

114-5069
Application Specification
Crimping AMP Multi-tap Connector,
Crimp, Snap-in Type Receptacle Contacts

1. Scope:

This specification covers requirements for crimping of AMP Multi-tap Connector, Crimp, Snap-in Type, Receptacle Contacts of the part numbers specified in Para. 2.

2. Applicable Contact Part Numbers:

Part Numbers	Descriptions
172751, 172754, 172757	Receptacle Contact, (Strip Form)
172752, 172755, 172758	Receptacle Contact, (Loose Piece)

3. Nomenclature:

For the purpose of this specification, the following terms shall apply.

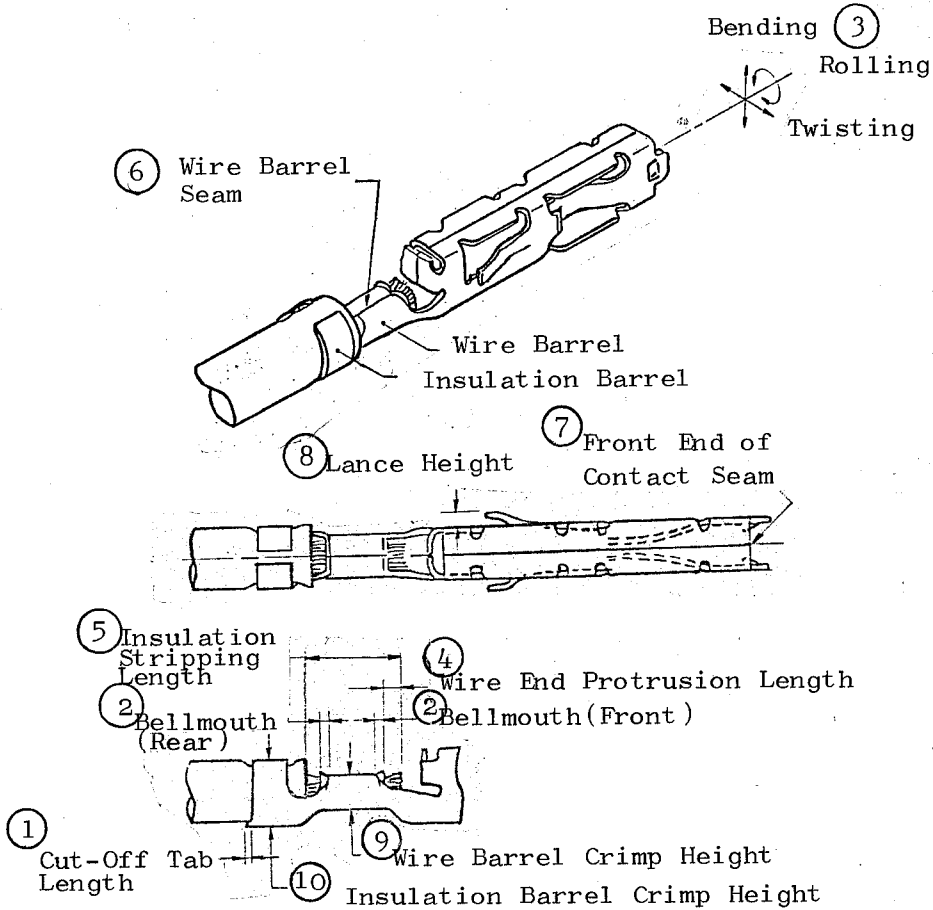


Fig. 1

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		DR <i>[Signature]</i>	AMP AMP (Japan), Ltd. TOKYO, JAPAN		NO 114-5069	REV 01	
		CHK <i>Y. Fujimura</i> 11-22 '85					
		APP <i>Tallos</i> 11/22 '85	LOC J A				
01	Revised RFA-1814	<i>[Signature]</i> 6-30 '85	SHEET 1 OF 3				NAME Application Specification Crimping of AMP Multi-tap Connector, Crimp, Snap-in Type, Receptacle Contact
0	Released RFA-637	<i>[Signature]</i> 11/22 '85					
LTR	REVISION RECORD	DR	CHK	DATE			


