

APPLICATION SPECIFICATION

MINI MIC REC. CONTACT FOR SINGLE WIRE SEALING

WITH 5.6 mm OUT. DIA.

SCOPE

This specification covers the requirements for application of MINI MIC REC. CONTACTS.

P.N.s involved are listed in the table of Fig. 7.

GENERAL

These contacts are suitable for 0,35 -1,5 mm<sup>2</sup> wire, with single wire seals.

Each wire is inserted into a discrete wire seal before to be crimped into the contact.

The insulation barrel is crimped so that the wire seal is gripped in order to avoid any movement of the seal.

The contacts are suitable for single wire only.

The indications on the figures are valid for receptacle contacts.


1. CRIMPING

The following information contains nomenclature, crimping conditions, crimp data for mini-applicators, insertion of wire seals on cables, mending or replacement of parts and checks.

IPL 444 P.C. 0933

THIS INFORMATION IS CONFIDENTIAL AND IS DISCLOSED TO YOU ON CONDITION THAT NO FURTHER DISCLOSURE IS MADE BY YOU TO OTHER THAN AMP PERSONNEL WITHOUT WRITTEN AUTHORIZATION FROM AMP ITALIA S.p.A.

TEC 034 2.83

		DR S. SERRA 18-5-93		 <b>AMP ITALIA S.p.A.</b> Corso F.lli Cervi, 15 COLLEGNO (TORINO)		
		DALLA RIVA 18-5-93				
		CHK		LOC.	NO	REV.
C1		REVISED EC ETD0-0116-99	M.P.	I	114-20062	C1
C		REVISED EC ETD0-0408-97		APP.		
B		REVISED EC ETD0-0154-97	P.S. 3/4/93			
A		RELEASED PER ECN ETD0039/93	24-1-94	SHEET		
0		FIRST ISSUE	18-5-93	NAME		
REV LTR		REVISION RECORD	DR DATE	1 OF 6		
				APPLICATION SPECIFICATION FOR MINI-MIC CONTACT FOR SINGLE WIRE SEALING WITH 5.6 mm OUT.DIA.		

