

APPLICATION SPECIFICATION

1. SCOPE

This specification covers the requirements for the application of the AMP* VMT (Vertical Multiple Termination) assembly. This assembly consists of the VMT receptacle contact crimped to flexible flat cable with an insulator housing, to mate with an .025 square post either top or bottom entry.

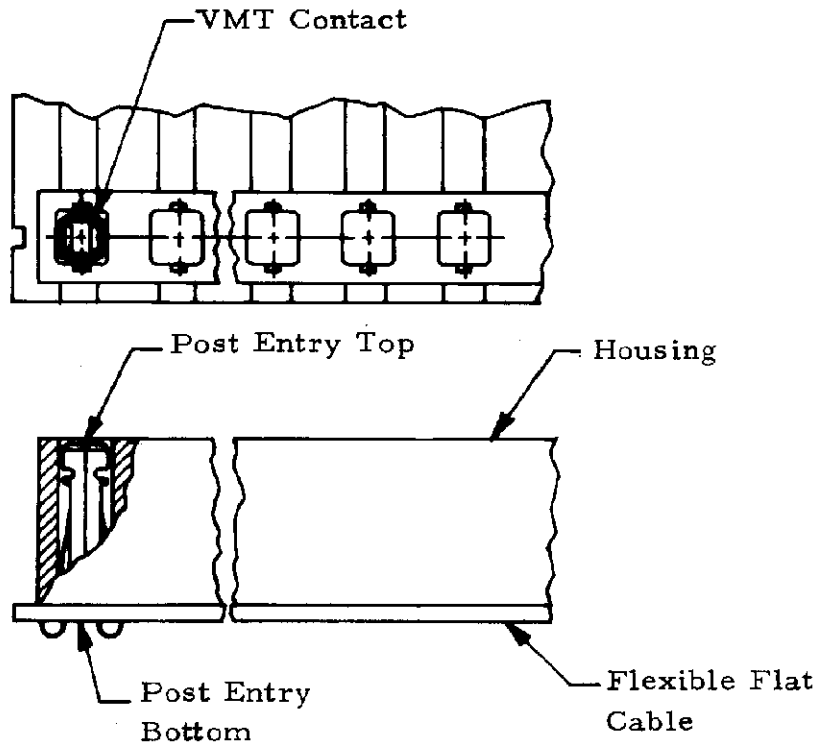
2. APPLICABLE DOCUMENT

The following document forms a part of this specification to the extent indicated herein.

2.1. Commercial Document

IPC-FC-220: Specification for Flat Cable, Flat Conductor, Unshielded

3. NOMENCLATURE



*Trademark of AMP Incorporated.

				DR <i>Mary D English 4-4-84</i>	AMP AMP INCORPORATED Harrisburg, Pa. 17105		
				CHK <i>Robert A McHugh 4/6/84</i>			
				APP <i>Tom Mangan 4-9-84</i>	LOC B	NO 114-16007	REV B
B	Revise per ECN AZ-548	TLC	<i>5/2/85</i>	SHEET 1 OF 6		TITLE CONNECTOR, VMT	
A	Revise per ECN AZ-257	<i>NOE</i>	<i>4/1/84</i>				
LTR	REVISION RECORD	APP	DATE				

©COPYRIGHT 1983 BY AMP INCORPORATED HARRISBURG, PA. ALL INTERNATIONAL RIGHTS RESERVED. AMP PRODUCTS MAY BE COVERED BY U.S. AND FOREIGN PATENTS AND/OR PATENTS PENDING.

4. REQUIREMENTS

4.1. Cable Requirements

A. Dimensional

Flexible flat cable shall meet the requirements of IPC-FC-220, tolerance class IV.

B. Contact is designed to be used on cable which meets the following requirements:

- (1) Conductor size: $.062 \pm .003$ wide x $.0025 - .0035$ thick
- (2) Conductor spacing: $.100$ or greater
- (3) Conductor Spacing tolerance: $\pm .005$ noncumulative
- (4) Cable thickness: $.013$ maximum
- (5) Number of conductors: 35 maximum on $.100$ centerline spacing or 3.60 maximum cable width.
- (6) Materials: Taken from IPC-FC-220, Table 1
 - (a) Type A: Polyester, self-extinguishing, heterogeneous
 - (b) Other Cable

If contact is to be applied to cable other than that listed in Para 4.1.B., contact AMP Engineering.

