The performance of applicable product is guaranteed only when processed by proper application tooling and condition described in this specification and/or AMP recognized ones. No product is guaranteed when processed with the other tool or condition.

1. Scope

This specification covers the requirements for crimping of 025 G Tab Contact.

2. Applicable Contacts

AMP Part Numbers		Finish	Applicable Wires
Strip Form	Loose Piece		
1473579-1	1674075-1	Tin Plating	AVSS/CAVS/AVSSH 0.3~0.5 CAVUS 0.3~0.5

3. Nomenclature

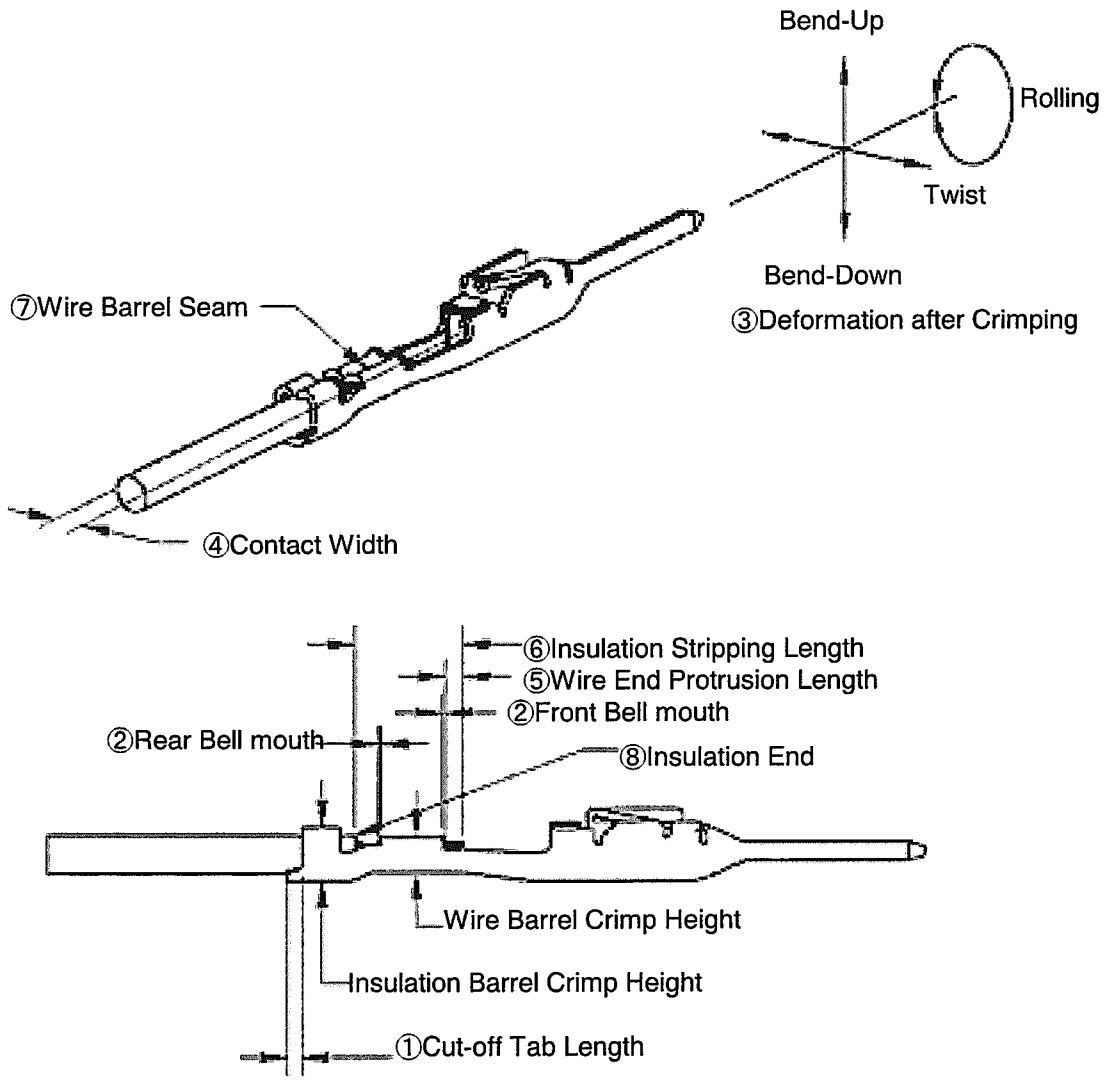

Fig.1

4. Crimping Condition

4.1 Applicator Crimp

Check Items			AVSS/CAVS/AVSSH 0.3 CAVUS 0.3~0.5	AVSS/CAVS/AVSSH 0.5	Remarks
1	Cut-off Tab Length		0.1~0.5 mm		Fig.1-①
2	Bell mouth	Front	0.2 mm Max.		Fig.1-②
		Rear	0.1~0.4 mm		
3	Deformation After Crimping	Bend	-1° , +2° Max.		Fig.1-③
		Twist	±4° Max.		
		Rolling	±10° Max.		
4	Contact Width after Crimping (1)		1.6mm Max.	1.8mm Max.	Fig.1-④
5	Wire End Protrusion Length		0~1.0 mm		Fig.1-⑤
6	Insulation Stripping Length		3.0~3.5 mm		Fig.1-⑥
7	Wire Barrel Seam		Seam must be closed (No strand looses out of the seam)		Fig.1-⑦
8	Insulation End		Insulation End must be between Wire barrel and Insulation Barrel		Fig.1-⑧

NOTE (1) There is possibility of the dimension is different caused of the ability of operator. Make sure the contact must be inserted smoothly into the Cap housing.

4.2 Hand Tool Crimp

Check Items			AVSS/CAVS/AVSSH 0.3 CAVUS 0.3~0.5	AVSS/CAVS/AVSSH 0.5	Remarks
1	Cut-off Tab Length		0.1~0.5 mm		Fig.1-①
2	Bell mouth	Front	0.1~0.4 mm		Fig.1-②
		Rear	0.1~0.4 mm		
3	Deformation After Crimping	Bend	±4° Max.		Fig.1-③
		Twist	±4° Max.		
		Rolling	±10° Max.		
4	Contact Width after Crimping		1.6mm Max.	1.8mm Max.	Fig.1-④
5	Wire End Protrusion Length		0~1.0 mm		Fig.1-⑤
6	Insulation Stripping Length		3.0~3.5 mm		Fig.1-⑥
7	Wire Barrel Seam		Seam must be closed (No strand looses out of the seam)		Fig.1-⑦
8	Insulation End		Insulation End must be between Wire barrel and Insulation Barrel		Fig.1-⑧