## 1.1 NOMENCLATURE

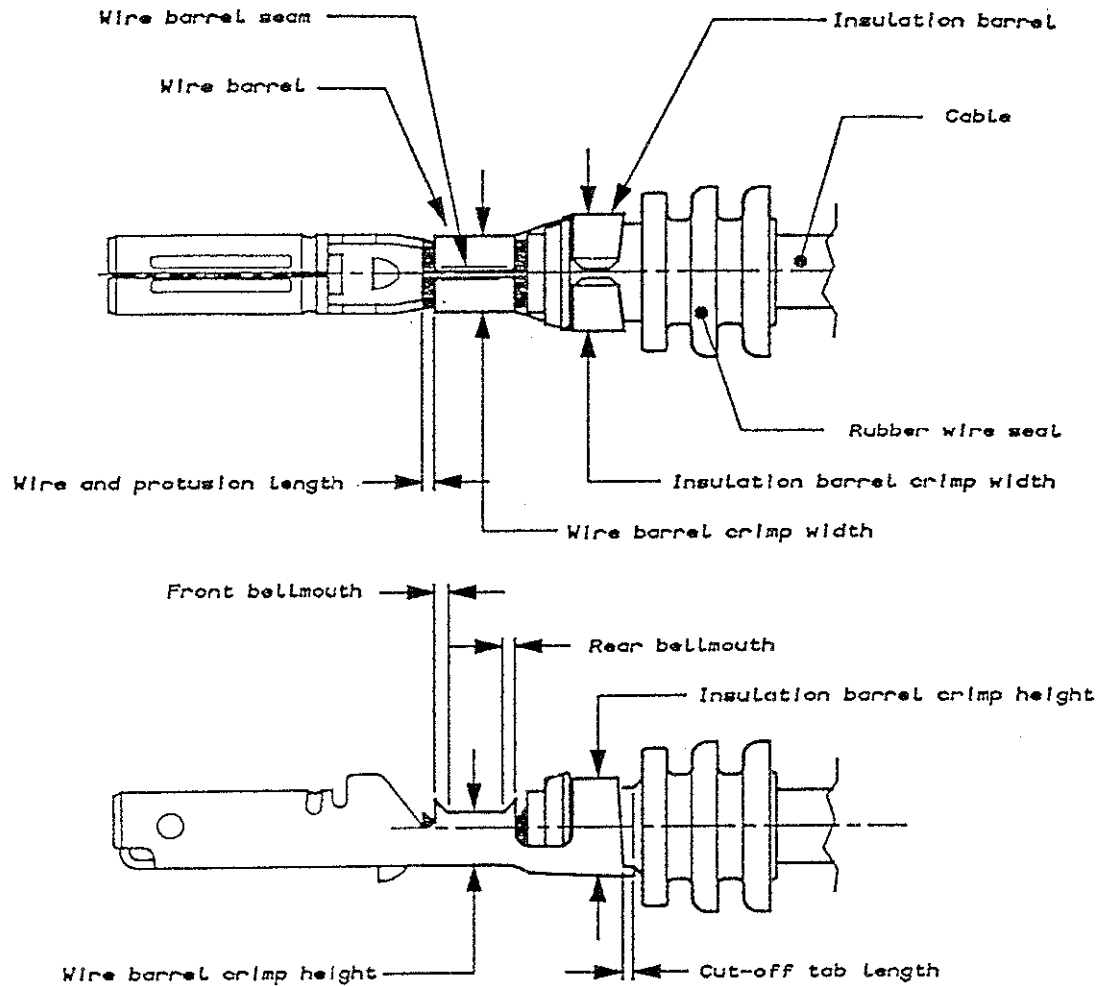


Fig. 1

## 2. CRIMPING CONDITIONS

Refer to nomenclature (Par. 1.1) see Fig. 1  
Fig. 2 and Fig. 3.

- |  |                |
|--|----------------|
| 1. Cut-off tab length                      | 0,3 mm MAX     |
| 2. Front bellmouth                         | 0,10 x 45° MAX |
| Rear bellmouth                             | 0,25 x 60° MIN |
| 3. Bend up                                 | 5° MAX         |
| Bend down                                  | 5° MAX         |
| Bend right                                 | 5° MAX         |
| Bend left                                  | 5° MAX         |
| Rolling                                    | 5° MAX         |
| 4. Cable end protrusion<br>(brush length)  | 0,2 to 0,7 mm  |
| 5. Insulation stripping<br>length          | 3,0 to 3,5 mm  |
| 6. Wire barrel seam must be neatly closed. |                |

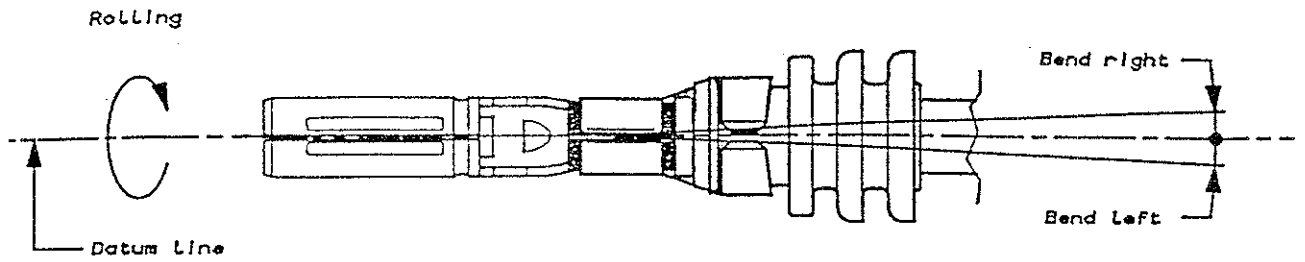


Fig. 2

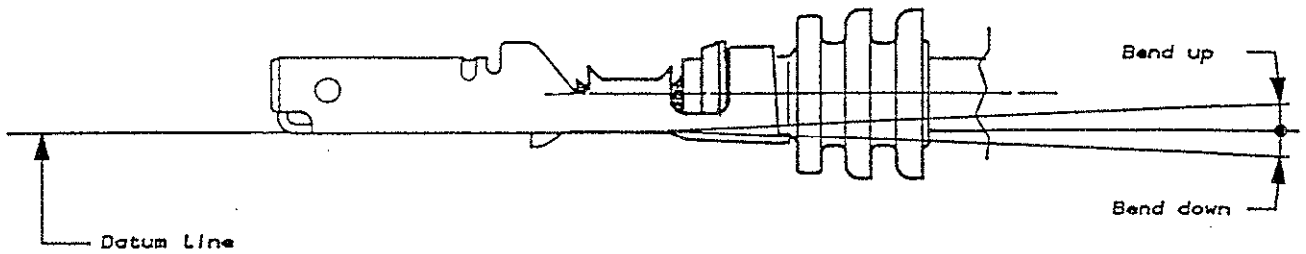


Fig. 3

### 3. CRIMP DATA

3.1 For applicator crimping see Fig. 7.

### 4. INSERTION OF RUBBER WIRE SEAL ON THE CABLE

When the rubber seal is installed on cable, the end of the cable insulation shall be positioned from the edge of the rubber seal, as shown in Fig. 4. This length is usually regardless of cable size.

