

**FASTON\* & FASTIN-FASTON\* Connector, .250" sr.s  
FLAG Receptacle Contact.**

**1. SCOPE**

This specification covers the requirements for application of FASTON\* & FASTIN-FASTON\* Connectors, .250" sr.s FLAG receptacle contacts. These requirements are applicable to automatic machine crimping tools. For specific wire and insulation ranges relative to the products covered in this specification see figure 6.

**1.1 REFERENCE SPECIFICATION.**

For applicable performance requirements, see AMP Product specification listed in Figure 6.

**2. PRODUCT FEATURES.**

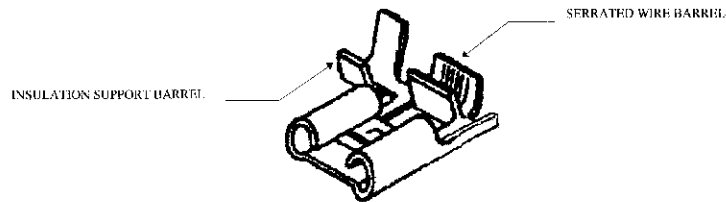


Figure 1

**3. NOMENCLATURE**

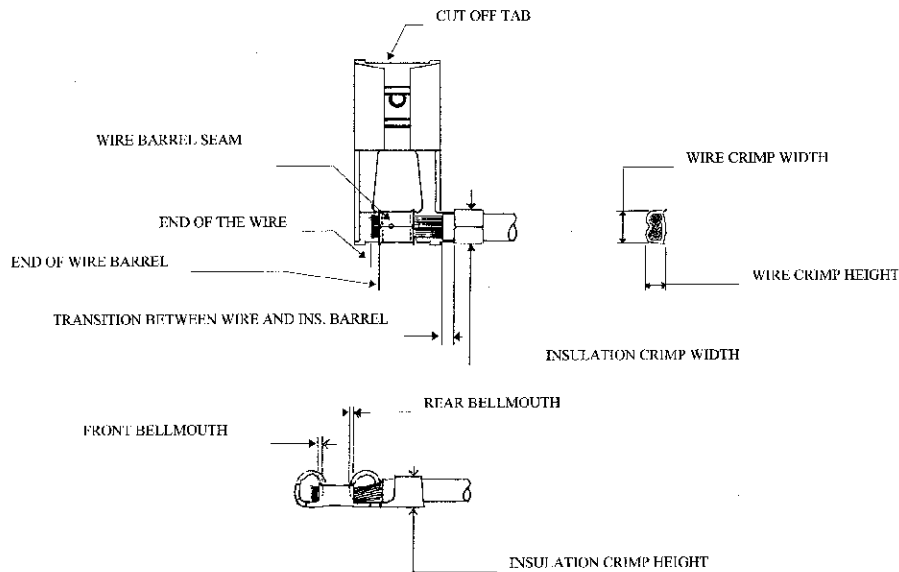


Figure 2

D3	ADDED NEW P/N.s. ET00-0003-05	H.Y.	05 JAN 2005	G.T.	05 JAN 2005
D2	REVISED FOR ET00-0128-03	H.Y.	25 July 2003	C.T.	25 July 2003
D1	REVISED FOR ET00-0048-02	H.Y.	07 MAR 2002	C.T.	07 MAR 2002
D	REVISED FOR ET00-0225-01	H.Y.	14 FEB 2002	C.T.	14 FEB 2002
C	REVISED AND RETYPED FOR ET00-0086-01	H.Y.	17 APR 2001	C.T.	17 APR 2001
rev letter	rev. record	DR	Date	CHK	Date
DR. H. YAALI	DATE 23 MAR 2001	APVD C. TARTARI	DATE 23 MAR 2001		

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**4. CRIMP AND DIMENSIONAL REQUIREMENTS.**

**4.1 Wire preparation**

- A. **Strip length:** Insulation shall be stripped as indicated in Figure 7.
- B. **Workmanship:** Reasonable care shall be taken not to nick, scrape or cut any strands during the stripping operation.

**4.2 Carrier Cutoff Tab and Burr**

- A. **Cutoff Tab:** shall not exceed .012 [0.31 mm. max.].
- B. **Burr on cutoff:** shall not exceed .006 [0.15 mm. max.].

**4.3 Wire Barrel Crimp.**

- A. **Crimp Dimensions and Type:** Crimp height, width and type shall be as shown in Figure 7.
- B. **Wire barrel flash:** Shall not exceed .006 [0.15 mm. max.].
- C. **Wire barrel seam:** shall not be completely closed and there shall be no evidence of loose wire strands or wire strands visible in the seam.
- D. **Bellmouth:**
  - (1) Rear bellmouth length shall be .015x60° max. [0.38x60° max.]
  - (2) Front bellmouth length shall be .000 [0]
- E. **Conductor location:**
  - (3) End of the wire shall be flush with the front end of the wire barrel or extend .030 [0.8mm] maximum after crimping.
  - (4) 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.

