

114-5197

Application Specification

Crimping of O40 III Series, Receptacle Contacts

114 - 5197

NUMBER:

Customer Release

SECURITY CLASSIFICATION:

1. Scope:

This specification covers the requirements for crimping of O40 III Series, Receptacle Contacts.

2. Applicable Product Part Numbers:

Part No. (Strip)	Descriptions	Finish
179963	Receptacle Contact(S)	Tin-plated
179964	" " (S)	Gold-plated

3. Nomenclature:

For the purpose of this specification, the following nomenclature shall apply.

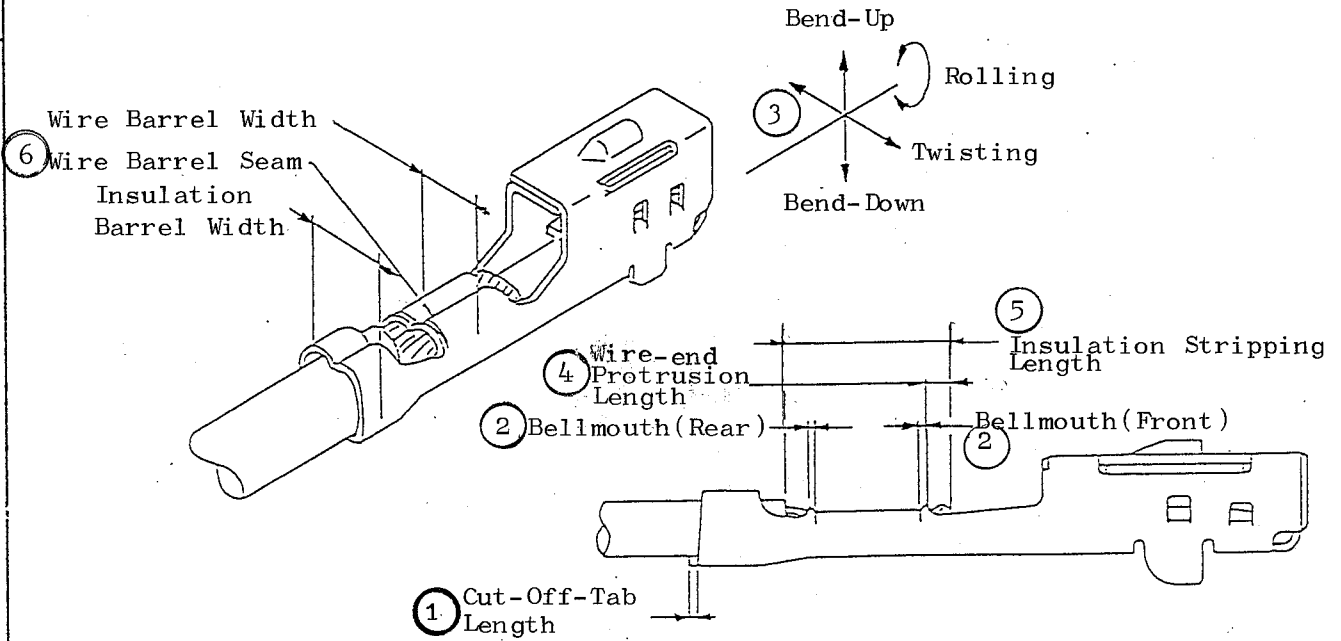


Fig. 1

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4. Crimping Conditions:

NUMBER: 114 - 5197  
 Customer Release  
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No.	Check Items	Applicable Part Nos.		Remarks
		179963	179964	
1	Cut-Off-Tab Length		0.5 max.	Fig. 1 (1)
2	Bellmouth	Front	0.2 max.	Fig. 1 (2)
		Rear	0.5 max.	
3.	Deviation after Crimping	Bend	$\pm 4^\circ$ max.	Fig. 1 (3)
		Twisting	$\pm 4^\circ$ max.	
		Rolling	$10^\circ$ max.	
4	Wire End Protrusion Length		0 - 1.0mm	Fig. 1 (4)
5	Insulation Stripping Length		4 - 4.5mm	Fig. 1 (5)
6	Wire Barrel Seam	Seam shall be neatly closed. A slight gap may be permissible so long as no strand exposure is present.		Fig. 1 (6)

5. Crimp Data:

Contact Description	Contact Part No. (Strip Form)	Applicator Number	Wire Size Nominal	Wire Crimp			Insulation Crimp			Crimp Tensile Strength (kg) (min.)			
				Width (mm)	Height (mm)	Disc Ltr.	Width (mm)	Height (mm)	Disc Ltr.				
Receptacle (S)	179963	915767-2	0.3	1.78	0.94	C	1.78	7	7	6.0			
	179964		0.5		"F"	1.03				B	Ref.	Ref.	9.0
			0.85			1.17				A			13.0

- Notes:
- The general tolerance of wire barrel crimp height to be within  $\pm 0.05$ mm.
  - Crimp tensile strength includes the strength of wire insulation grip.
  - The width of wire barrel and insulation barrel refers to the width of crimping tool.

NAME Crimping of O40 III Series, Receptacle Contacts

SHEET

2 OF 3



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LOC	LOC	NO.	114 - 5197	REV.	0
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NUMBER: 114 - 5197

NUMBER:

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## 6. Applicable Wires:

Wire Size Nominal (mm <sup>2</sup> )	No. of Conduc- tors of a Conductor	Dia- meter of Conductor	Calculated Cross- Sectional Area (mm <sup>2</sup> )	Finished Insulation Diameter (mm)					
				AVS		AVSS/CAVS		CAVUS	
				STD	Max.	STD	Max.	STD	Max.
0.3	7 /	0.26	0.37	1.8	1.9	1.4	1.5	1.1	1.2
0.5	7 /	0.32	0.56	2.0	2.1	1.6	1.7	1.3	1.4
0.85	11 /	0.32	0.88	-	-	1.8	1.9	1.5	1.6

## 7. Insulation Barrel Crimp Data (Reference):

Contact Part No.	Wire Type Wire Crimp Size Data (mm <sup>2</sup> )	AVS		AVSS/CAVS		CAVUS	
		Height (mm)	Disc (Ref.)	Height (mm)	Disc. (Ref.)	Height (mm)	Disc (Ref.)
179963	0.3	2.45	2	2.29	3	2.17	5
179964 (S)	0.5	2.53	2	2.37	3	2.25	5
	0.85	--	--	2.45	4	2.33	5

- Notes:
1. The columns with a bar(-) show the wires of the types not being applicable to this application.
  2. The general tolerance of insulation barrel crimp to be within  $\pm 0.1\text{mm}$ .
  3. In crimping AVS wire by  $0.5\text{mm}^2$  range and on AVSS/CAVS wire by  $0.85\text{mm}^2$  range, some excessive biting crimp on insulation may occur. It is, however, this biting crimp may be permissible, since no practical problem is resulted.

NAME

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SHEET

3 OF 3

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NO.

114 - 5197

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