NOTE: Seals are supplied lubricated. This lubrication must not be removed.

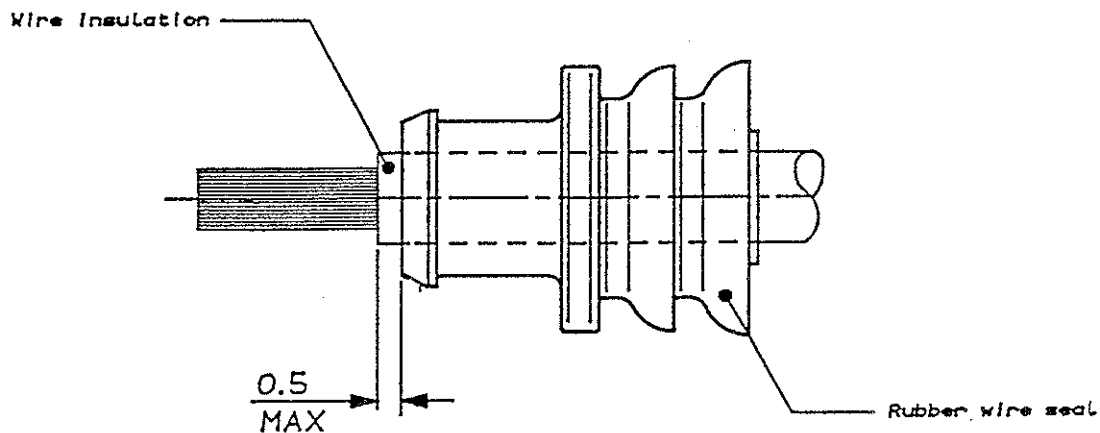


Fig. 4

TEC 035 2.83

**AMP**

AMP ITALIA S.p.A.  
Corso F.lli Cervi, 15  
COLLEGNO (TORINO)

LOC.

I

SHEET

3 OF 6

NO

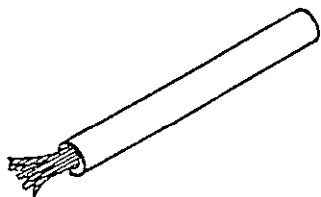
114-20062

REV.

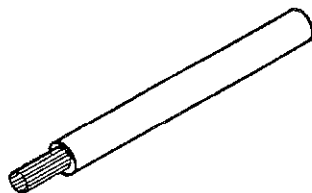
C1

5. CORRECTION OR REPLACEMENT OF PARTS

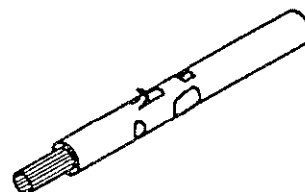
When defects and/or improper applications are found on parts to be installed, as shown in Fig. 5, rework to set up properly, or replace with new part.



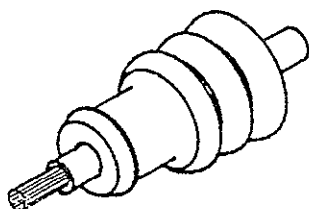
The end of the cut wire shall appear neat without any bend of stranded conductor



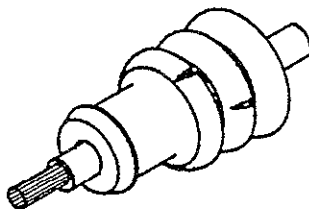
The conductor shall be free from nick, cut and scrape.



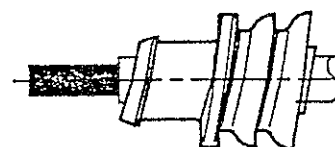
The wire insulation must have smooth surface in a round form without damage, groove or recessed surface.



The end of the wire shall be straight without bend and untidiness after insertion of the wire seal. The bent wire seal be checked out



The flanges of the rubber seal shall be free from cut and damage. Any seal having such defects shall be discarded, and replaced with new part.



Insertion of rubber seal shall be done straightly and evenly. If flanges are in tilt condition, the plug must be corrected so that flanges are perpendicular to contact center line.

