

DESIGN OBJECTIVES

This product described in this document has not been fully tested to insure conformance to the requirements outlined below. Therefore, AMP do Brasil makes no representation or warranty, express or implied, that the product will comply with these requirements. Further, AMP do Brasil may change these requirements based on the results of additional testing and evaluation. Contact AMP Engineering for further details.

1. SCOPE

1.1. CONTENT

This specification covers the performance, tests and quality requirements for the Mini AMP-IN Short Terminal (PN 444082). These contacts are designed to facilitate lead preparation for printed circuit boards to wave soldering. Through their use, support is gained in the wire insulation area insuring a reliable solder connection with resistance to wire flexing and vibration.

1.2. QUALIFICATION

When tests are performed on the subject product line, the procedures specified in AMP 109 series specifications shall be used. All inspections shall be performed using the applicable inspection plan and product drawing.

2. APPLICABLE DOCUMENTS

The following documents form a part of this specification to the extent specified herein. In the event of conflict between the requirements of this specification and the product drawing, the product drawing shall take precedence. In the event of conflict between the requirements of this specification and the referenced documents, this specification shall take precedence.

2.1. AMP DOCUMENTS

- A. 109-1 Rev C: General Requirements for Test Specifications
- B. 109 Series : Test Specifications as indicated in
Figure 1. (Comply with MIL-STD-202 Rev of 1 Apr 80, MIL-STD-1344 Rev of 31 Oct 73 and EIA RS-364 Rev of 17 Aug 71).
- C. 114-37004 Rev 0 : Mini AMP-IN Short, Terminal, Application of -

AMP SECURITY CLASSIFICATION:

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			APP	E.A. Sfeir	<i>[Signature]</i>	LOC	NO	REV	
						AP	08-37010		0
						TITLE			
						MINI AMP-IN SHORT TERMINAL			
						SHEET			
						01 OF 05			
						20Aug93			
						ISSUED			
						LTR			
						REVISION RECORD			
						APP			
						DATE			

3. REQUIREMENTS

3.1. DESIGN AND CONSTRUCTION

Product shall be of the design, construction and physical dimensions specified on the applicable product drawing.

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3.2. MATERIALS

A. Contact: Brass, tin/lead plated

3.3. PERFORMANCE AND TEST DESCRIPTION

The product is designed to meet mechanical performance requirements specified in Figure 1.

3.4. TEST REQUIREMENTS AND PROCEDURES SUMMARY

TEST DESCRIPTION	REQUIREMENT	PROCEDURE
Examination of Product	Meets requirements of product drawing and AMP Spec 114-37004 Rev 0	Visual, dimensional and functional per applicable inspection
MECHANICAL		
Contact Insertion Force	Maximum force per contact: AWG 26: 10 N AWG 24: 15 N AWG 22: 20 N	Measure force to insert contact into gage with size hole described in figure 3; AMP Spec 109-41 Rev A
Contact Extraction Force	4 N minimum	Apply axial load to extract the contact assembled into gage with size hole described in figure 3; AMP Spec 109-30 Rev C
Solderability	Applicable portion of contact shall have coverage of 95% min.	Subject contacts to solderability; AMP Spec 109-11-5 Rev F
Crimp Tensile	15 N minimum	Determine tensile of wire crimped by insulation support at a rate of 25mm/min. using support described in Figure 4; AMP Spec 109-16 Rev A

FIGURE 1.

3.5 CONTACT TEST AND SEQUENCE

Test or Examination	Test Group (a)			
	1	2	3	4
	Test Sequence (b)			
Examination of Product	1			
Contact Insertion Force		1		
Contact Extraction Force		2		
Solderability			1	
Crimp Tensile				1

(a) See 4.1.A

(b) Numbers indicated sequence in which tests are performed

Figure 2

4. QUALITY ASSURANCE PROVISIONS

4.1. QUALIFICATION TESTING

A. Sample Selection

Contacts shall be prepared in accordance with applicable instructions sheets.

They shall be selected at random from current production. Tests groups 2 through 4 shall consist of 50 contacts of each type being qualified. They shall be selected from lots which have met the requirements of group 1. All contacts shall be crimped in accordance with AMP Specification 114-37004 Rev 0.

B. Test Sequence

Qualification inspection shall be verified by testing samples as specified in Figure 2.

C. Acceptance

(1) Requirements put on test samples, as indicated in the requirements portion of Figure 1, exist as either the upper or lower statistical tolerance limit.

All samples tested in accordance with this specification shall meet the stated tolerance limit.

