



2.2 WIRE PROTRUSION - After crimping, the end of the bare wire shall be located between a point flush with the front end of the wire barrel or extend beyond the front edge of the wire barrel .030. (See Figure II)

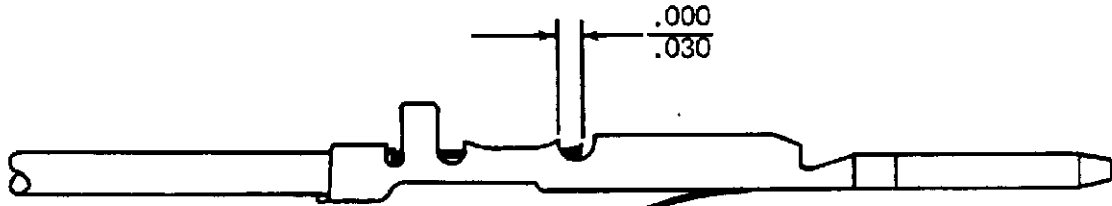


FIGURE II

2.3 CUT-OFF TAB - The cut-off tab shall be a minimum of .005 to a maximum of .015 on insulation barrel and must not be bent up. However, this tab may have a maximum downward cut-off burr of .003.

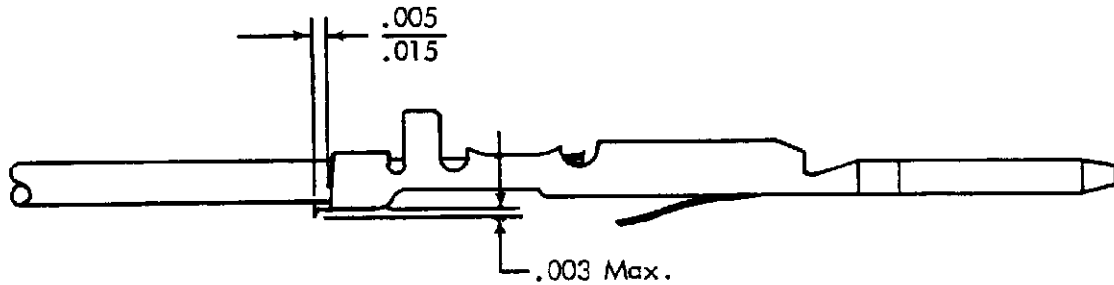


FIGURE III

2.4 WIRE BARREL BELLMOUTH - The crimped wire barrel must have a bellmouth on the rear between the limits of .006 to .018. The front of the wire barrel may have a maximum bellmouth of .006. (See Figure IV)

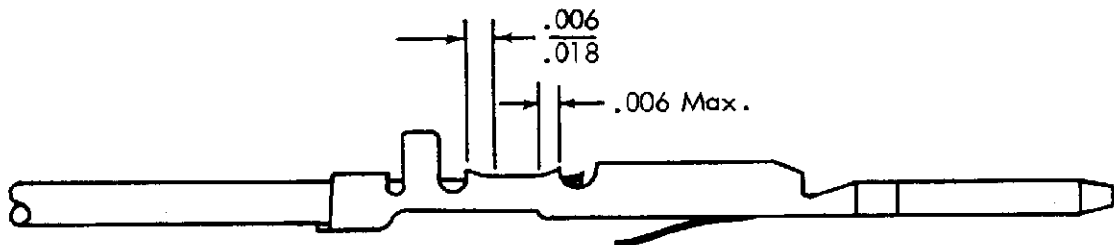


FIGURE IV

SHEET		<b>AMP</b>		AMP INCORPORATED	
2 OF 4				HARRISBURG PENNA.	
LOC	A	NO	108-9,206	REV	A
NAME Product Specification for Crimping AMP Duo-Tyne Leaf Contacts					

2.5 STABILIZER WIDTH (Female Contacts Only) - After crimping the width of the stabilizer shall not exceed .096. (See Figure V)

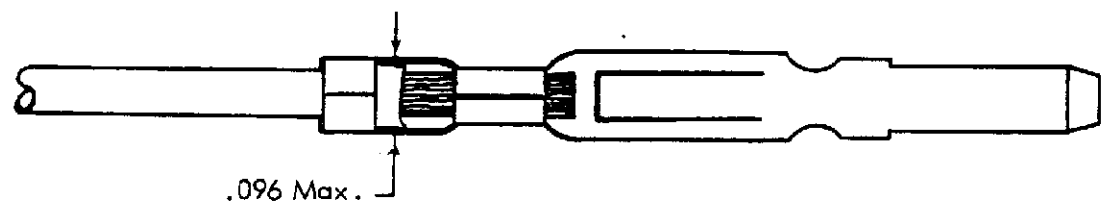


FIGURE V

2.6 INSULATION BARREL LOCATION - The lowest part of the insulation barrel including the cut-off burr shall not exceed .128 when measured as shown in Figure VI for the female contacts or Figure VIa for the male contact.