NOTE (1) There is possibility of the dimension is different with operator's skill level. Make sure the contact must be inserted smoothly into the cap housing.

5. Crimp Data

5.1 Applicator Crimp

Contact Part Number (Strip Form)	Wire Size (Nominal)	Applicator Part Number	Wire Barrel Crimp (mm)			Insulation Barrel Crimp (mm)			Crimp Tensile Strength (N)
			Width(2)	Height(1)	Disk Ltr.	Width(2)	Height(1)	Disk Ltr.	
1473579-1	0.3 0.3f	1463982-2	1.4 "F"	0.96	B	1.4 "F"	See Para. 6		70 Min.(3)
	0.5			1.01	A				90 Min.

NOTE (1)Wire Barrel Crimp Height to be within ±0.05
(2)Crimp Width dimensions are not the product width after crimping, but given by the width of crimper slot for reference
(3) Crimp Tensile Strength of 0.3 wires includes the wire grip of insulation barrel crimp.

5.2 Hand Tool Crimp

Contact Part Number (Loose Piece)	Wire Size (Nominal)	Hand Tool (1) Part Number	Insulation Diameter (mm)	Crimp Symbol		Wire Barrel Crimp Height (mm)	Crimp Tensile Strength (N)
				Wire	Insulation		
1674075-1	0.3 0.3f	1463260-1(3)	1.1-1.7	20-22	INS	0.84-1.00	50 Min. (2)
	0.5						63 Min.

NOTE (1) This tool is for maintenance. The different dimensions may be caused with operator's skill level. Except for the purpose above, you should use the applicator.
(2) Crimp Tensile Strength of 0.3 wires includes the wire grip of insulation barrel crimp.
(3) Common hand tool for receptacle and 025G tab.

6. Insulation Barrel Crimp Data

Contact Part Number (Strip Form)	Wire Size (Nominal)	AVSSH/AVSS/CAVS		CAVUS	
		Height (1) (mm)	Disk Ltr. (Ref.)	Height (1) (mm)	Disk Ltr. (Ref.)
1473579-1	0.3/0.3f	1.85	4	1.75	5
	0.5	1.85	4	1.85	4

NOTE (1) Insulation Barrel Crimp Height to be within ±0.1

7. Applicable Wire Data

Wire Size (Nominal)	Number/ Diameter (mm) of Conductor	Calculated Cross sectional Area (mm^2)	Insulation Diameter (mm)			
			AVSSH/AVSS/CAVS		CAVUS	
			STD.	MAX.	STD.	MAX.
0.3	7/0.26	0.3716	1.4	1.5	1.1	1.2
0.3f	19/0.16	0.3821	1.4	1.5	—	—
0.5	7/0.32	0.5629	1.6	1.7	1.3	1.4