



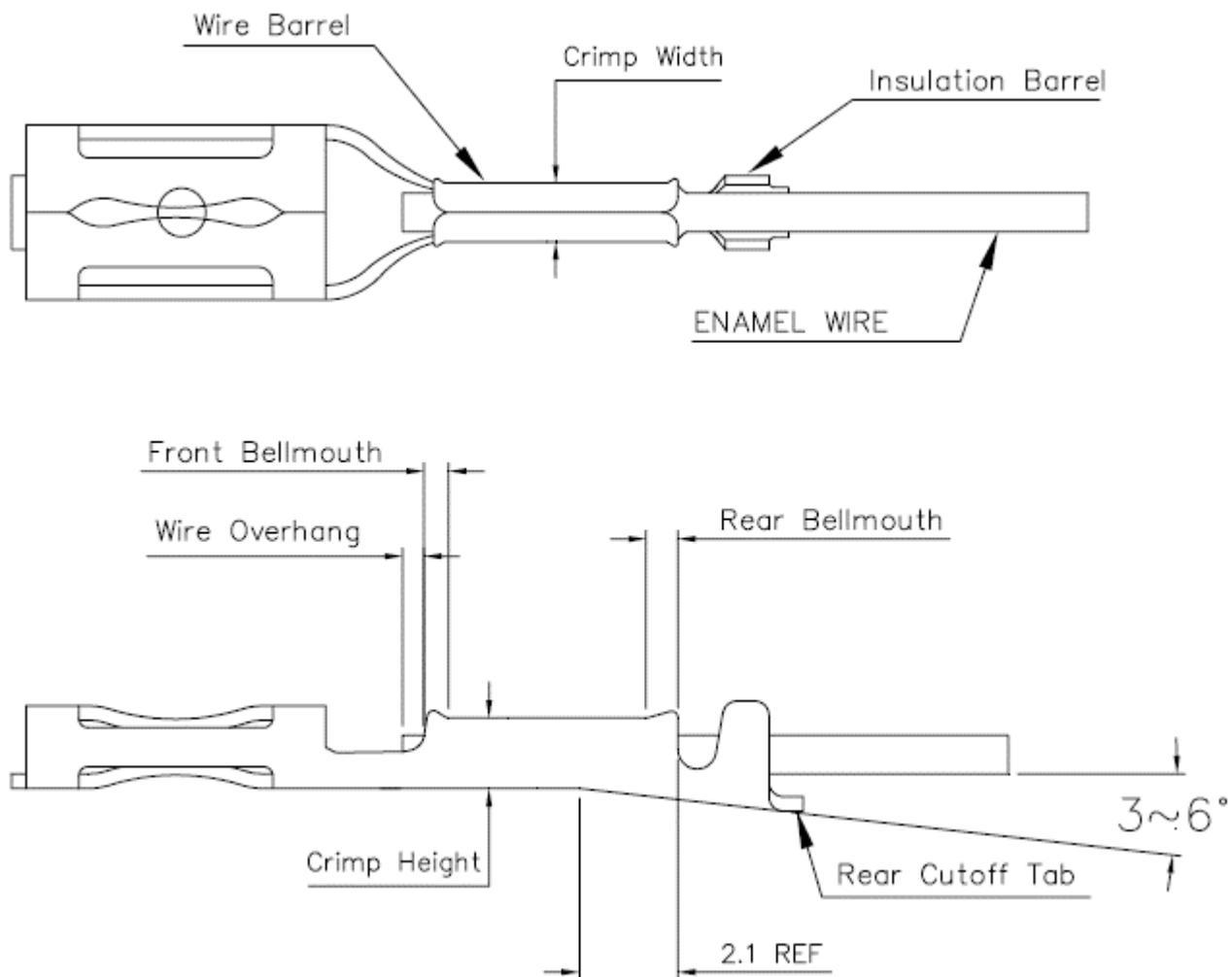
**NOTE**

All numerical values are in metric units [with U.S. customary units in brackets]. Dimensions are in millimeters [and inches]. Unless otherwise specified, dimensions have a tolerance of  $\pm 0.13$  [ $\pm .005$ ] and angles have a tolerance of  $\pm 2^\circ$ . Figures and illustrations are for identification only and are not drawn to scale.

**1. INTRODUCTION**

This specification covers the requirements for application of AMPLIVAR\* FASTON\* Receptacle Terminals 1494212-1, 1494212-2, 1930002-1, 1930003-1, and 1930003-2. For specific wire and insulation ranges relative to the products covered in this specification, please refer to the appropriate TE Connectivity Customer Drawings.

Basic terms and features of this product are provided in Figure 1.