4.2. Cable Preparation

A. Cable shall be prepared in accordance with Figure 2 for edge mounting contacts.

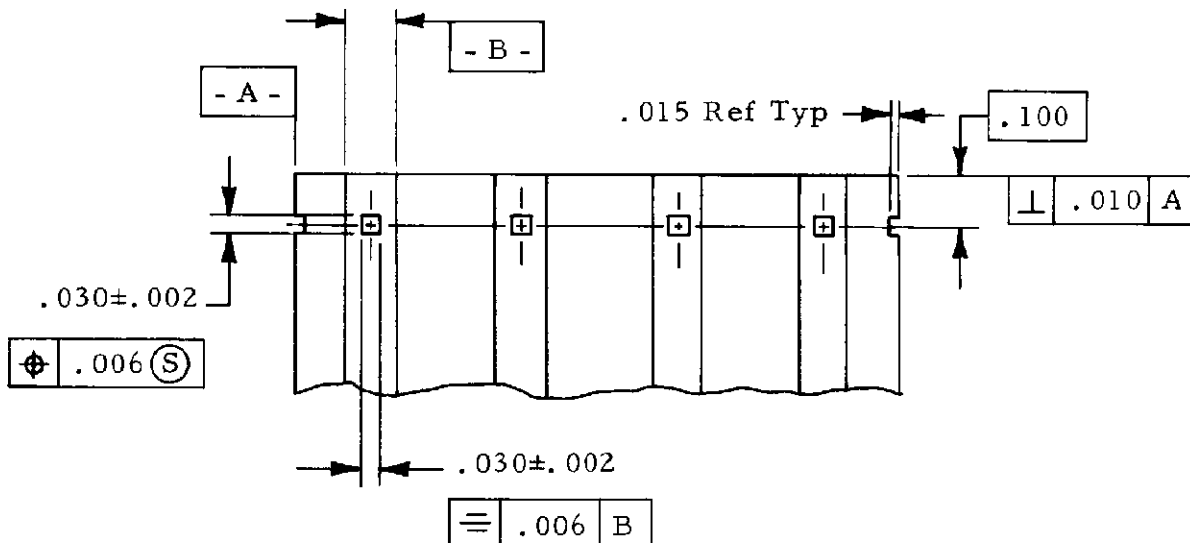


Figure 2

AMP

AMP INCORPORATED
Harrisburg, Pa. 17105

LOC
B

SHEET
2 OF 6

NO
114-16007

REV
B

B. Cable shall be prepared for mounting contacts other than at the edge of the cable in accordance with Figure 3.

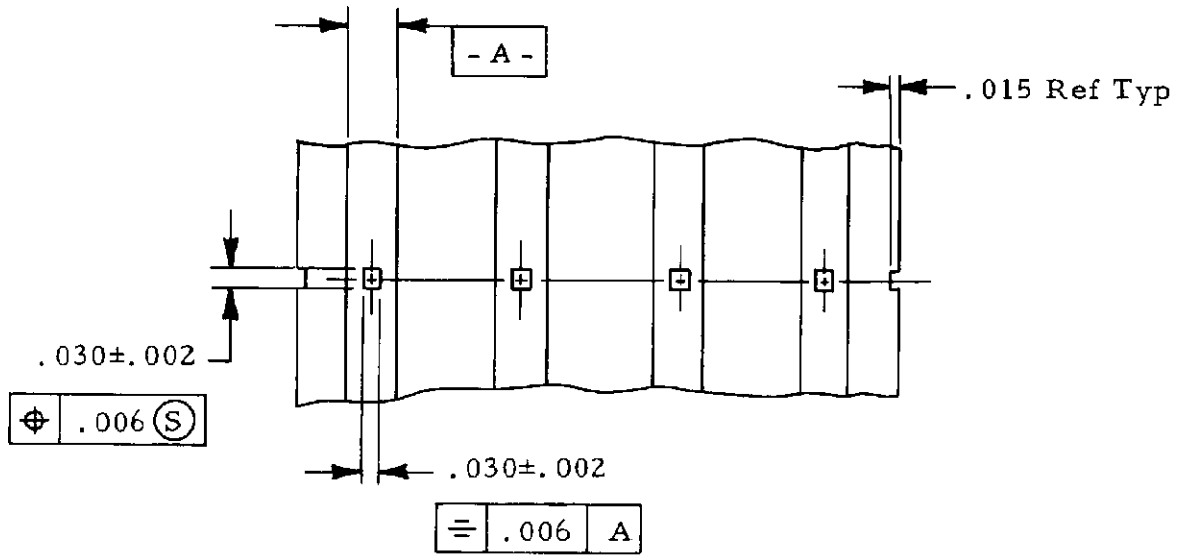


Figure 3

4.3. Contact Application

A. Contacts applied to the cable shall be in accordance with the requirements of Figure 4.

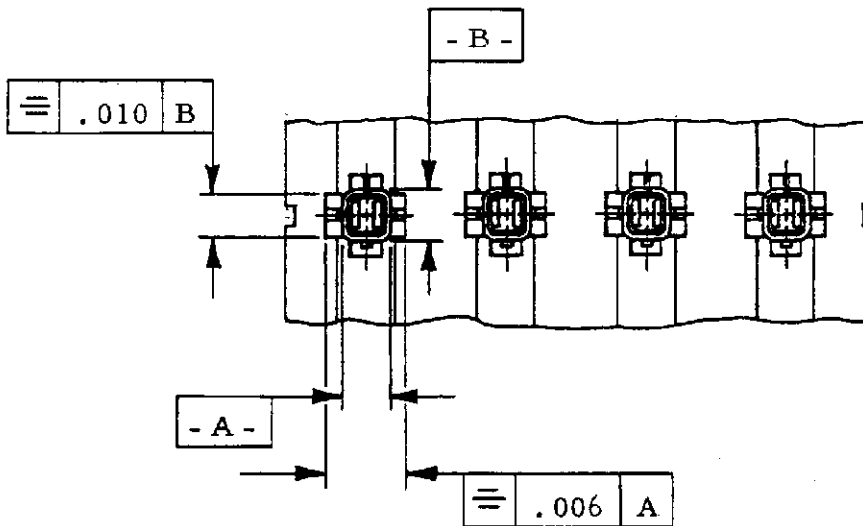


Figure 4

AMP

AMP INCORPORATED
Harrisburg, Pa. 17105

LOC
B

SHEET
3 OF 6

NO
114-16007

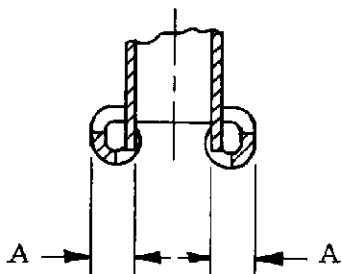
REV
B

4.4. Slivers

Slivers of the copper conductor may occur when the contact barrel is not exactly centered on the conductor. Loose slivers shall be removed to prevent electrical shorts. A recommended procedure after crimping is to remove loose slivers by vacuuming, and visually examine, with unaided eye, the crimped areas to assure that no slivers appear which can cause electrical shorts.

4.5. Crimp Configuration

Tooling alignment shall be checked by crimping a contact without a conductor in place. The crimped contact without conductor shall have a configuration shown in Figure 5.



Note: A-A shall be Symmetrical within .003.

