APPLICATION SPECIFICATION

1. SCOPE

1.1. Content

This specification covers the requirements for application of dual lance MATE-N-LOK* pin and socket contacts. These requirements are applicable to hand or automatic machine crimping tools. For specific wire and insulation ranges relative to the products covered in this specification see Figures 4 and 5.

1.2. Reference Specification

For applicable performance requirements see AMP Specification 108-1030.

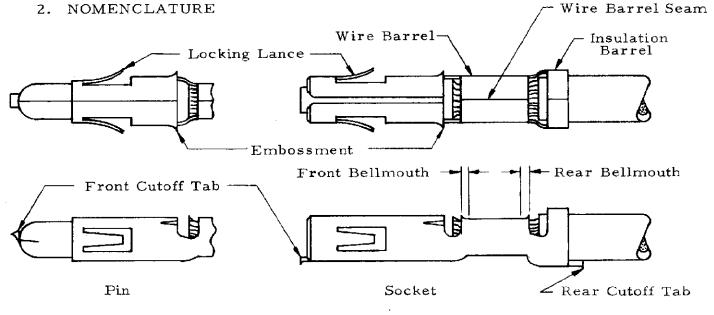


Figure 1

3. CRIMP AND DIMENSIONAL REQUIREMENTS

3.1. Wire Preparation

A. Strip Length

Insulation shall be stripped as indicated in Figures 4 and 5.

B. Workmanship

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

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	A	Rev Fig 4 & 5	EL.	4-27	SHEET	NAME CONTA	CT,	PII	N AND SOCKET,			
กเรา 01		Strip Length			1 OF <u>4</u>	MATE-N-LOK, DUAL LANCE,						
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3.2. Carrier Cutoff Tab

A. Cutoff Tab

- (1) Front cutoff tab shall not exceed . 008 and shall be wiped upward toward the centerline on pin contacts.
- (2) Rear cutoff tab shall not exceed .015.

3.3. Wire Barrel Crimp

A. Crimp Dimensions and Type

Crimp height, width and type shall be as shown in Figures 4 and 5.

B. Tensile Strength

Crimp tensile strength shall be as shown in Figure 4.

C. Wire Barrel Seam

The wire barrel seam shall be closed adequately to confine all strands of the wire. There shall be no loose wire strands or wire strands embedded in the outside of the wire barrel.

D. Bellmouth

- (1) Rear bellmouth length shall be . 005-. 030.
- (2) Front bellmouth length shall be .010 maximum.

E. Conductor Location

- (1) End of the wire shall be flush with the front end of the wire barrel or extend .047 maximum after crimping.
- (2) Both 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.

3.4. Insulation Barrel Crimp

A. Crimp Dimensions and Type

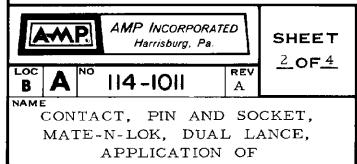
Crimp width and type shall be as shown in Figures 4 and 5.

B. Workmanship

Reasonable care shall be taken not to cut or break the insulation during the crimping operation.

3.5. Locking Lance

Locking lance shall not be deformed.



3.6. Embossments

Embossments on pin contacts shall pass through a .117 maximum diameter circle and a .145 maximum diameter circle for socket contacts.

3.7. Alignment

A. Axial Concentricity

(1) Crimped insulation barrel of single conductor crimped contacts shall fall into an area defined by a .160 diameter circle whose center is the centerline of the contact as shown in Figure 2.

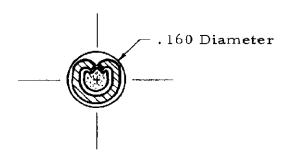


Figure 2

(2) Crimped insulation barrel of 2 conductor crimped contacts shall fall into an area defined by a .210 by .155 rectangle whose vertical center is the centerline of the contact and whose horizontal center is .030 above the centerline of the contact as shown in Figure 3.

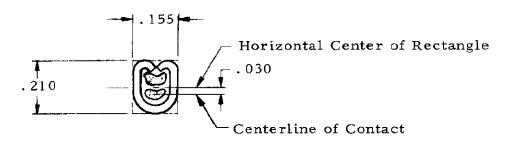
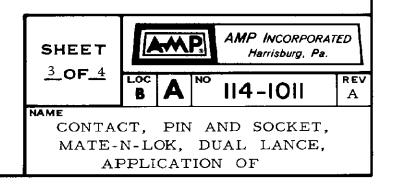


Figure 3

B. Twist or Roll

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



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Part N	Part Numbers	A	Wires	In and a bina			Wire B	Wire Barrel Crimp	lmp	Insulation B	Insulation Barrel Crimp
Pin	Socket		No Size	Diameter, maximum	Strip Length	Width	Height ±.002	Width Height Type	Tensile Strength, Ib min	Width	Type Crimper
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			24				. 038		14		
250561	072026	-	22	00	187	t	. 040	£	20		ŗ
106066	000000	1	20	661.	156	0.00.	. 043	ч	25	. 100	ㅂ
		1	18				. 048		30		

Automatic Machine Wire Crimp Dimensions Figure 4

	Hand Tool	Part No		90297-1			90300-1						
	arrel Crimp	Type Crimper		ŗ	ч			Ή			Ļ	-	
	Insulation Barrel Crimp	Width		000	001.			. 130		. 100			
	Wire Barrel Crimp	Width 4.002 Crimper		Ę	ч	:		Ţ	-		[ч	
	Barrel	Height ±.002	.050	. 050	£90°	.063	.073	,,,,	000.	.040	.040	. 046	046
	Wire	Width		0	060 .			060.			000	060.	
	Strin	Length		187	.156	:	187	156	•		. 187	.156	
	Insulation	Diameter, maximum		0 5 -	001.		311 (6)	C11 · (2)	Stacked		001	001.	
	Wires	No Size	1 20	1 18	1 16	1 14	2 18	1 18	1 16	1 24	1 22	1 20	1 18
	nbers	Socket P	350546				350548			350691			
	Part Numbers	Pin		7 7 7	1 #cncc			350549			350500	060000	
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Hand Tool Wire Crimp Dimensions Figure 5

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