(2) Failures attributed to equipment, test setup, or operator deficiencies shall not disqualify the product. When product failure occurs, corrective action shall be taken and samples resubmitted for qualification.

4.2. QUALITY CONFORMANCE INSPECTION

The applicable AMP Quality Inspection Plans will specify the sampling acceptable quality level to be used.

Dimensional and functional requirements shall be in accordance with the applicable product drawing and this specification.

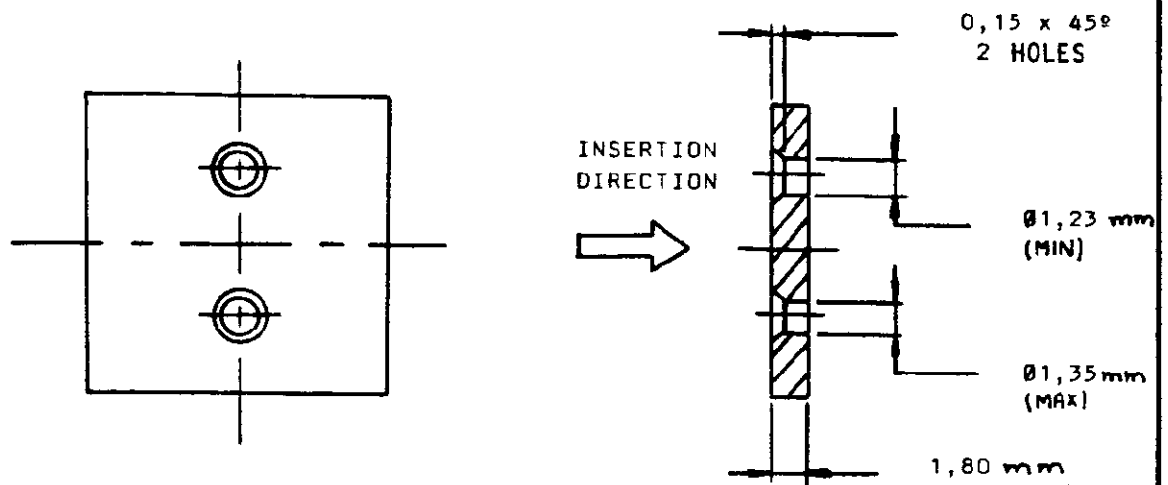
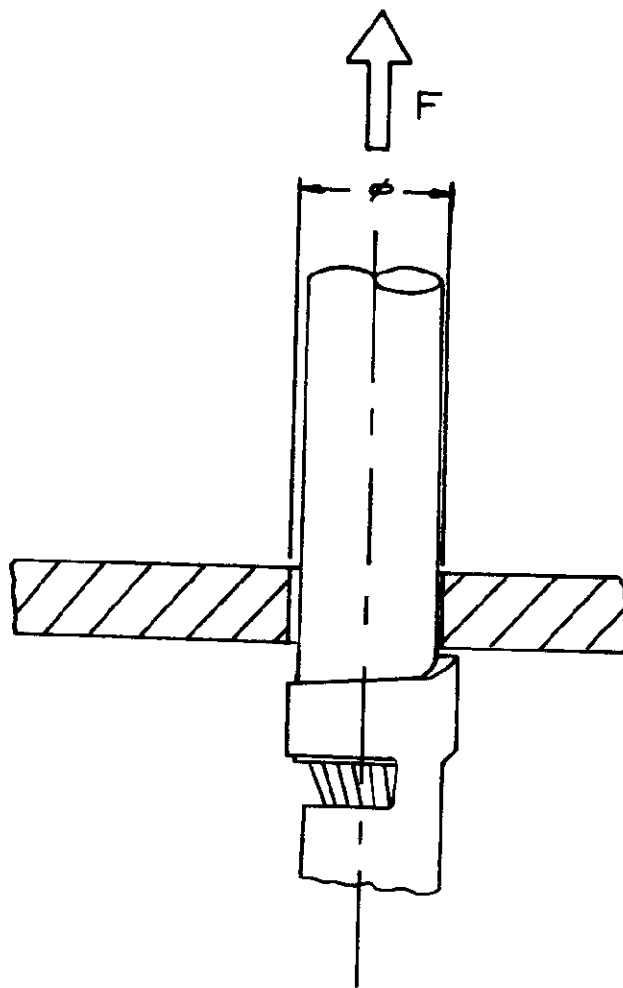


FIGURE 3 - GAGE INFORMATION



WIRE SIZE AWG	ϕ mm $\pm 0,05$
26	1,08
24	1,33
22	1,68

FIGURE 4 - CRIMP TENSILE SUPPORT