Figure 5

AMP

AMP INCORPORATED
Harrisburg, Pa. 17105

LOC
B

SHEET
4 OF 6

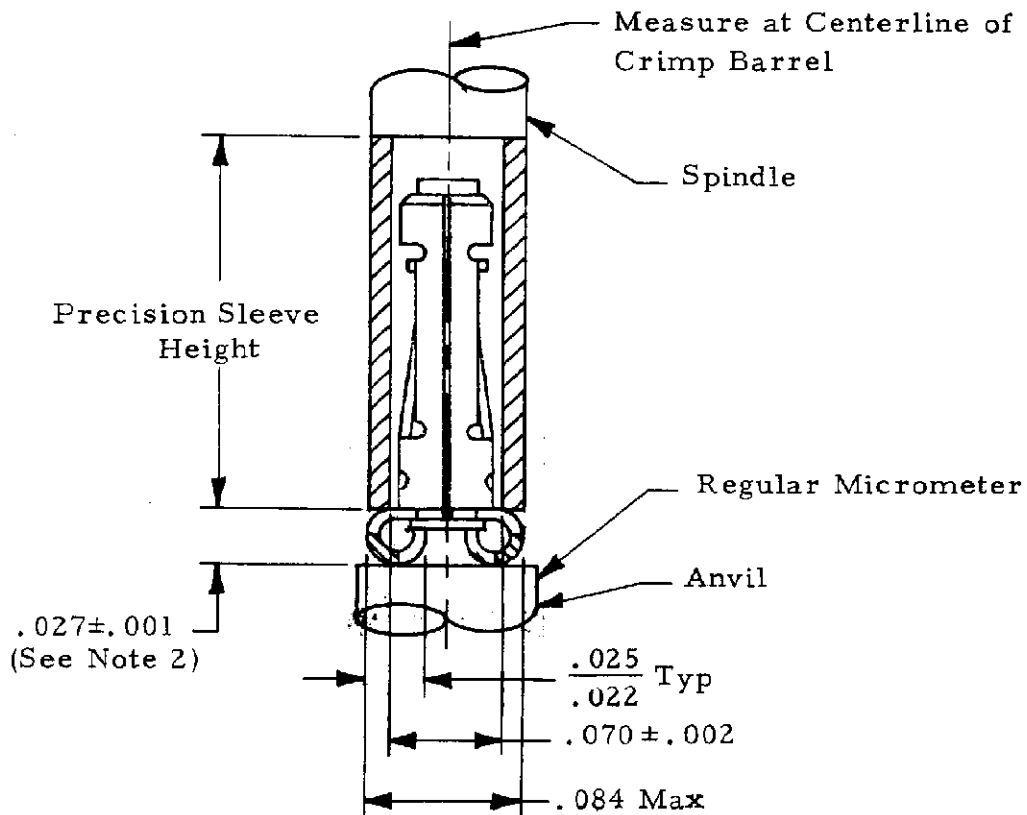
NO
114-16007

REV
B

4.6. Crimp Height and Width

Crimp height and width shall be measured with a properly aligned conductor as shown in Figure 6, after removing all insulation that has extruded outside the crimp. A regular flat micrometer with a precision sleeve as shown in Figure 6, shall be used for crimp height measurements.

- A. Crimp height shall be measured on the centerline of a well centered contact and shall be within limits shown in Figure 6.
- B. Crimp width shall not exceed limits shown in Figure 6 over the entire length of the barrel.



Notes:

- 1. Crimp heights indicated apply only to cable meeting the dimensional requirements of Para 4.1.B.
- 2. Crimp height equals overall measurement minus precision sleeve height.

Figure 6

AMP	AMP INCORPORATED Harrisburg, Pa. 17105	LOC	SHEET	NO	114-16007	REV
		B	5 OF 6			B

4.7. Contact Cutoff Tab and Burr

Length of cutoff tab beyond the end of the contact and amount of burr shall be controlled within the dimensions shown in Figure 7.

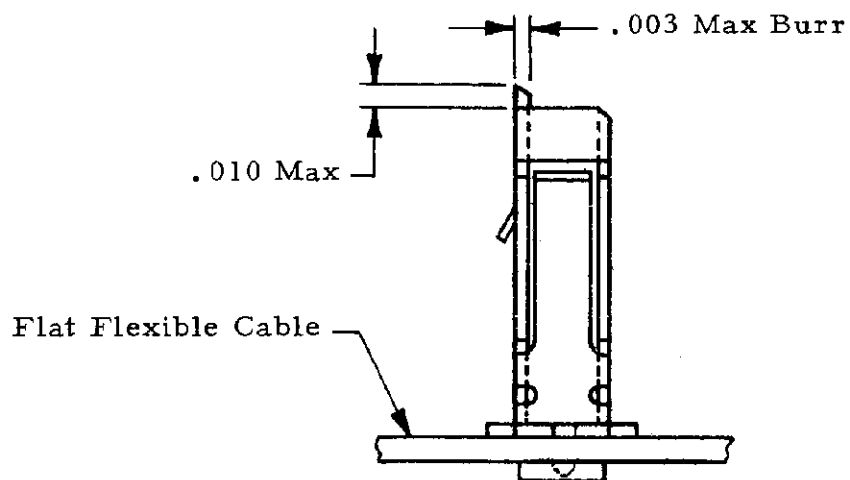


Figure 7

4.8. Workmanship

The crimped contacts and crimp area of the cable shall be carefully examined on both sides to determine that it meets the requirements of this specification. The assembly shall show no signs of cracking or tearing.

AMP

AMP INCORPORATED
Harrisburg, Pa. 17105

LOC

B

SHEET

6 OF 6

NO

114-16007

REV

B