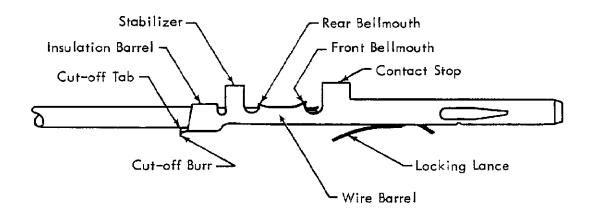
PRODUCT SPECIFICATION FOR CRIMPING AMP DUO-TYNE LEAF CONTACTS

1. SCOPE:

- 1.1 SCOPE The purpose of this specification is to establish the parameters within which the AMP CRIMP-ON, SNAP-IN, DUO-TYNE LEAF CONTACT shall be crimped.
- 1.2 STYLE The requirements apply to both male and female contacts crimped by hand tool or machine unless otherwise specified.
- 1.3 TYPE This contact shall have an "F" wire crimp and "F" or "O" insulation crimp.
- 1.4 DEFINITIONS The following definitions shall apply for this specification.



Female Duo-Tyne Leaf Contact

FIGURE 1

2. REQUIREMENTS:

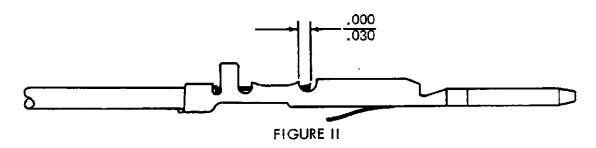
- 2.1 WIRE STRIP LENGTH The AMP recommended wire strip length shall be a minimum of .125 and a maximum of .156. Care must be exercised so that no strands are scraped, nicked or cut off during the stripping operation.
 - 2.1.1 INSULATION LOCATION The end of the wire insulation shall be visible between the insulation and wire barrel.

APP Long 10-21-63

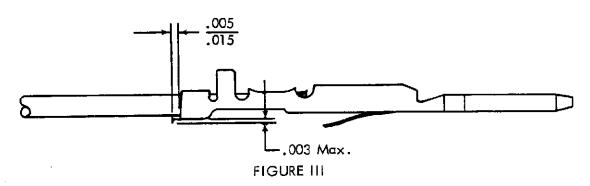
APP Duo-Tyne Leaf Confacts

E.S. 8-10-2

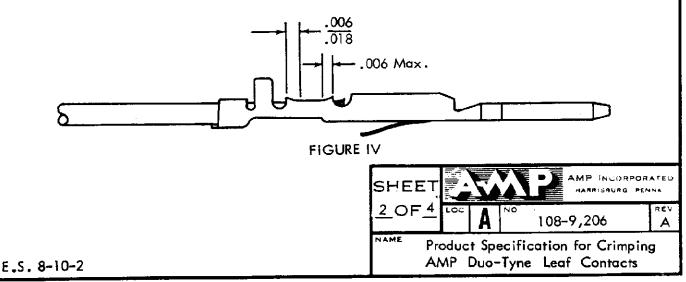
2.2 WIRE PROTRUSION - After crimping, the end of the bare wire shall be located between a point flush with the front end of the wire barrel or extend beyond the front edge of the wire barrel .030. (See Figure II)



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.



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)



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

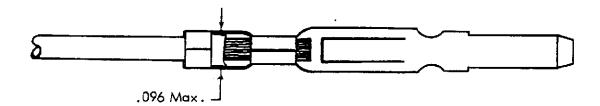


FIGURE V

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.

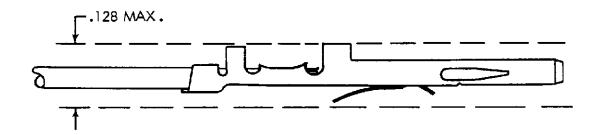


FIGURE VI

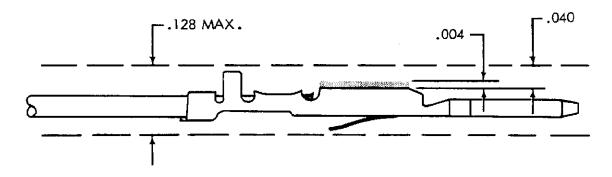
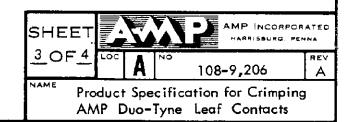


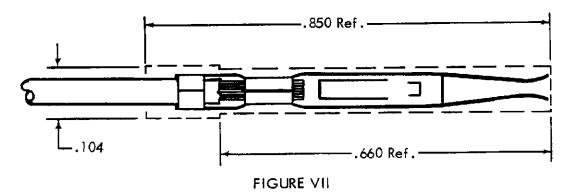
FIGURE VIa



E.S. 8-10-2

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.



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.

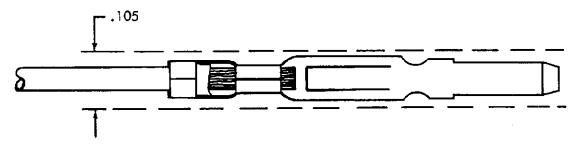
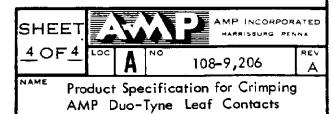


FIGURE VIII

2.8 CRIMP HEIGHTS - Crimped contacts shall be measured for certifying crimp heights in accordance with Table 1.

TABLE I

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



E.S. 8-10-2