Application Specification

114-5108

Crimping .040 Series Tab Contact

1. Scope:

This specification covers crimping requirements for .040 Series Tab Contact.

2. Applicable Contact:

Part No.: 173682 Tab Contact (Strip Form)
175063 " " (Loose Piece)

3. Nomenclature of Product:

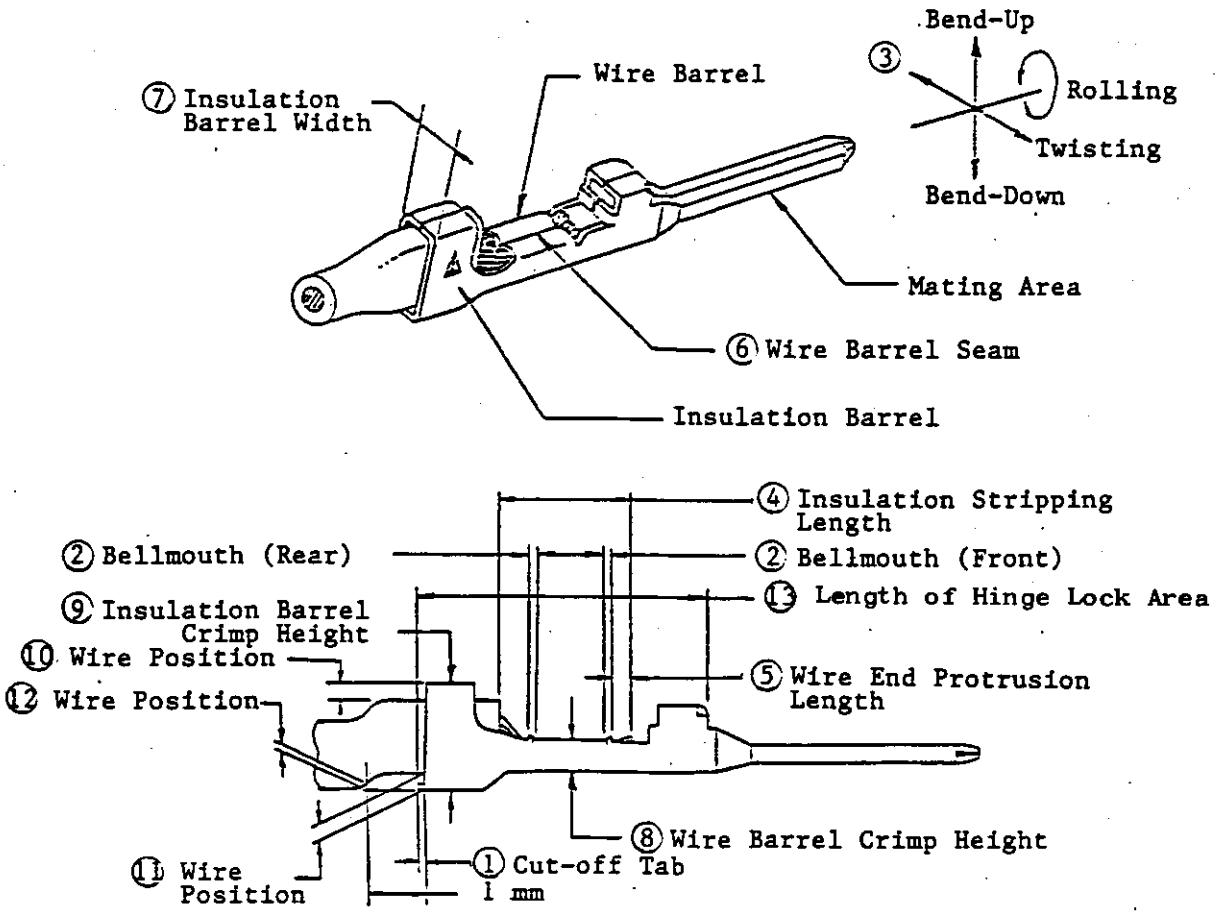

Fig.1

LTR	REVISION RECORD	DR	CHK	DATE
A	Revised RFA-1510			2/9/90
0	Released RFA-1258			4/7/88

DR 26 FEB 88 CHK 1 MAR 88 APP

AMP (Japan), Ltd. TOKYO, JAPAN

LOC J A NO 114-5108 REV A

SHEET 1 OF 3

NAME Application Specification Crimping ".040" Series Tab Contact

AMP SECURITY CLASSIFICATION Application Specification NUMBER 114-5108

4. Crimping Requirements:

No.	Item		Crimping Requirements	Remarks
1	Cut-off Tab		0.25 mm max.	Fig.1 ①
2	Bellmouth	Front	0 ∿ 0.4 mm	" ②
		Rear	0.15 ∿ 0.65 mm	
3	Allowable Limit of Deformation	Bending	Within +2°& -4°	" ③
		Twisting	Within 3°	
		Rolling	Within 5°	
4	Wire Insulation Stripping Length (Ref.)		4 ~ 4.5 mm	" ④
5	Wire End Protrusion Length		0 ~ 1.5 mm	" ⑤
6	Wire Barrel Seam		Core wire shall not be seen.	" ⑥
7	Insulation Barrel Width (after crimping)		2.05 mm max.	" ⑦
8	Wire Position	Upper Side	0.35 mm min.	" ⑩
		Lower " (1)	0.35 mm min.	" ⑪
		Lower " (2)	0 min.	" ⑫
9	Length of Hinge Lock Area		10.3 mm max.	" ⑬

5. Crimp Data:

5.1 Applicator Crimp:

Contact Part No. (Strip Form)	Wire Size (Nominal)	Applicator Part No.	Wire Barrel Crimp			Insulation Barrel Crimp			Crimp Tensile Strength (kg)
			Width (mm)	Height ±0.05(mm) (Fig.1 ⑧)	Disk	Width (mm)	Height(mm) (Fig.1 ⑨)	Disk (Ref.)	
173682-1	0.3	755831-1	1.57 "F"	0.92	B	1.78	3.7±0.1	4	6 min.
	0.5	-2		1.02	A			5	9 min.

Note: Crimp tensile strength includes the strength of insulation support.

5.2 Hand Tool Crimp:

Contact Part No. (Loose Piece)	Wire Size (Nominal)	Hand Tool Part No.	Wire Barrel Crimp			Insulation Crimp		Crimp Tensile Strength (kg) min.
			Width (mm)	Height (mm) Fig. 1 ⑧	Crimp Symbols	Width (mm)	Height(mm) Fig. 1 ⑨	
175063-1	0.3	911738-2	1.57 "F"	0.74-0.90	B	1.78	3.7 ±0.1	6 min.
	0.5			0.90-1.07	A			9 min.

Note: Crimp tensile strength includes the strength of insulation support.

6. Applicable Wire:

Nominal	No. of Conductors / Diameter of a Conductor (mm)	Calculated Cross-sectional Area (mm^2)	Finished Overall Diameter (mm)	Symbol of Wire (Ref.)	Wire Specification
					(Low voltage wire and cable for automobile)
0.3	7/0.26	0.37	1.8	AVS	
0.5	7/0.32	0.56	2.0	AVS	

(Approved by A/T Technical Dept.)

Manager	Designer
11 MAR 88	J. KOGA 11 Mar 88