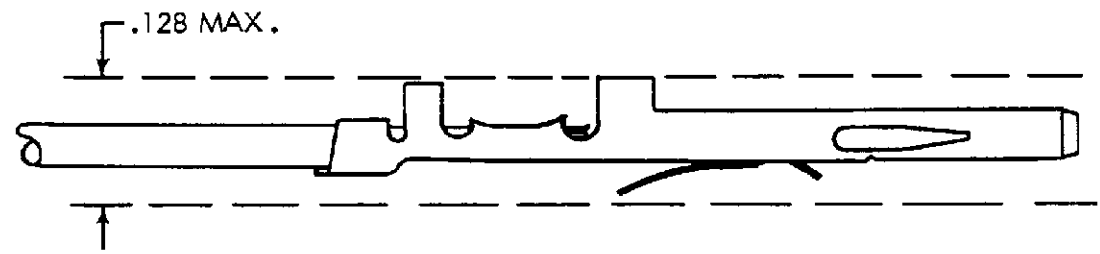


FIGURE VI

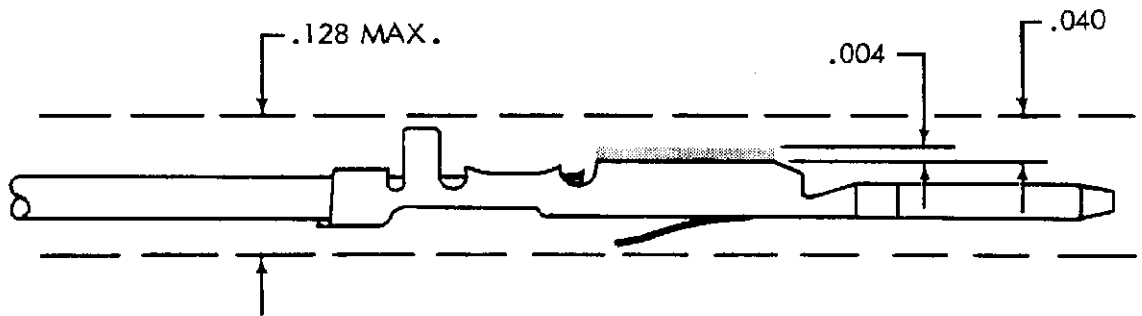


FIGURE VIa

SHEET 3 OF 4	<b>AMP</b>		AMP INCORPORATED HARRISBURG, PENNA.
	LOC <b>A</b>	NO 108-9,206	REV <b>A</b>
NAME Product Specification for Crimping AMP Duo-Tyne Leaf Contacts			

2.7 CONTACT DISTORTION -

2.7.1 CONTACT DISTORTION (Female Contacts) - The crimped contact shall not become distorted to the extent that it will not lie between the parallel lines as shown in Figure VII.

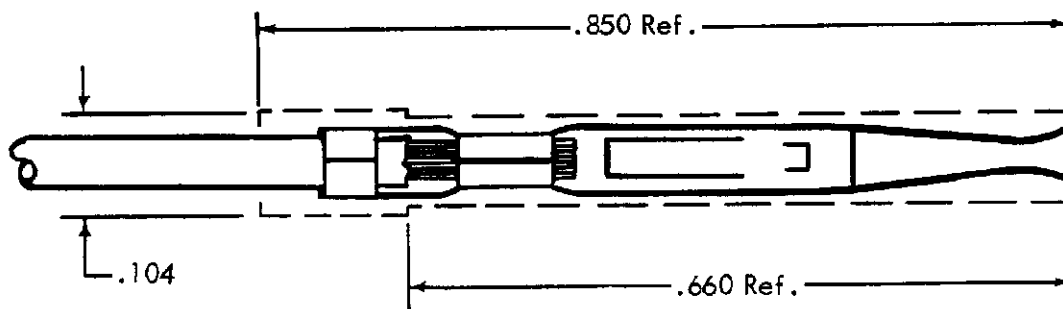


FIGURE VII

2.7.2 CONTACT DISTORTION (Male Contacts) - The crimped contact shall not become distorted to the extent that it will not lie between the parallel lines as shown in Figure VIII.

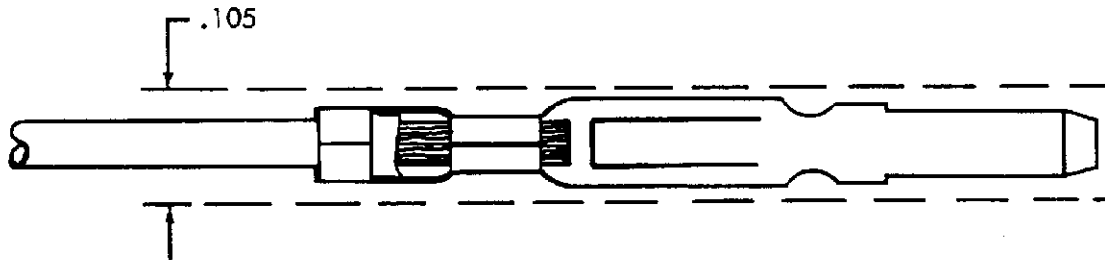


FIGURE VIII

2.8 CRIMP HEIGHTS - Crimped contacts shall be measured for certifying crimp heights in accordance with Table I.

TABLE I

HAND TOOL NO. 90023		APPLICATOR
#22	.045 ± .002	.044 ± .002
#20	.045 ± .002	.048
#18	.050 ± .002	.053
2- #22	.050 ± .002	.050

SHEET	<b>AMP</b>		AMP INCORPORATED	
			HARRISBURG PENNA.	
4 OF 4	LOC	NO	REV	
	A	108-9,206	A	
NAME Product Specification for Crimping AMP Duo-Type Leaf Contacts				