**Figure 1 (continued)**

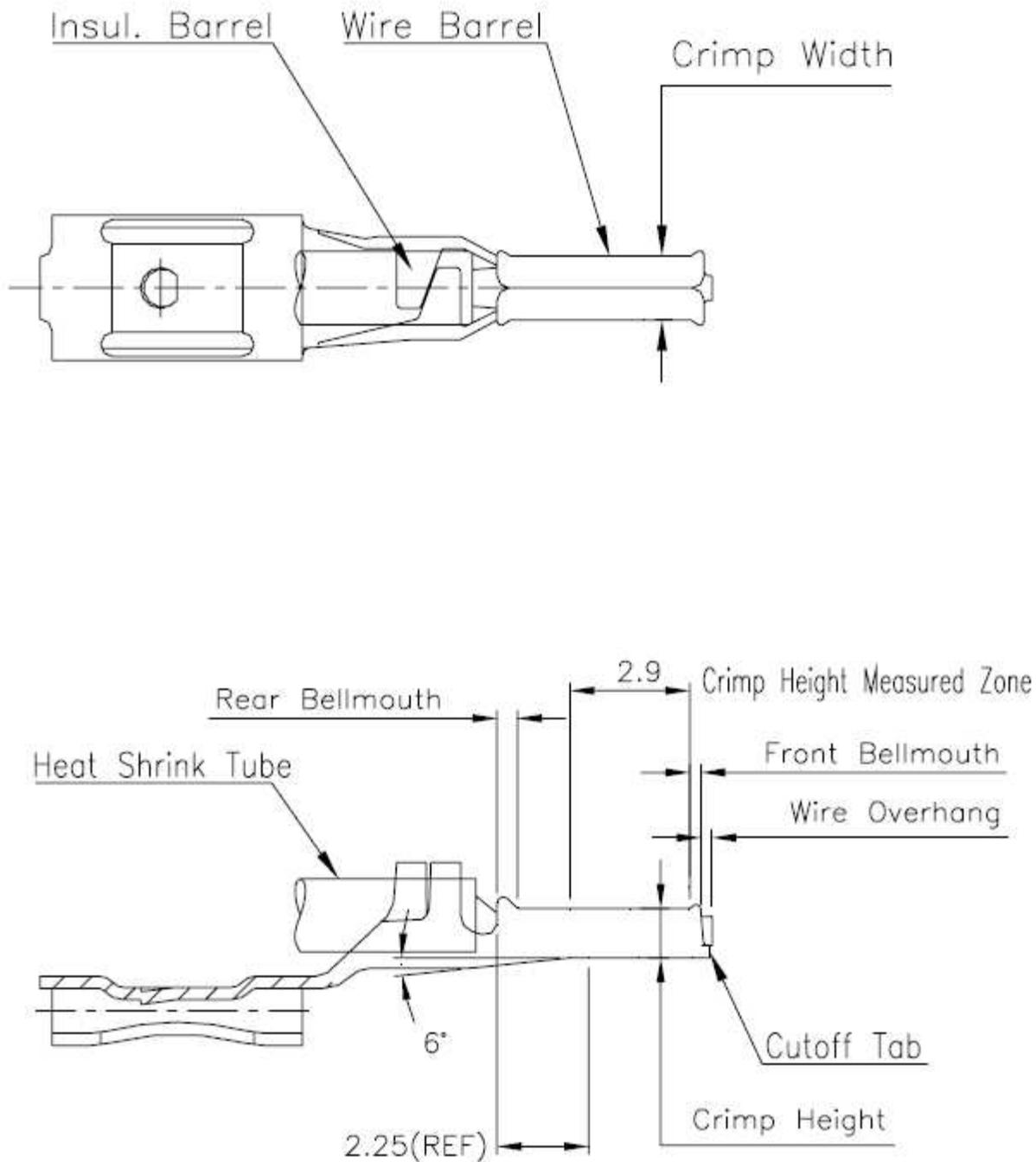


Figure 1 (end)

## 2. REFERENCE MATERIAL

### 2.1. Revision Summary

This paragraph is reserved for a revision summary covering the most recent additions and changes made to this specification which include the following:

- Updated application specification format to corporate requirements.
- Front and rear bellmouth length specifications updated.

## 2.2. Customer Assistance

Reference Product Base Part Number 1494212, 1930002, 1930003 and Product Code 1045 are representative of AMPLIVAR\* FASTON\* Receptacle Terminals. Use of these numbers will identify the product line and help you to obtain product and tooling information when visiting [www.te.com](http://www.te.com) or calling the number at the bottom of page 1.

## 2.3. Drawings

Customer drawings for product part numbers are available from [www.te.com](http://www.te.com). Information contained in the customer drawing takes priority.

## 2.4. Specifications

Product Specification 108-58502 provides product performance and test results.

## 3. REQUIREMENTS

### 3.1. Wire Selection and Preparation



The applicable wires for this product are enamel wires. The acceptable wire sizes are listed in Figure 2.  
**CAUTION**

*Care must be taken not to nick, scrape, or cut any part of the wire during the stripping operation. Filaments of insulation material remaining after stripping should be avoided and shall never extend among the bare conductor.*

### 3.2. Contact Crimp

#### A. Cutoff Tab

The cutoff tab is the remaining portion of the carrier strip after the contact is cut from the strip. The cutoff tab shall not exceed 0.50 mm.

#### B. Wire Barrel Crimp

The crimp height and width shall be as shown in Figure 2 for machine applications.

