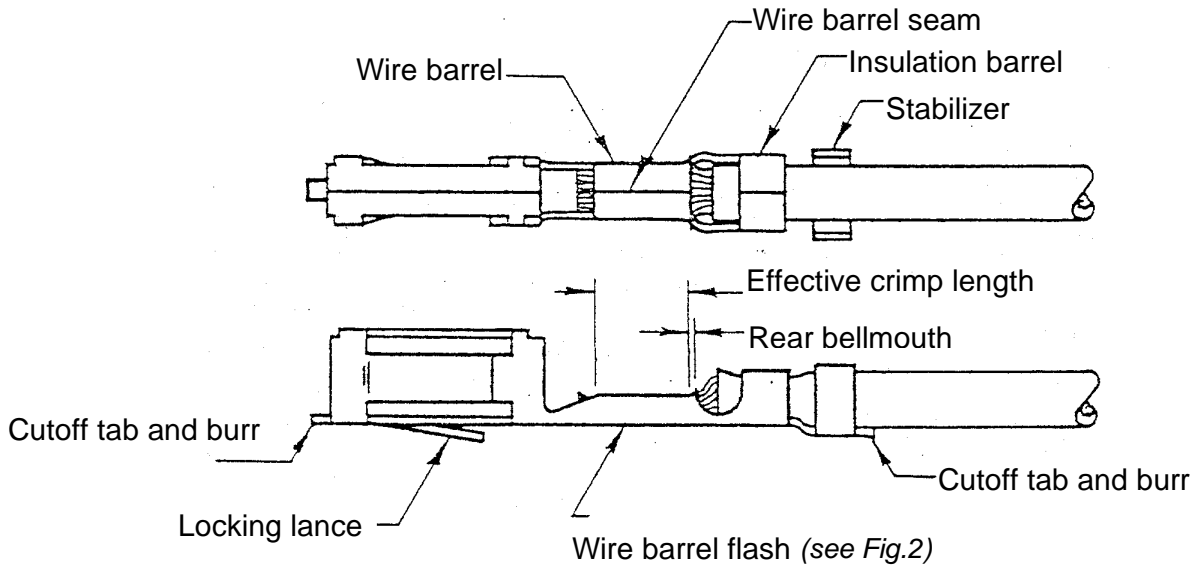


FIGURE 1  
(Receptacle with stabilizer illustration)

Product Code : 5434

B	REVISED hand tool pn on PAGE 4	R.F.	07/JAN/10	M.W.	07/JAN/10
A5	Corrected Crimp Height EC ET00-0230-02	R.M.	11/NOV/02	C.T.	11/NOV/02
A4	Modf bellmouth DIM to .020 and crimp length EC ET00-0095-02	R.M.	15/MAY/02	C.T.	15/MAY/02
A3	ADDED 0,3 Sq mm FOR 22 AWG PER EC ET00-0142-01	R.M.	28/MAY/01	C.T.	28/MAY/01
A2	ADDED Sq mm WIRE SIZE PER EC ET00-0049-01	R.M.	09/FEB/01	C.T.	09/FEB/01
rev letter	rev. record	DR	Date	CHK	Date
DR. R. FABRIS	DATE 31/AUG/99	APVD C. TARTARI	DATE 31/AUG/99		

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**3. CRIMP AND DIMENSIONAL REQUIREMENTS**

**3.1 Wire preparation**

**A. Strip Length**

Insulation shall be stripped as indicated in Figure 5.

**B. Workmanship**

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

**3.2 Carrier cutoff tab and burr**

**A. Cutoff tab**

Cutoff tab shall not exceed .015

**B. Burr**

Burr on cutoff tab shall not exceed .003

**3.3 Wire barrel crimp**

**A. Crimp dimensions and type**

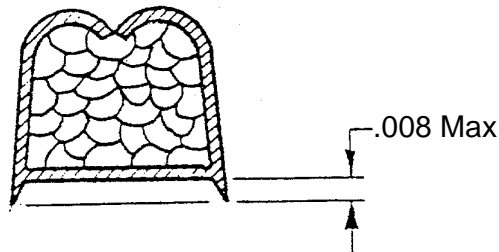
Crimp height, width and type shall be as shown in Figure 5.

**B. Effective crimp length**

Effective crimp length shall be .070 minimum, and is defined as that portion of the barrel, excluding bell mouth, fully formed by the crimping tool (.110min for contacts without stabilizer, see Figure 5).

**C. Wire barrel flash**

Wire barrel flash shall not exceed the limits shown in Figure 2.



**FIGURE 2**

**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. Bell mouth**

Rear bell mouth length shall be .005±.020.

**F. Conductor location**

1. End of the wire shall be flush with the front end of the wire barrel or extend .010 maximum after crimping
2. Insulation can be flush with either the rear of the wire barrel or the front of the insulation 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 Figure 5.

B. *Workmanship*

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

3.5 Locking lance

Locking lance shall not be deformed.

3.6 Alignment

A. *Straightness*

1. The contact, including the cutoff tab and burr shall not be bent above or below the datum line more than the amount shown in Figure 3.

