

114-5079

Application Specification

Crimping ".312" Series, Positive Lock, Flag Receptacle Contact

1. Scope:

This specification covers requirements for crimping ".312" Series, Positive Lock, Flag Receptacle Contacts of the numbers, shown in Para. 2.

2. Applicable Part Numbers:

The products of the following part numbers shall be governed under this specification.

Contact Part No.	Contact Form	Application Tooling Number	Type of Tooling
172795-1	Strip Form	752838-2	Miniature Quick Change Applicator
172796-1			

3. Nomenclature:

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

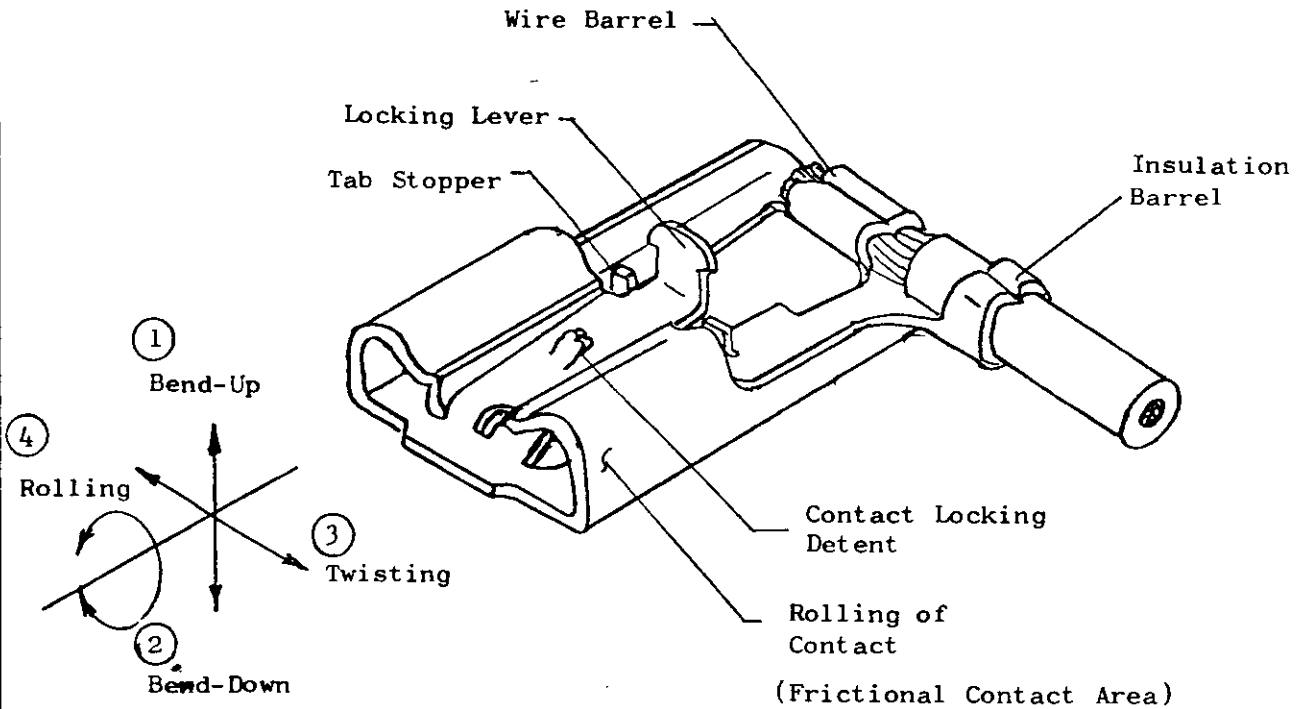


Fig. 1

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	A	Revised J-0784	J.K.			APP	<i>[Signature]</i>							
	O1	Revised RFA-1814	<i>[Signature]</i>					10/8/83						
	O	Released per RFA-588	<i>[Signature]</i>											
	LTR	REVISION RECORD	DR	CHK	DATE	SHEET		NAME Application Specification						
							1 OF 3		Crimping ".312" Series, Positive Lock Flag Receptacle Contact					