114-5069 NUMBER Customer Release AMP SECURITY CLASSIFICATION	4. Crimp and Crimp Data:				
	4.1 Crimping Requirements:				
	No.	Check Items	Contact Numbers	Requirements after Crimping	Remarks
				172751-1, 172754-1, 172757-1 172752-1, 172755-1, 172758-1	
	1.	Cut-Off Tab Length		0.5 max.	Fig.1 (1)
	2.	Bellmouth	Front	Its forming must be visually confirmed.	Fig.1 (2)
			Rear	0.05-0.65mm (It must be visually confirmed.)	
	3.	Deformation after Crimping	Bending	7° max. (Bend-Up & Bend-Down Inclusive)	Fig.1 (3)
Twisting			6° max.		
Rolling			13° max.		
4.	Wire End Protrusion Length		0.15 - 1.5 mm	Fig.1 (4)	
5.	Insulation Stripping Length (REF.)		4.5 - 5.0 mm	Fig.1 (5)	
6.	Wire Barrel Seam		Wire barrel seam must be neatly closed.	Fig.1 (6)	
7.	Gap of Front Contact Seam		0.2 mm max.	Fig.1 (7)	
8.	Lance Height (Right & Left)		0.6 - 0.8mm	Fig.1 (8)	

4.2 Crimp Data:

4.2.1 Applicator Crimp:

Contact Part No. (Strip)	Wire Size (mm ²)	Applicator Number (See Note 3.)	Wire Barrel Crimp			Insulation Barrel Crimp			Crimp (kg Tensile Strength)
			Width (mm)	Height (Note 1.)	Disc Ltr.	Width	Height Fig.1 (10)	Disc	
172757-1	0.08	752828-1 -2	1.40 "F"	0.91	C	2.03 "F"	1.7 max.		1.3min.
	0.14			0.95	B				2.5 min.
	0.20			0.98	A				3.6 min.
172754-1	0.20	752827-1 -2	1.78 "F"	1.04	D	2.79 "O"	2.8 max.		3.6 min.
	0.30			1.08	C				5.4 min.
	0.50			1.17	B				9.0 min.
	0.75			1.30	A				14.6 min.
172751-1	0.50	752826-1 -2	2.54 "F"	1.20	D	3.56 "O"	3.6 max.		9.0 min.
	0.75			1.34	C				14.6 min.
	1.25			1.45	B				22.6 min.
	2.0			1.66	A				31.7 min.

- Notes: (1) The tolerance of wire barrel crimp height must be within ± 0.05 mm. Fig.1 (10)
 (2) Unless otherwise noted, all the dimensions in the tables are in millimeters.
 (3) The applicator dash numbers, -1 tooling is for AMP-O-MATOR, and -2 tooling is for Automachine.

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4.2.2 Hand Tool Crimp:

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Contact Part No. (Loose Piece)	Wire Size (mm ²)	Hand Tool Part No.	Insulation Diameter (mm)	Crimp Symbols	Wire Barrel Crimp Height (mm)	Crimp Height Control Gage No.	Crimp Tensile Strength (kg)
172758-1	0.08	752929-1	0.8-1.1	A	0.78 - 0.96	289016-208	1.3 min.
	0.20		1.0-1.4	B	0.83 - 1.00	289016-209	3.6 min.
172755-1	0.20	752928-1	1.1-1.6	A	0.94 - 1.07	289016-206	3.6 min.
	0.3						5.4 min.
	0.5		2.0-2.8	B	1.06 - 1.22	289016-207	9.0 min.
	0.75						14.6 min.
172752-1	0.50	752927-1	2.0-3.2	A	1.09 - 1.24	289016-204	9.0 min.
	0.75						14.6 min.
	1.25		3.0-3.4	B	1.39 - 1.51	289016-205	22.6 min.
	2.00						31.7 min.

5. Applicable Wires:

Wire Size Nominal	Number of Conductors / Diameter of a Conductor	Calculated Cross sectional Area (mm ²)	Insulation Diameter (mm)	Remarks
0.08	7 / 0.12	0.08	0.8 Standard	
	7 / 0.127	0.09	1.0 "	
0.20	7 / 0.2	0.22	1.05 "	
	19 / 0.12	0.21	1.4 "	
0.30	12 / 0.18	0.30	1.6 "	
0.50	19 / 0.18	0.48		
	20 / 0.18	0.51	2.0 & 2.6 Standard	
0.75	30 / 0.18	0.76	2.2 & 2.8 Standard	
1.25	7 / 0.45	1.11	3.0 "	
	40 / 0.18	1.02	3.2 "	
	50 / 0.18	1.27	3.1 "	
2.0	7 / 0.6	1.98	3.4 "	
	37 / 0.26	1.96	3.4 "	

Application Tooling Design Group:

Designed by: J. Yoshioka
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Approved by: K. Tominoi
K. Tominoi

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