**4.4 Insulation Barrel Crimp.**

- A. **Crimp Dimensions and Type:** Crimp width and type shall be as shown in Figure 7.
- B. **Workmanship:** Reasonable care shall be taken not to cut or break the insulation during the crimping operation.

**4.5 Alignment.**

- A. **Straightness.**
  - (1) The contact, including the cutoff tab and burr shall not be bent above or below the datum line more than the amount shown in Figure 3.

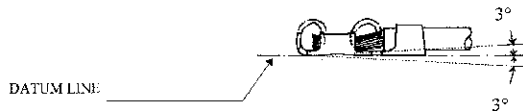


Figure 3

- (2) The side to side bending of the contact shall not exceed the limits specified in Figure 4.

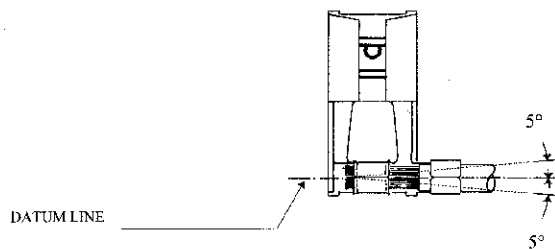


Figure 4

**B. Twist or Roll:** Twist or Roll of the crimped contact shall not exceed the limits specified in Figure 5.

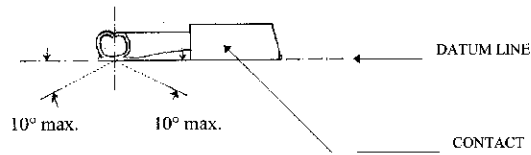


Figure 5

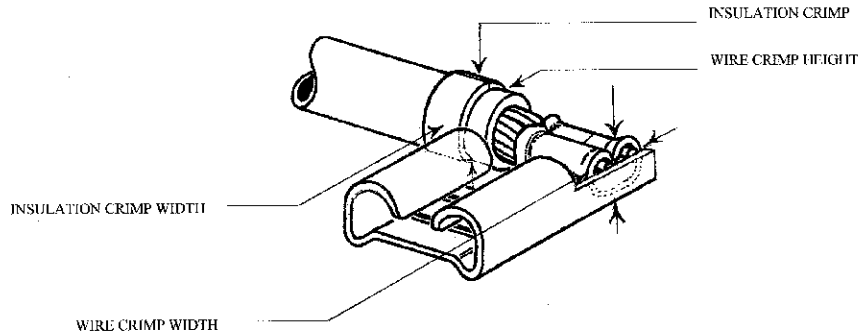


Figure 6

**AUTOMATIC MACHINE WIRE CRIMP DIMENSIONS**

**FASTON Connectors**

AMP P/N	LOG	AMP PRODUCT SPEC.	WIRE SIZE mm2	INSULATION DIA. mm	STRIP LENGTH APPROX. mm	WIRE BARREL CRIMP			INSUL. BARREL CRIMP		
						WIDTH REF. mm	HEIGHT mm	T Y P E	WIDTH REF. mm	HEIGHT REF. mm	T Y P E
180464	780311	108-20019	2.50	2.5-3.8	6.0	2.8	1.93	F	4.6	-	F
			2.00								
			1.50								
			1.00								
280050	780891	108-20019	1.50	2.0-3.3	6.0	2.54	1.55	F	3.55	-	F
			1.00								
			0.75								
			0.50								
160871	878042	108-20019	1.00	2.0-3.3	6.0	2.28	1.39	F	3.3	-	F
			0.75								
			0.50								

**FASTIN-FASTON\* Connectors**

AMP P/N	LOG	AMP PRODUCT SPEC.	WIRE SIZE mm2	INSULATION DIA. mm	STRIP LENGTH APPROX. mm	WIRE BARREL CRIMP			INSUL. BARREL CRIMP		
						WIDTH REF. mm	HEIGHT mm	T Y P E	WIDTH REF. mm	HEIGHT REF. mm	T Y P E
284697	780891	108-20020	1.50	2.0-3.3	6.0	2.54	1.55	F	3.55	3.00 MAX.	F
			1.00								
			0.75								
			0.50								
180398 280085	780311 680262		2.50	2.5-3.8	6.0	2.8	1.93	F	4.6	-	F
			2.00								
			1.50								
			1.00								

Figure 7