

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 2.3mm TW Receptacle Contact.

### 2. Applicable Contacts

Part Numbers	Finish	Applicable Wires [mm <sup>2</sup> ]
1981341-1	Tin Plating	AVS/CAVS/AVSS/CAVUS 0.3~0.5, AVX/AEX/ABAVX 0.5f
1981341-2	Tin Plating	AVS/CAVS/CAVUS 0.85~1.25, AVSS 0.75f, 0.85~2.0

### 3. Nomenclature

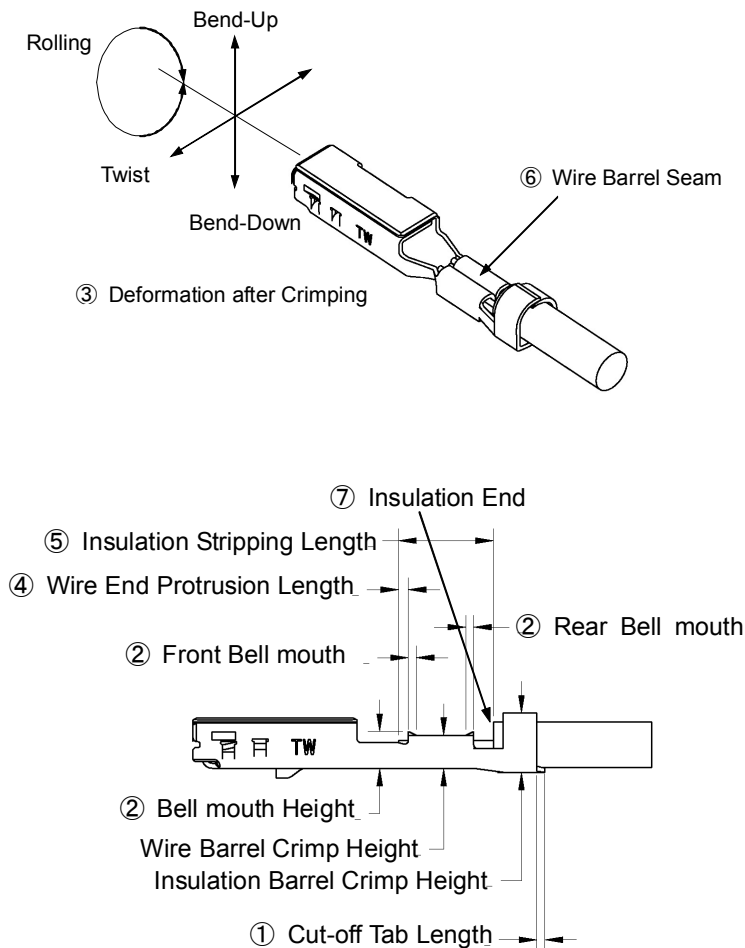


Fig.1

## 4. Crimping Condition

### 4.1 Applicator Crimp

Check Items		1981341-1 / -2	Remarks
1	Cut-off Tab Length	0.1~0.4 mm	Fig.1-①
2	Bell mouth	Front (1)	0.4 mm 以下
		Rear	0.1~0.65 mm
		Height	1.7mm以下
3	Deformation After Crimping	Bend	±2° 以下
		Twist	±2° 以下
		Rolling	±10° 以下
4	Wire End Protrusion Length	0~0.5 mm	Fig.1-④
5	Insulation Stripping Length	4.5~5.5 mm	Fig.1-⑤
6	Wire Barrel Seam	Seam must be closed (No strand looses out of the seam)	Fig.1-⑥
7	Insulation End	Insulation End must be between Wire barrel and Insulation Barrel	Fig.1-⑦

**NOTE** (1) No cracks after crimp.

## 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 <sup>(2)</sup>	Height <sup>(1)</sup>	Disk Ltr.	Width <sup>(2)</sup>	Height <sup>(1)</sup>	Disk Ltr.	
1981341-1	0.3	1596588-2	2.0"F"	0.81	C	2.6"O"	See Para.6	58.8 Min	
	0.5			0.90	A			88.2 Min	
	0.5f			0.87	B			88.2 Min	
1981341-2	0.75f	1596590-2	2.4"F"	1.11	D	3.0"O"	See Para.6	127 Min	
	0.85			1.14	C			127 Min	
	1.25			1.28	B			167 Min	
	2.0			1.47	A			167 Min	

**NOTE** (1) Wire Barrel Crimp Height to be within: ±0.05

Insulation Barrel Crimp Height to be within: ±0.1

(2) Crimp Width dimensions are the product width after crimping.

Crimp Width to be within:  $\begin{matrix} +0 \\ -0.15 \end{matrix}$

**6. Insulation Barrel Crimp Data**

Contact Part Number (Strip Form)	Wire Size (Nominal)	AVS		CAVS		CAVUS		AVX/AEX/ABAVX	
		Height (mm) <sup>(1)</sup>	Disk Ltr. (Ref.)	Height (mm) <sup>(1)</sup>	Disk Ltr. (Ref.)	Height (mm) <sup>(1)</sup>	Disk Ltr. (Ref.)	Height (mm) <sup>(1)</sup>	Disk Ltr. (Ref.)
1981341-1	0.3	2.20	2	1.90	5	1.80	6	/	/
	0.5	2.30	2	2.10	4	1.90	7	/	/
	0.5f	/	/	/	/	/	/	2.30	2
		AVS, AEX		CAVS		CAVUS		AVSS	
1981341-2	0.75f	/	/	/	/	/	/	2.35	4
	0.85	2.65	3	2.35	4	2.10	6	2.35	4
	1.25	3.15	2	2.60	4	2.35	5	2.60	4
	2.0	/	/	/	/	/	/	3.00	3

**NOTE** (1) Insulation Barrel Crimp Height to be within:  $\pm 0.1$

**7. Applicable Wire Data**

Wire Size (Nominal)	Number/ Diameter (mm) of Conductor	Calculated Cross sectional Area (mm <sup>2</sup> )	Insulation Diameter (mm)					
			AVS		CAVS		CAVUS	
			STD.	MAX.	STD.	MAX.	STD.	MAX.
0.3	7/0.26	0.3716	1.8	1.9	1.4	1.5	1.1	1.2
0.5	7/0.32	0.5629	2.0	2.1	1.6	1.7	1.3	1.4
0.85	11/0.32	0.8846	2.2	2.3	1.8	1.9	1.5	1.6
1.25	16/0.32	1.287	2.5	2.6	2.1	2.2	1.8	1.9
			AVSS					
0.5	7/0.32	0.5630	1.6	1.7	/	/	/	/
0.75f	19/0.23	0.7894	1.8	1.9	/	/	/	/
0.85	19/0.24	0.8595	1.8	1.9	/	/	/	/
1.25	19/0.29	1.2550	2.1	2.2	/	/	/	/
2.0	37/0.26	1.9644	2.6	2.7	/	/	/	/
			AVX, AEX, ABAVX					
0.5f	20/0.18	0.5087	2.0	2.2	/	/	/	/