

APPLICATION SPECIFICATION

1. SCOPE

This specification covers the requirements for application of AMPLIMITE* series 109 pin and socket contacts. These requirements are applicable for the ASTRO hand tool only. For specific wire and insulation ranges relative to the products covered in this specification see Figure 2.

2. NOMENCLATURE

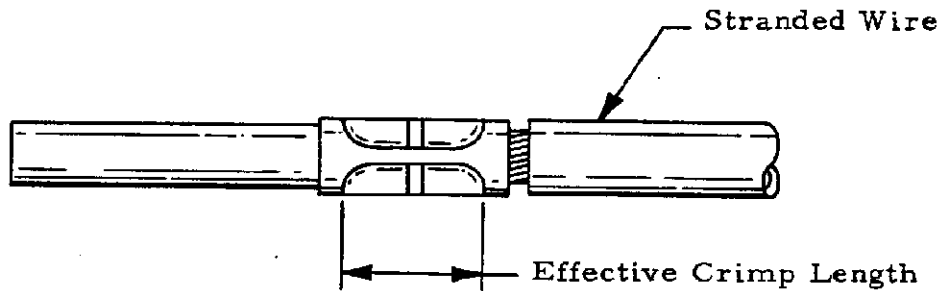


Figure 1

3. CRIMP AND DIMENSIONAL REQUIREMENTS

3.1. Wire Preparation

A. Strip Length

Insulation shall be stripped as indicated in Figure 2.

B. Workmanship

Reasonable care shall be taken not to nick, scrape or cut any strands during the stripping operation.

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							1 OF 2	CONTACT, AMPLIMITE, 109 PIN AND SOCKET, USING ASTRO HAND TOOL					

3.2. Wire Barrel Crimp

A. Crimp Dimensions and Type

Crimp type shall be as shown in Figure 2.

B. Effective Crimp Length

Effective crimp length shall be .055 nominal, and is defined as that portion of the barrel, excluding bellmouth, fully formed by the crimping tool.

3.3. Alignment

A. Straightness

The axial concentricity of crimped contacts shall not exceed .012 inch total indicator reading (TIR) for size 20 contacts.

B. Twist or Roll

There shall be no twist or roll in crimped portion that will impair usage of the contact.

Part No	Wire		Tensile Strength Pounds (min)	Strip Length	Wire Barrel Crimp
	Qty	Size			Type Crimper (a)
205089	1	20	19	9/64	4/8 Indent
205090		22	12		
		24	8		

(a) Crimp tool shall be a certified ASTRO 300 D 4/8 indent hand tool.

Figure 2

Hand Tool Wire Crimp Dimensions

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