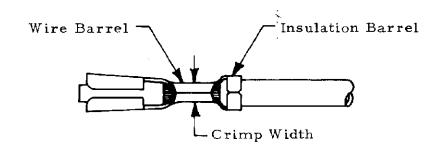## APPLICATION SPECIFICATION

1. SCOPE

This specification covers the requirements for application of 78, 98 and 196 series AMP* Taper Tab receptacle 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 refer to the appropriate AMP customer drawing.
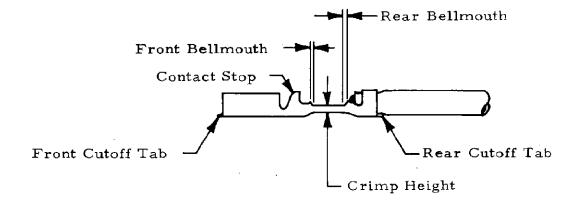
2. NOMENCLATURE

Figure 1

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				CHK F.C. Ba... III 12-7-84			
				APP J.H. ... 12/7/84	LOC B	NO 114-2076	REV 0

C					SHEET 1 OF 3	TITLE RECEPTACLE, TAPER TAB, 78, 98 & 196 SERIES
DIST 02	0	Was SDF 1C-3				
	LTR	REVISION RECORD	APP	DATE		

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3. CRIMP AND DIMENSIONAL REQUIREMENTS

3.1. Wire Preparation

A. Strip Length

Insulation shall be stripped as indicated in Figure 2 and is based on wire barrel length.

Wire Barrel Length	Wire Strip Length, nominal
.093 – .108	1/8
.109 – .141	5/32
.142 – .174	3/16
.175 – .207	7/32
.208 – .240	1/4
.241 – .273	9/32

Figure 2

B. Workmanship

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

Front cutoff tab shall not be bent up toward receptacle portion.

3.3. Wire Barrel Crimp

A. Crimp Dimensions and Type

Crimp height, width and type shall be as shown in the appropriate Applicator Log Sheet for machine applications or the Instruction Sheet for hand tool applications.

B. Bellmouth

(1) Front bellmouth height shall not exceed height of transition.

(2) Rear bellmouth required.

C. Conductor Location

(1) End of the wire shall lay flat and extend through front end of wire barrel.

		LOC	SHEET	NO	REV
AMP	AMP INCORPORATED Harrisburg, Pa. 17105	B	2 OF 3	114-2076	0

AMP 1251-13 REV 4-82

       (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

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

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