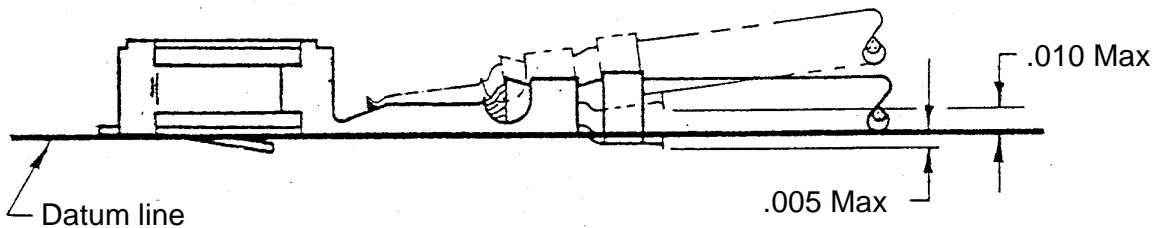


FIGURE 3

2. The side to side bending of the contact shall not exceed the limits specified in Figure 4.

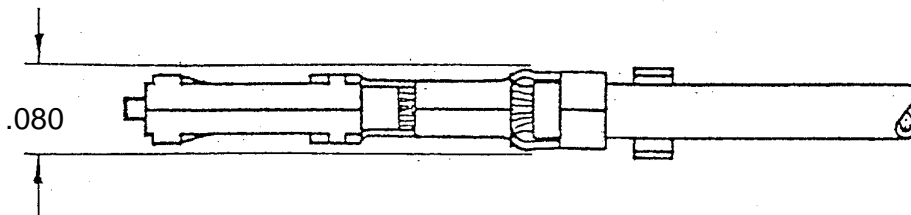


FIGURE 4

B. *Twist or roll*

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

**AUTOMATIC MACHINE: WIRE CRIMP DIMENSIONS**

PART N° STRIP FORM	WIRE SIZE			INSULATION  DIAMETER	STRIP  LENGTH	WIRE BARREL CRIMP			INSULATION BARREL CRIMP		
	Q.TY	AWG	Sq mm *			WIDTH	HEIGHT	TYPE	WIDTH	HEIGHT	TYPE
280422	1	28 ÷ 30	0,09 ÷ 0,05	.025 ÷ .050	.110 ÷ .140	.055	.022 ± .001	F	.062	.050	O
280709	1	28 ÷ 30	0,09 ÷ 0,05	.025 ÷ .050	.110 ÷ .140	.055	.022 ± .001	F	.062	.050	O
280530	1	22 ÷ 24 26	0,4 ÷ 0,2 0,12	.040 ÷ .061	.110 ÷ .140	.055	.027 ± .001 .025 ± .001	F	.062	.063	O
280708	1	22 ÷ 24 26	0,4 ÷ 0,2 0,12	.040 ÷ .061	.110 ÷ .140	.055	.027 ± .001 .025 ± .001	F	.062	.063	O
281556 (a)	1	20 22 24	0,5 0,4 ÷ 0,3 0,2	.063	.140 ÷ .170	.055	.035 ± .001 .033 ± .001 .029 ± .001	F	.062	.063	F
281999 (a)	1	20 22 24	0,5 0,4 ÷ 0,3 0,2	.063	.140 ÷ .170	.055	.035 ± .001 .033 ± .001 .029 ± .001	F	.062	.063	F

**HAND TOOL: WIRE CRIMP DIMENSIONS**

PART N° LOOSE PIECE	PART N° HAND TOOL	WIRE SIZE			INSULATION  DIAMETER	STRIP  LENGTH	WIRE BARREL CRIMP			INSULATION BARREL CRIMP		
		Q.TY	AWG	Sq mm *			WIDTH	HEIGHT	TYPE	WIDTH	HEIGHT	TYPE
181271	58654-1	1	28 ÷ 30	0,09 ÷ 0,05	.040 ÷ .050	.110 ÷ .140	.055	.022 +0 -0.0005	F	.062	.055	O
182207		1	28 ÷ 30	0,09 ÷ 0,05	.040 ÷ .050	.110 ÷ .140	.055	.022 +0 -0.0005	F	.062	.055	O
181270	58654-1 58535-1	1	22 24 ÷ 26	0,4 ÷ 0,3 0,2 ÷ 0,12	.040 ÷ .056	.110 ÷ .140	.055	.028±.0015 .0245±.0015	F	.062	.056	O
182206	91537-1	1	22 24 ÷ 26	0,4 ÷ 0,3 0,2 ÷ 0,12	.040 ÷ .056	.110 ÷ .140	.055	.028±.0015 .0245±.0015	F	.062	.056	O
182698 (a)	783560-1	1	20 ÷ 24	0,5 ÷ 0,2	.063	.140 ÷ .170	.055	.032±.001	F	.062	.065	O
182913 (a)		1	20 ÷ 24	0,5 ÷ 0,2	.063	.140 ÷ .170	.055	.032±.001	F	.062	.065	O

**FIGURE 5**

(a) Parts do not contain stabilizer

\* Wire size in Sq mm is for reference only.