The performance of applicable product is guaranteed only when processed by proper application tooling and condition described in this specification and/or AMP recognized ones. No product is guaranteed when processed with the other tool or condition.

1. Scope

This specification covers the requirements for crimping of the Sealed type .060 Receptacle Contact.

2. Applicable Contacts

Contact Features	Part Numbers	Finish	Applicable Wires
Strip	900293	Pre-Tin	AVSS/CAVS 0.3~0.85 AVSSX/AESSX 0.5f CAN120-LAB 0.3SQx2C
	1717173		CHFUS 0.35

3. Nomenclature

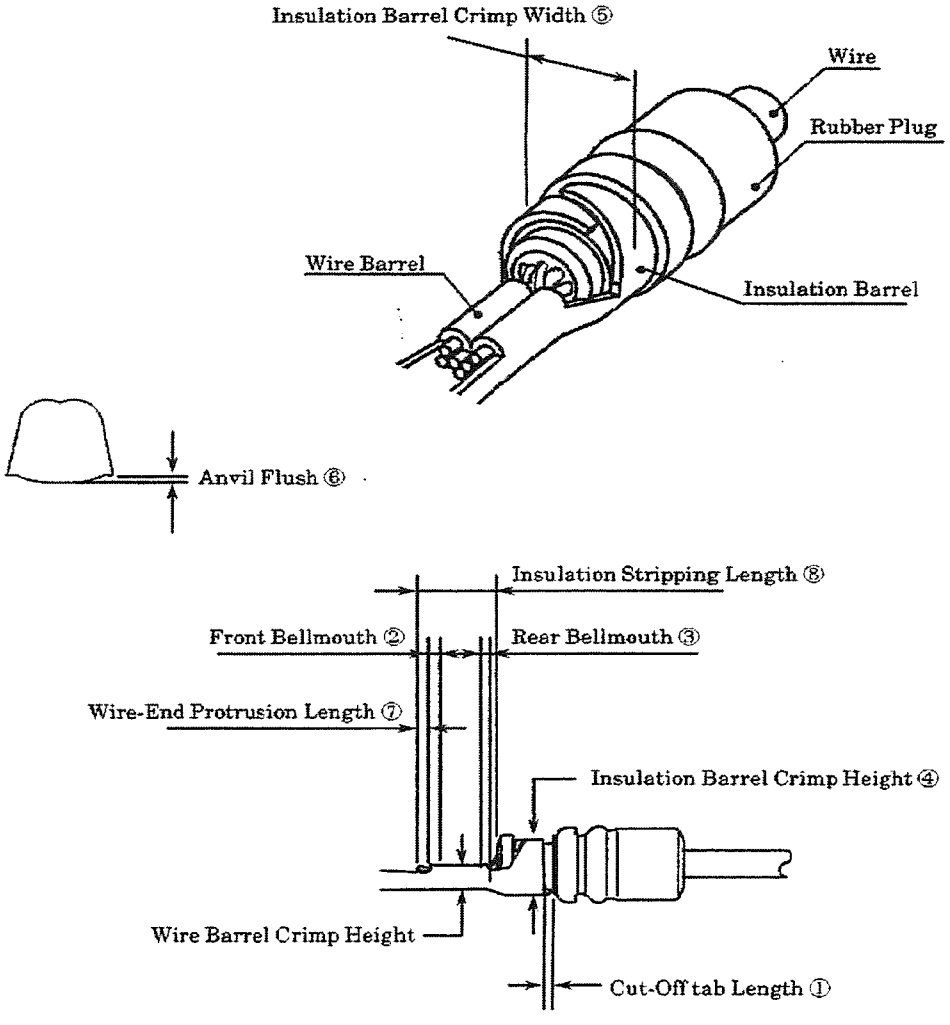


Fig.1

4. Crimping Conditions

No.	Checking Items \ Part Numbers		900293	1717173	Remarks
1.	Allowable Deviation after Crimping	Bend up	4° Max.		Fig.2-①
		Bend down	4° Max.		Fig.2-②
		Twisting	±4° Max.		Fig.2-③
		Rolling	±10° Max.		Fig.2-④
2.	Cut-off Tab Length		0.5 mm Max.		Fig.1-①
3.	Bellmouth	Front	0.2 mm Max.	(1)	Fig.1-②
		Rear	0.5 mm Max.	0.5mm Max.	Fig.1-③
4.	Insulation Barrel Crimp	Height	3.2 ± 0.1 mm		Fig.1-④
		Width(REF)	3.2 mm		Fig.1-⑤
5.	Anvil Flush		0 mm Min.		Fig.1-⑥
6.	Wire-End Protrusion Length		Wire-end must protrude beyond the front edge of wire barrel, but shall not exceed 1mm.		Fig.1-⑦
7.	Insulation Stripping Length		$4.25^{\pm 0.25}$ mm	$3.55^{\pm 0.25}$ mm	Fig.1-⑧

NOTE (1) The bell mouse can check by viewing.

