

114 - 5208
Application Specification
Crimping of SHUR PLUG* Contacts

NUMBER: 114 - 5208

Customer Release

SECURITY CLASSIFICATION:

1. Scope:

This specification covers the requirements for crimping of AMP SHUR PLUG* Contact of the part numbers listed in Para. 2.

2. Applicable Contact Part Numbers:

The contacts of the part numbers shown below are applicable to this specification.

Descriptions	Part Number	Descriptions	Part Number
Ø4 SHUR PLUG* Contact	170002-X	Ø5 SHUR PLUG* Receptacle Contact	170003-4

3. Nomenclature:

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

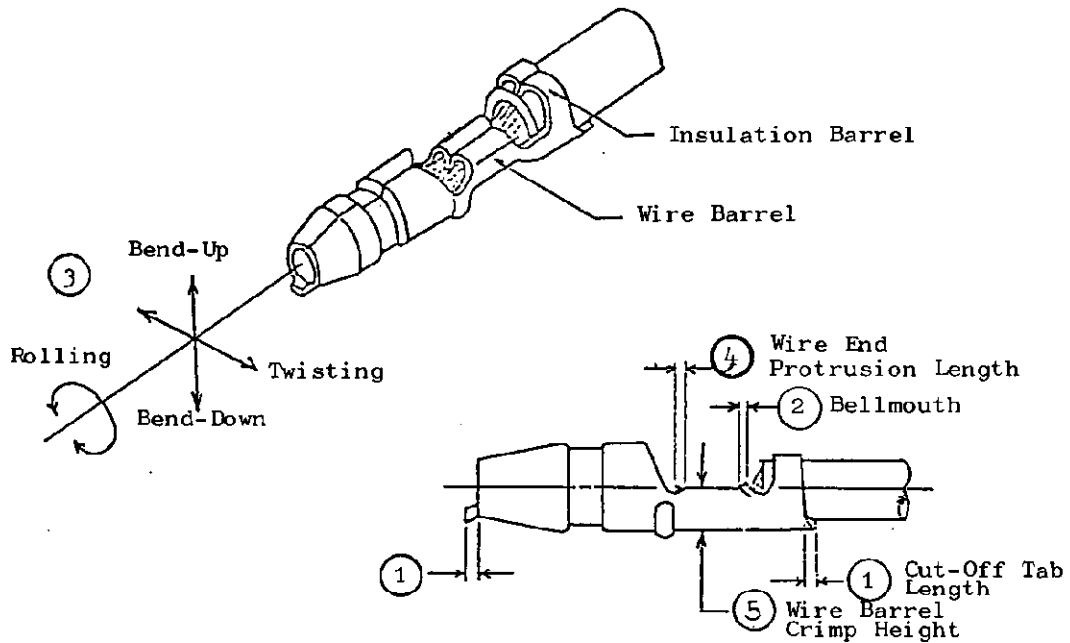


Fig. 1

PRINT	DST.	O	ECN FJ00-2077-95	DR. 2-25-95	CHK. 27.FEB.'95	APP. 27 FEB '95	SHEET 1 OF 3	<p style="text-align: center;">AMP AMP (Japan), Ltd. Kawasaki, Japan</p>		
LTR	REVISION RECORD	DR	CHK	DATE	NAME Crimping of SHUR PLUG* Contacts					

