

1. INTRODUCTION

This specification covers the requirements for application of AMP* (Mallory) timer connector terminal. 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 5.

2. NOMENCLATURE

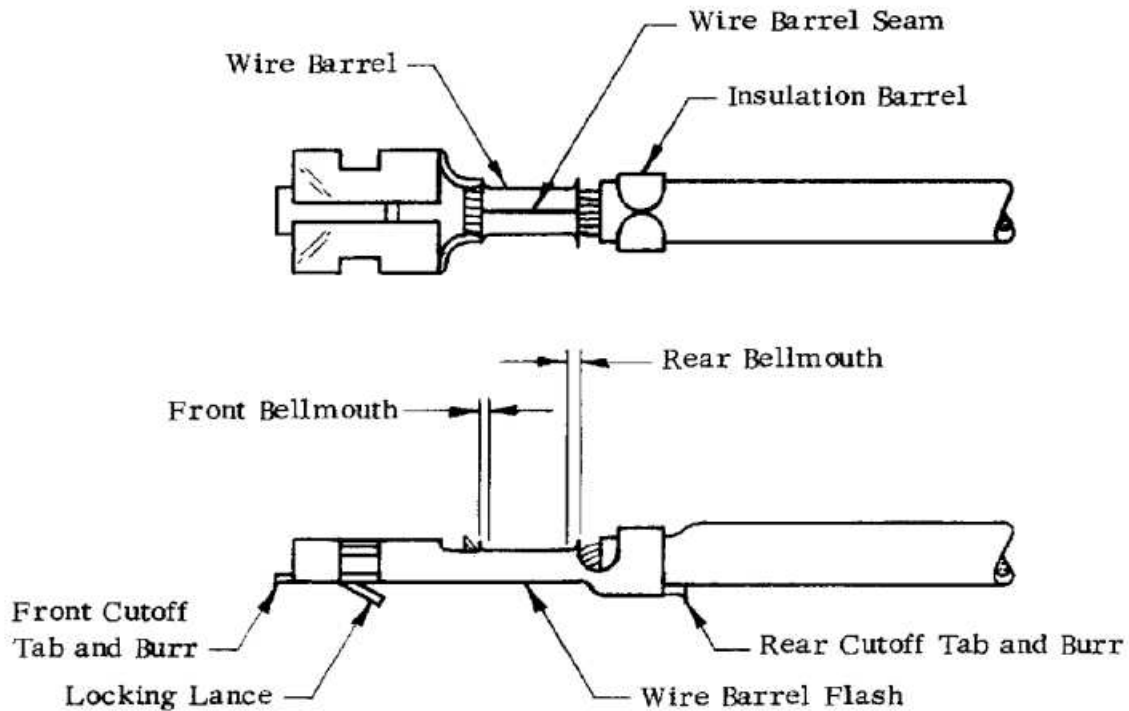


Figure 1

3. CRIMP AND DIMENSIONAL REQUIREMENTS

3.1. Wire preparation

A. Strip Length

Insulation shall be stripped as indicated in Figure 5.

B. Workmanship

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

3.2. Carrier Cutoff Tab and Burr

A. Cutoff Tab

Cutoff tab shall not exceed .010.

B. Burr

Burr on cutoff shall not exceed .005.

3.3. Wire Barrel Crimp

A. Crimp Dimensions and Type

Crimp Height, width and type shall be as shown in Figure 5.

B. Wire Barrel Flash

Wire barrel flash shall not exceed .005.

C. Wire Barrel Seam

Wire barrel seam shall 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 .020 - .040.
2. Front bellmouth length shall be .020 max.

E. Conductor Location

1. End of the wire shall be flush with the front end of the wire barrel or extend .031 max 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 height, width and type shall be as shown in Figure 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. 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 2.

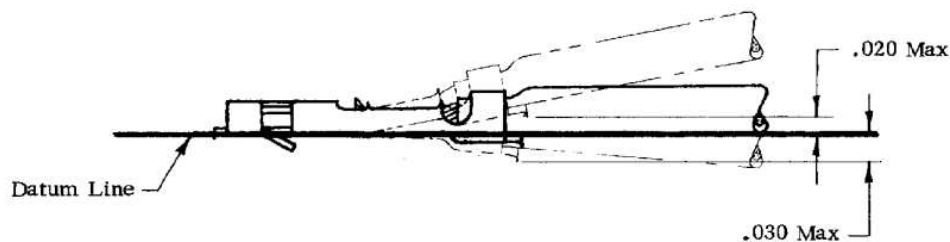


Figure 2

2. The side to side bending of the contact shall not exceed the limits specified in Figure 3.

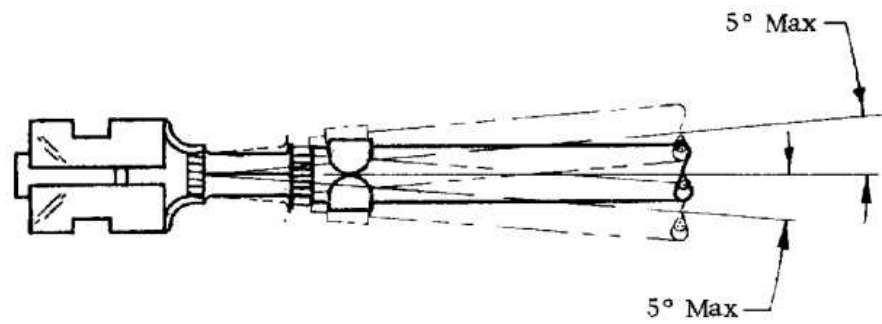


Figure 3

B. Twist and Roll

There shall be no twist or roll in crimped portion that will impair usage of the contact and shall be within the limits shown in Figure 4.

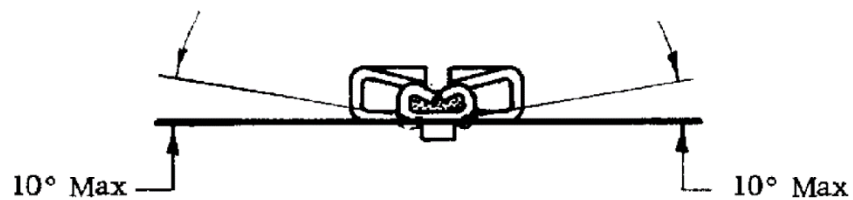


Figure 4

Part No	Wires		Insulation Diameter	Strip Length ± 0.015	Wire Barrel Crimp			Insulation Barrel Crimp	
	No	Size			Width	Height	Type Crimper	Width	Type Crimper
62058	1	22	.060 - .105	.215	.070	.047	F	.140	F
	1	20		.230		.049			
	1	18		.230		.055			
62063	1	20	.105 - .130	.230	.090	.048	F	.140	F
	1	18		.230		.053			
	1	16		.230		.060			
61992	1	18	.180 - .230	.230	.110	.055	F	.250	F
	1	16		.230		.061			
	1	14		.245		.070			
	2	18	(2) .125 max	.230		.066			
	2	16		.230		.076			
928845	1	0.34 mm ²	.075 - .150 [1.9 – 3.8]	0.197 [5.0 mm]	.080	.042	F	.140	OV
	1	0.5 mm ²				.045			
	1	0.75 mm ²				.049			
	1	0.88 mm ²				.052			

Figure 5: Automatic Machine Wire Crimp Dimensions