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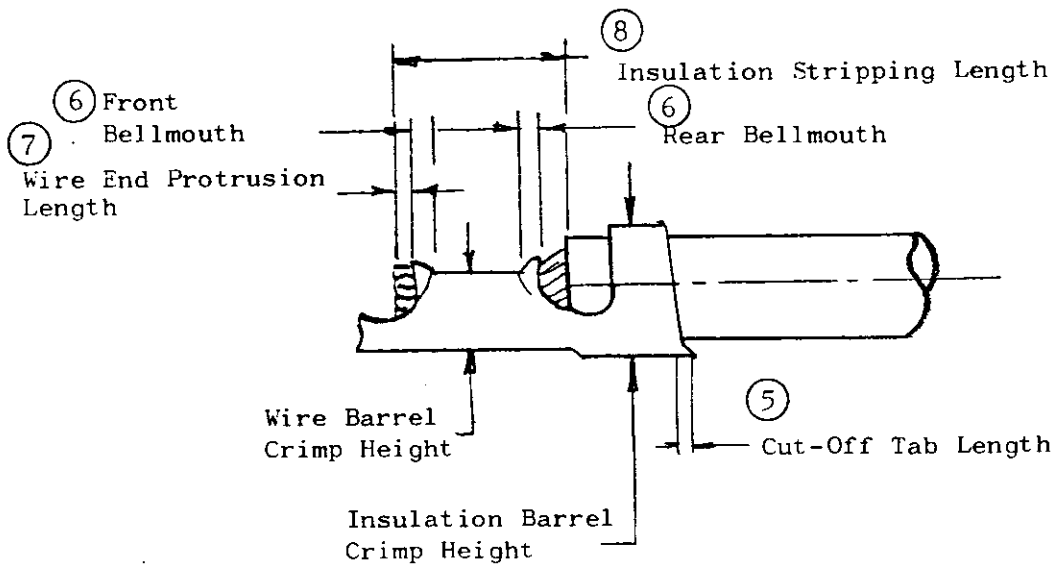


Fig. 2

4. Crimping Requirements and Crimp Data:

4.1 Crimping Requirements:

Check Points		Requirements	Remarks
Allowable Limits of Crimping Deformation	Bend-Up	3° max.	Fig. 1 (1)
	Bend-Down	5° max.	" 1 (2)
	Twisting	3° max.	" 1 (3)
	Rolling	5° max.	" 1 (4)
Cut-Off Tab Length		0.5mm max.	Fig. 2 (5)
Length	Front Bellmouth	0.7mm max.	" 2 (6)
	Rear Bellmouth	0.2 - 0.7mm	" 2 (6)
Length of Wire End Protrusion		0 - 2mm	" 2 (7)
Length of Insulation Stripping		7 <sup>+</sup> <sub>-</sub> 0.5mm	" 2 (8)

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2 OF 3	LOC J A	NO 114-5079	REV. B	
NAME Application Specification Crimping "312" Series, Positive Lock Flag Receptacle Contact				

4.2 Crimp Data:

Contact Part No.	Applicator Number	Wire Size		Wire Barrel Crimp		Insulation Barrel Crimp	
		mm <sup>2</sup>	(AWG)	Width mm	Height mm	Width mm	Height mm
172795-1	752838-2	0.5	(#20)	2.29	1.30	3.56	3.4
		0.85	(#18)		1.34		
172796-1		1.25	(#16)	"F"	1.50	"F"	max.
		2.0	(#14)		1.78		

5. Crimp Tensile Strength:

Tensile strength of the wire crimp shall meet the requirements specified in the following table.

Wire Size		Tensile Strength (min.)	
mm <sup>2</sup>	(AWG)	kg	(lbs.)
0.5	(#20)	9.0	(19.84)
0.85	(#18)	13.0	(28.66)
1.25	(#16)	18.0	(39.68)
2.0	(#14)	27.0	(59.52)


6. Applicable Wires:

Wire Size		Strand Composition		Calculated Cross-sectional Area (mm <sup>2</sup> )	Insulation Diameter (mm) Nominal	Wire Marking
mm <sup>2</sup>	(AWG)	Number of Strands	Diameter of a Strand			
0.5	(#20)	7	0.32	0.56	2.2	AV
0.85	(#18)	11	0.32	0.88	2.4	AV
1.25	(#16)	16	0.32	1.29	2.7	AV
2.0	(#14)	26	0.32	2.09	3.1	AV
<del>1.25</del>	<del>(#16)</del>	<del>16</del>	<del>0.32</del>	<del>1.29</del>	<del>2.1</del>	<del>CAVS</del>
1.25	(#16)	19	0.29	1.26	2.1	AVSS

Application Tooling

Design Engineer: J. Kaga 10/5/83

Approved by: V. Tomioka 10/5/83

SHEET				AMP (Japan), Ltd. TOKYO, JAPAN	
3	OF 3			LOC	A
NAME		Application Specification			
Crimping "312" Series, Positive Lock Flag Receptacle Contact					
		REV.	B		

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