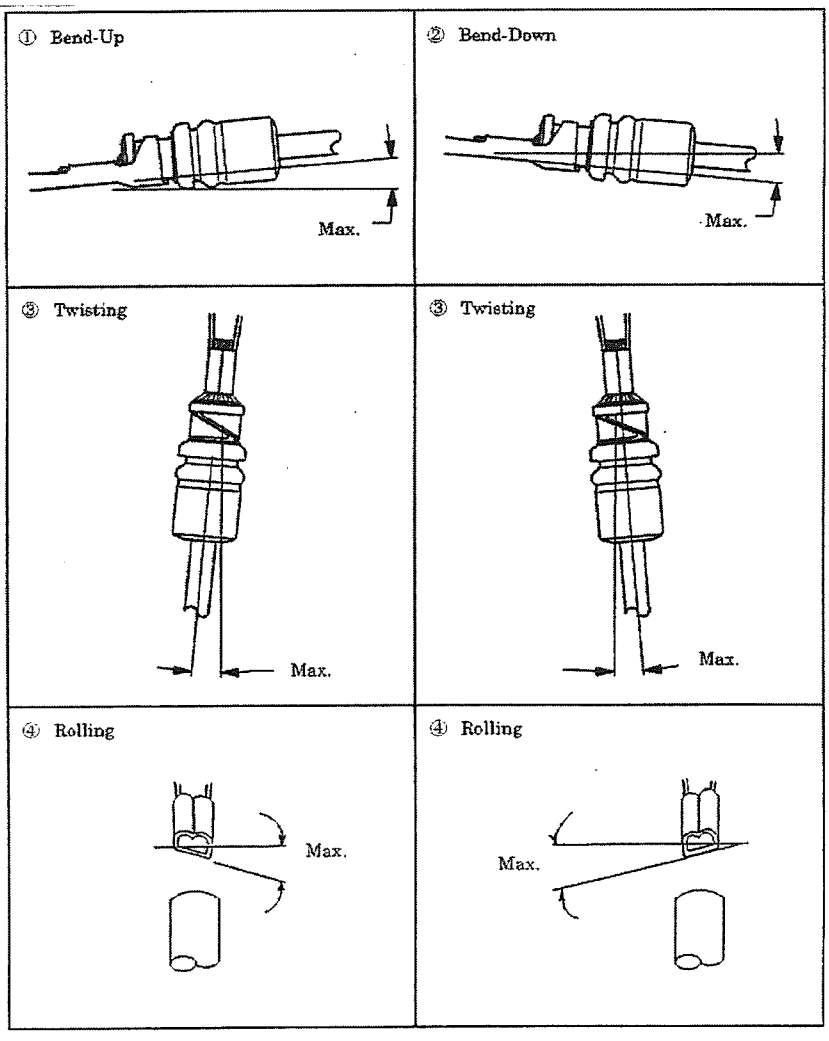


Fig.2

5. Crimp Data

Contact Part Number (Strip Form)	Applicator Part Number	Wire Size		Wire Barrel Crimp(mm)			Insulation Barrel Crimp (mm)		Crimp Tensile Strength (N)	Rubber Plug Parts Number
		No of Wires	mm² (AWG)	Width(2)	Height (1)	Disk Ltr.	Width(2)	Finished Insulation Diameter (mm)		
900293	234749-2	7	0.3(22)	1.78	0.94	C	3.3	1.4	59 Min. (3)	316867-1
		7	0.5(20)		1.03	B		1.6	89 Min.	
		19	0.5f(20)		1.03	B		1.6	89 Min.	
		7	0.3(22) (4)		0.94	C		2.0	59 Min. (3)	967067-1
		19	0.85(18)		1.17	A		1.8	128 Min.	
1717173	1596953-2	7	0.35(-) (5)	1.4	0.92	B		1.1	50 Min. (3)	967067-2

NOTE (1)Wire Barrel Crimp Height to be within ±0.05

(2)Crimp Width dimensions are not the product width after crimping , but given by the width of crimper slot for reference