Fig. 5

TEC 035 2.83

**AMP**

AMP ITALIA S.p.A.  
Corso F.lli Cervi, 15  
COLLEGNO (TORINO)

LOC  
I

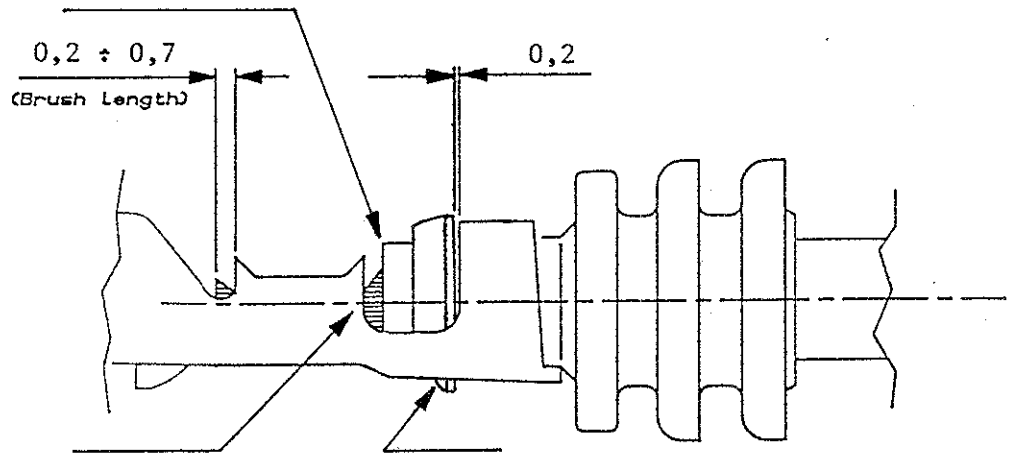
SHEET  
4 OF 6

NO  
114-20062

REV.  
G1

5.1 After crimping, the part of the cable insulation that is inside the seal shall be in good condition and within the requirements shown in Figure 5. Check by visual inspection in the transition area (between wire and insulation barrel), as indicated in Figure 6.

After crimping the rubber seal must protude from the insulation crimp without any damage



After crimping no parts of insulation or rubber in the wire crimp is allowed

Part of rubber seal must stick out from transition hole

Tilt shape of rubber wire is not allowed

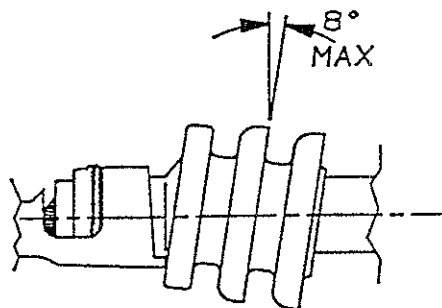


Fig. 6

5.2 Crimped contacts should appear as illustrated in Par. 1.1 (Nomenclature).

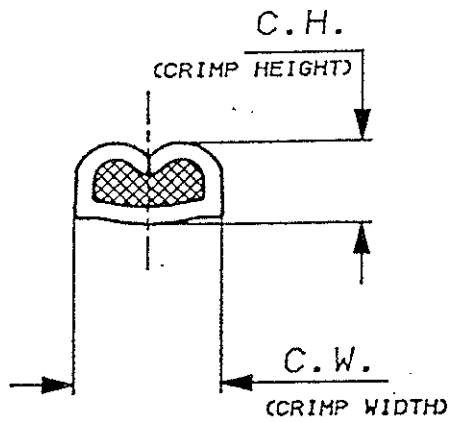


Fig. 7

(Dimensions are in mm)

REC. CONTACT

PART NO.	WIRE SIZE mm <sup>2</sup>	INS. DIA. FOR WIRE SEAL (P.N.)	STRIP LENGTH	WIRE BARREL CRIMP			INS. BARREL CRIMP		
				HEIGHT ± 0,05	WIDTH (REF.)	CRIMPER TYPE	HEIGHT (REF.)	WIDTH (REF.)	CRIMPER TYPE
282110-1	1,5	2,2÷2,4 (828905-1)	3,0÷3,5	1,39	2,28	F	4,00	3,68	0
	1,0	1,9÷2,1 (828904-1)		1,22	2,28	F	3,80	3,68	0
	0,75	1,9÷2,1 (828904-1)		1,14	2,28	F	3,75	3,68	0
282403-1	0,5	1,5÷1,7 (828904-1)	3,0÷3,5	1,09	1,78	F	3,75	3,68	0
	0,35	1,45÷1,55 (828904-1)		1,02	1,78	F	3,70	3,68	0

TEC 035 2.83

**AMP**

AMP ITALIA S.p.A.  
Corso F.lli Cervi, 15  
COLLEGNO (TORINO)

LOC.  
I

SHEET  
6 OF 6

NO  
114-20062

REV.  
1