

APPLICATION SPECIFICATION

1. SCOPE

This specification covers the requirements for the application of AMPLIVAR* 5 serration thru splices. These requirements are applicable to automatic machine crimping tools. For specific CMA (circular mil area) ranges relative to the products covered in this specification, see Figure 4.

2. NOMENCLATURE

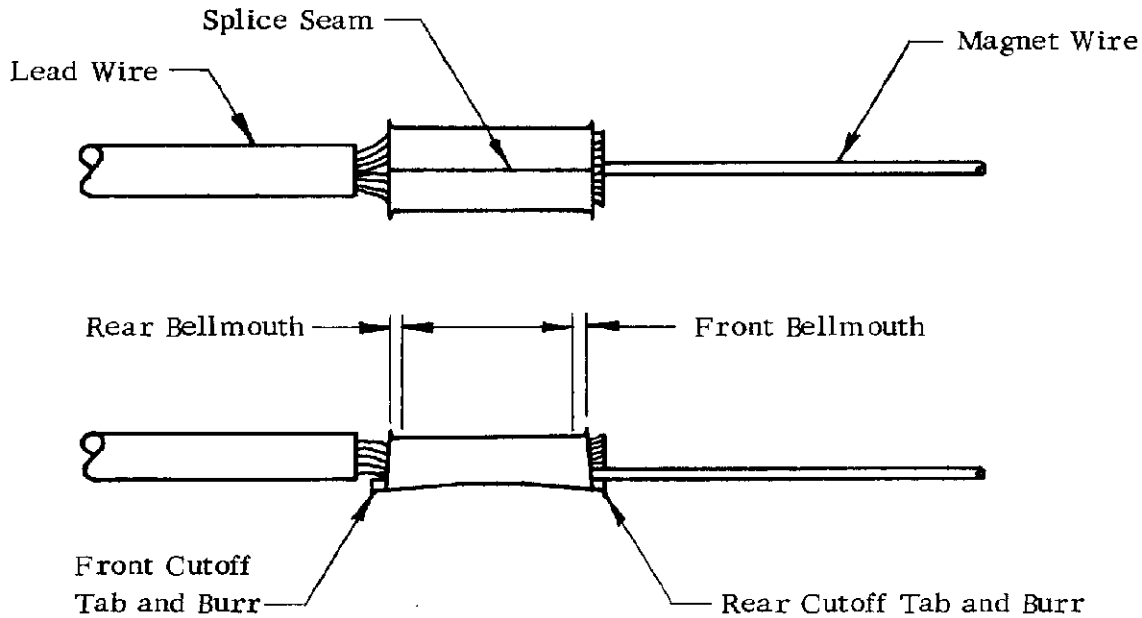


Figure 1

3. CRIMP AND DIMENSIONAL REQUIREMENTS

3.1. Wire Preparation

A. Magnet Wire

No preparation required.

B. Lead Wire

- (1) Insulation shall be stripped as indicated in Figure 4.
- (2) 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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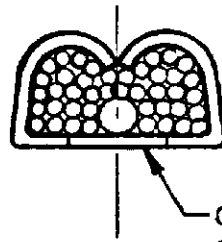
NO 114-2009

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				APP <i>C. E. Felt 6/9/75</i>	LOC B	A	NO 114-2009	REV B	
	B	Revise Figure 3	<i>AGP</i>	<i>4/15/83</i>	NAME SHEET 1 OF 3				
	A	Rev Para 3.2.A.	<i>AGP</i>	<i>8-10-79</i>					SPLICE, THRU, 5 SERRATION, AMPLIVAR, APPLICATION OF
DIST 02	0	Was SDF 1C-22							
LTR		REVISION RECORD	APP	DATE					

3.2. Carrier Cutoff Tab and Burr

A. Cutoff Tab

Cutoff tabs shall be centered within the limits shown in Figure 2.



Cutoff tab centered with centerline of splice within .015 TIR.

Figure 2

B. Burr

Burr on cutoff shall not exceed .008.

3.3. Splice Crimp

A. Crimp Dimensions

- (1) Crimp width shall be as shown in Figure 4.
- (2) Consult AMP Engineering for specific crimp heights. Crimp heights specified by AMP Engineering shall be measured at the location shown in Figure 3, with a tolerance of $\pm .003$ unless otherwise specified.

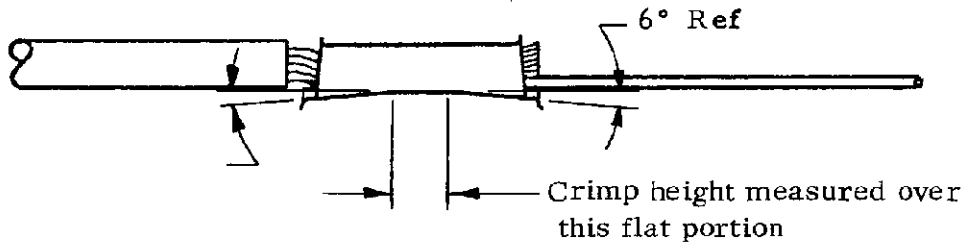



Figure 3

B. Tensile Strength

Crimp tensile strength shall be 70% of the wire tensile strength.

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C. Splice Seam

Splice seam shall be completely closed and there shall be no evidence of loose wire strands or wire strands visible in the seam.

D. Bellmouth

Bellmouth permissible both ends.

E. Conductor Location

- (1) Wires shall extend thru the splice before crimping.
- (2) Conductors shall be visible between the lead wire insulation and the rear of the splice.
- (3) Magnet wire(s) shall lie in the bottom of the splice.



Part Number	Wire CMA	Lead Wire Strip Length	Splice Crimp	
			Width	Type
42076	600-3000	$.310 \pm .031$ 	.110	F
42192	600-3000		.110	F
41765	1500-5000		.110	F
41899	1500-5000		.110	F
42119	1500-5000		.110	F
41766	3000-7000		.140	F
41900	3000-7000		.140	F
41770	7000-13000		.180	F
41904	7000-13000		.180	F

Figure 4

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