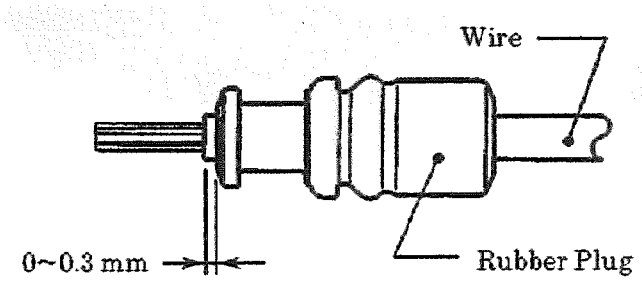
(3) Crimp Tensile Strength of 0.3 and 0.35 wire includes the wire grip of insulation barrel crimp.

(4)120Ω CAN wire ; CAN120-LAB 0.3SQx2C

(5)ISO wire ; CHFUS 0.35

6. Rubber Plug Installation

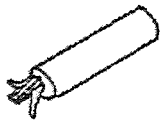
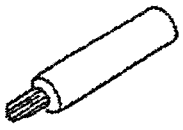
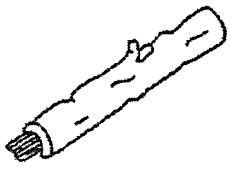
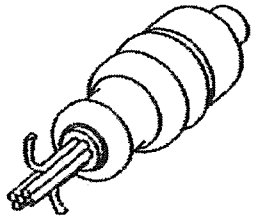
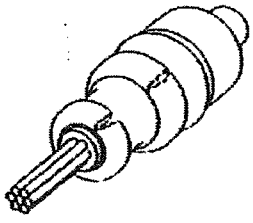
The length of the wire insulation protruding beyond the end of the rubber plug, assembled to the wire, shell be within 0~ 0.3mm.(Refer to the following illustration)



7. Notes

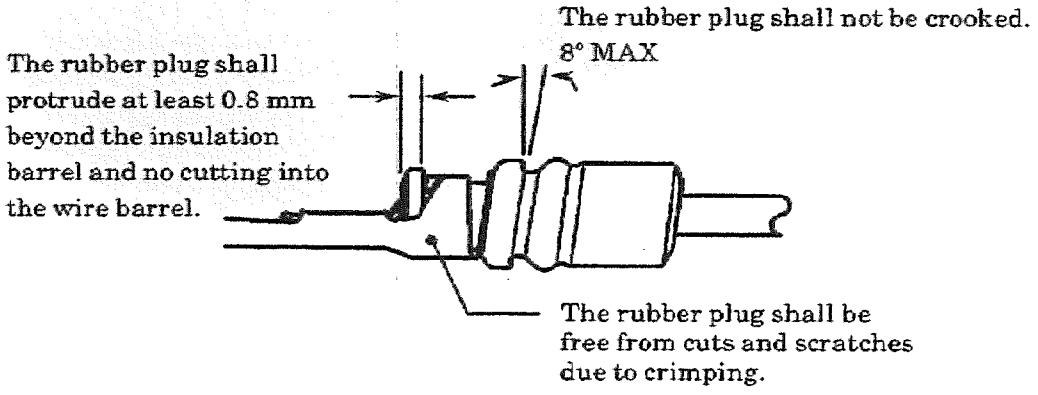
Wire and rubber plugs as illustrated below shall be reworked or replaced because they are detrimental to the required performance.

[Before Crimping]

 The strands shall not be frayed.	 The strands shall be free from nick and breakage.	 The insulation shall be round without scratches and dents.
 The strand shall not be frayed.	 The rubber plug shall be tree from scratches.	 The rubber plug shall not be crooked.

[After Crimping]

The wire barrel shall not cut into the rubber plug and the insulation.



8. Applicable Wire Data

Nominal Size	Number of Strands/Diameter of strand (mm)	Calculated Cross Section Area (mm^2)	Finished Insulation Diameter (mm)		Remarks
			Standard	Max	
0.3	7/0.26	0.37	1.4	1.5	AVSS/CAVS
0.3	7/0.25	0.34	2.0	2.2	CAN120-LAB 0.3SQx2C
0.35	7/Circular Compressed	0.34	1.1	1.2	CFHUS
0.5	7/0.32	0.56	1.6	1.7	AVSS/CAVS
0.5f	19/0.16	0.54	1.6	1.7	AVSSX/AESSX
0.85	19/0.24	0.86	1.8	1.9	AVSS/CAVS