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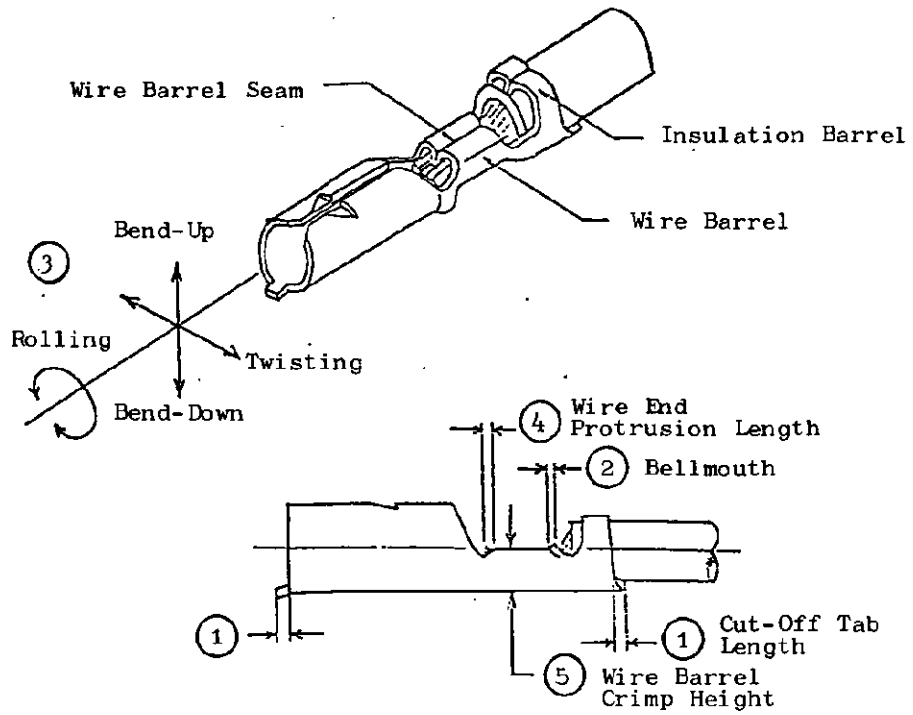


Fig. 2

SHEET 2 OF 3	AMP		AMP (Japan), Ltd. Kawasaki, Japan	
			LOC	LOC
NAME Crimping of SHUR PLUG* Contacts				

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4. Crimping Conditions and Crimp Data:
4.1 Crimping Conditions:

No.	Check Items	Crimping Requirements	Remarks
1	Cut-Off Tab Length	0.5mm max.	Fig. 1 (1)
2	Bellmouth(Rear End of the Barrel)	0.2 - 1.0mm	Fig. 1 (2)
3	Allowable Limits of Deformation after Crimping	Bend (Up/Down)	6° max.
		Twisting	6° max.
		Rolling	12° max.
4	Wire End Protrusion Length	0 - 1.5mm	Fig. 1 (4)
5	Insulation Stripping Length	5 - 6mm	--//--

4.2.1 Crimp Data: (Plug)

Contact Part Number	Wire Size mm ² (Nominal)	Applicator Number	Wire Barrel Crimp			Insulation Barrel Crimp		Crimp Tensile Strength (kg)(min.)
			Width (mm)	Height Note 1. Fig.15	Disc Pad. Ltr.	Width (mm)	Finished Insulation Diameter (mm)	
170002-X	0.5	See Note3	2.79 "F"	1.50	D	4.57 "F"	For "F" type: 2.54~3.68mm For "OV" type: 1.60~2.70mm Note4	8.0 min.
	0.75			1.63	C			15.0 min.
	1.25			1.73	B			20.0 min.
	2.0			1.88	A			25.0 min.

4.2.2 Crimp Data: (Receptacle)

Contact Part Number	Wire Size mm ² (Nominal)	Applicator Number	Wire Barrel Crimp			Insulation Barrel Crimp		Crimp Tensile Strength (kg)(min.)
			Width (mm)	Height Note 1. Fig.15	Disc Pad. Ltr.	Width (mm)	Finished Insulation Diameter (mm)	
170003-4	0.5	686270-2	2.79 "F"	1.37	D	4.57 "F"	2.54mm / 3.68mm	8.0 min.
	0.75			1.42	C			15.0 min.
	1.25			1.55	B			20.0 min.
				1.73	A			25.0 min.

Notes: (1) General tolerance of wire barrel crimp height to be within plus/minus (±) 0.05mm.
(2) Unless otherwise noted, all the dimensions are in millimeters.

(3)Applicator2150012:170002-3/170002-4/170002-/170002-8/170002-9/3-170002-3/3-170002-4.
Applicator4150018:170002-2/170002-7/3-170002-1/3-170002-2/6-170002-2.
(4)Applicator 2150012 and 4150018 have "F" and "OV" type.

SHEET	AMP AMP (Japan), Ltd. Kawasaki, Japan			REV. P
3 OF 3	LOC	LOC	NO.	
NAME Crimping of SHUR PLUG* Contacts				