Part Number	Wire Size (mm)	Crimp Height (mm) $\pm 0.05$	Nominal Crimp Width (mm) $\pm 0.10$
1494212-1 1494212-2	0.45	0.82	1.575
	0.57	0.86	
	0.68	0.91	
	0.75	0.95	
1930002-1	0.68	0.99	1.778
	0.76	1.03	
	0.85	1.08	
	0.95	1.14	
	1.09	1.23	
1930003-1 1930003-2	0.64	0.97	1.575
	0.76	1.03	
	0.85	1.09	
	0.93	1.16	



**NOTE**

*The diameter values are including coated film thickness.*

**Figure 2**

The crimp height must be measured in the area as indicated in Figure 3.

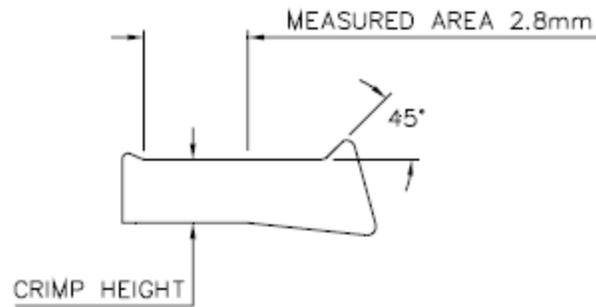


Figure 3

### C. Wire Barrel Flash

Wire barrel flash is the formation that may appear on both sides of the wire barrel as the result of the crimping process. The wire barrel flash shall not exceed 0.15 mm.

### D. Wire Barrel Seam

The 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. Bellmouths

1. The rear bellmouth length shall be 0.20 to 0.60 mm.
2. The front bellmouth length shall not exceed 0.70 mm.

### F. Wire End Extrusion

The wire conductor end must be flush with the front end of the wire barrel or extend 1.2 mm maximum after crimping.

### G. Conductor Location

Both the insulation and conductor shall be visible between the insulation barrel and wire barrel. Care shall be taken not to allow insulation to be crimped in the wire barrel.

### H. Bend Allowance

The bend allowance between the wire barrel and cable is acceptable within the limits given in Figure 4. The contact, including the cutoff tab and burr, shall not be bent above or below the datum line shown in the up and down bend allowance.

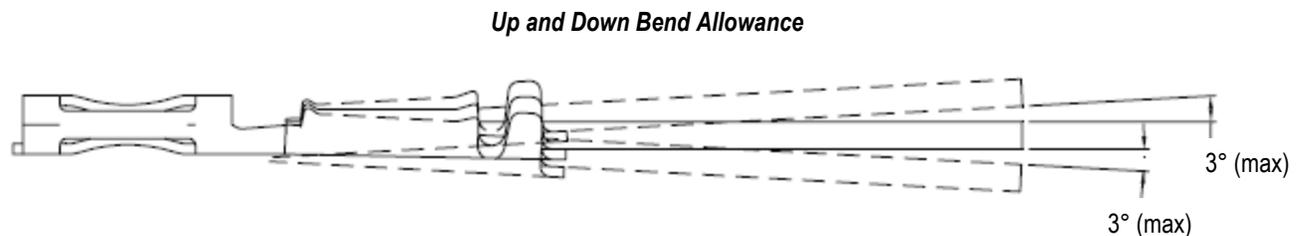
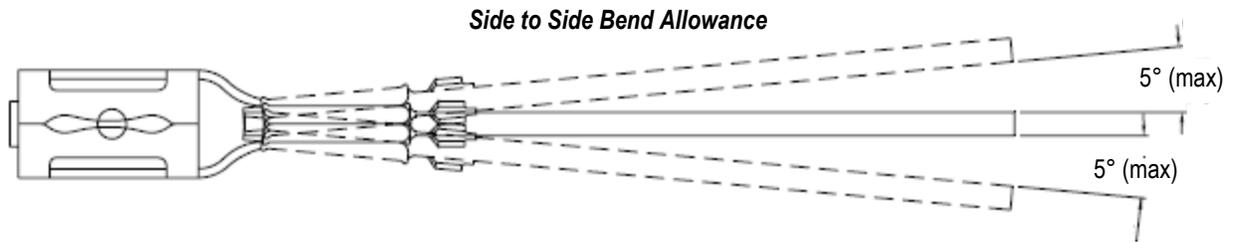


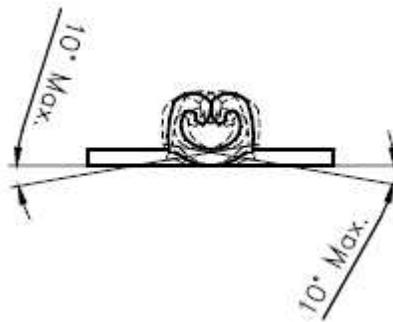
Figure 4 (continued)



**Figure 4 (end)**

**I. Twist and Roll**

Twist or roll of the crimped contact shall not exceed the limits specified in Figure 5.



**Figure 5**