



All numerical values are in metric units [with U.S. customary units in brackets]. Dimensions are in millimeters [and inches]. Unless otherwise specified, dimensions have a tolerance of ± 0.13 [$\pm .005$] and angles have a tolerance of $\pm 2^\circ$. Figures and illustrations are for identification only and are not drawn to scale.

1. INTRODUCTION

This specification covers the requirements for application of CST (Crimp-Snap Terminals) for connectors on 2.54 [.100] centerline. These requirements are applicable to hand or automatic machine crimping tools. These connectors are available in 2 through 28 positions and are terminated to 22, 24, and 26 AWG conductors. The CST-100 connectors provide an interconnection between wires and 0.64 [.025] square post headers mounted on printed circuit (pc) boards.

When corresponding with personnel, use the terminology provided in this specification to facilitate your inquiries for information. Basic terms and features of this product are provided in Figure 1.

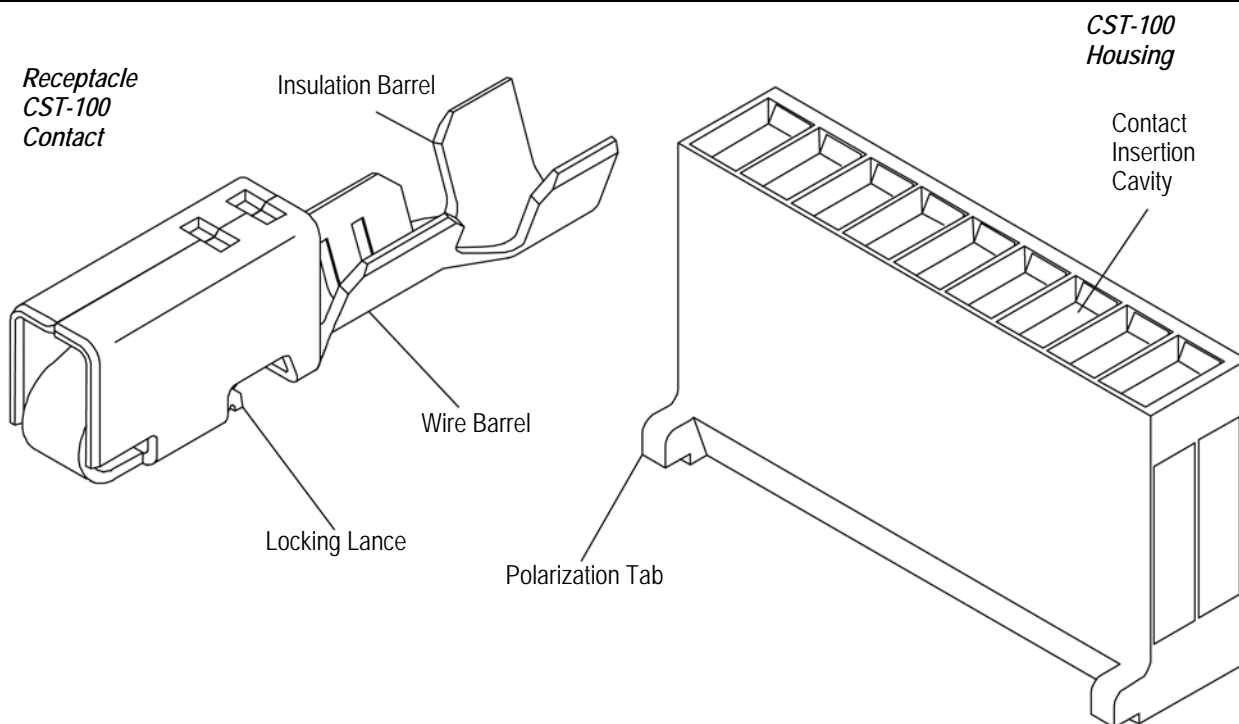


Figure 1

2. REFERENCE MATERIAL

2.1. Revision Summary

Since the previous release, the new company logo was applied.

2.2. Customer Assistance

Reference Part Number 770602 and Product Code 1443 are representative numbers of CST-100 Connectors. Use of these numbers will identify the product line and expedite your inquiries through a service network established to help you obtain product and tooling information. Such information can be obtained through a local representative (field service representative) or, after purchase, by calling the Tooling Assistance Center at the bottom of page 1.

2.3. Drawings

Customer drawings for specific products are available from the service network. The information contained in customer drawings takes priority if there is a conflict with this specification or with any other technical documentation supplied by this company.

2.4. Specifications

Product Specification 108-1328 covers test and performance requirements.

2.5. Instructional Material

The following list includes available instruction sheets (408-series) that provide assembly procedures for product, operation, maintenance and repair of tooling, as well as setup and operation procedures of applicators; and customer manuals (409-series) that provides setup, operation, and maintenance of machines.

- 408-3295 Preparing Reel of Contacts for Application Tooling
- 408-4064 PRO-CRIMPER* III Hand Crimping Tool Assembly 58517-1 with Die Assembly 58517-2
- 408-7424 Checking Terminal Crimp Height or Gaging Die Closure
- 408-8040 Heavy Duty Miniature Quick-Change Applicators (Side-Feed Type)
- 408-8053 Conversion Guide for Miniature Quick-Change Applicators
- 408-9816 Handling of Reeled Products
- 408-9866 Terminal Reel Flange Removal Tool 354030-1
- 408-9930 PRO-CRIMPER III Hand Crimping Tool Frame Assembly 354940-1
- 409-5128 AMP-O-LECTRIC* Model "K" Terminating Machine 565435-5
- 409-5289 AMP Model "T" Terminating Unit 458000-4
- 409-5842 AMP-O-LECTRIC Model "G" Terminating Machine 354500-[]

3. REQUIREMENTS

3.1. Storage

A. Ultraviolet Light

Prolonged exposure to ultraviolet light may deteriorate the chemical composition used in the housing material.

B. Reel Storage

When using reeled contacts, store coil wound reels horizontally and traverse wound reels vertically.

C. Shelf Life

The contacts and housings should remain in the shipping containers until ready for use to prevent deformation to those components. The components should be used on a first in, first out basis to avoid storage contamination that could adversely affect signal transmissions.

D. Chemical Exposure

Do not store contacts near any chemicals listed below as they may cause stress corrosion cracking in the contacts.

Alkalies	Ammonia	Citrates	Phosphates	Citrates	Sulfur Compounds
Amines	Carbonates	Nitrites	Sulfur Nitrites		Tartrates



Where the above environmental conditions exist, phosphor-bronze contacts are recommended instead of brass if available.

3.2. Wire Selection

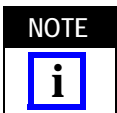
CST-100 Contacts will accept stranded copper wire sizes and insulation diameters as listed in Figure 2. The crimp heights and insulation barrel crimp widths are also provided.



The applied crimp dimension (within the functional range of the product) is dependent on the termination tooling being used. Refer to the AMP documentation (applicator logs and instruction sheets) supplied with the termination tooling for the applied crimp height. See Section 5, TOOLING.



Other contact crimp dimensions are provided on the documentation supplied with the termination tooling.



DO NOT nick, cut, or scrape the wire conductor during the stripping operation.

RECEPTACLE TYPE	WIRE SIZE, (AWG)	INSULATION DIAMETER RANGE	STRIP LENGTH	WIRE BARREL CRIMP		INSULATION BARREL CRIMP WIDTH
				WIDTH	HEIGHT	
	26	0.89-1.65 [.035-.065]	2.54-3.18 [.100-.125]	1.07 [.042]	0.81-0.71 [.032-.028]	1.78 [.070]
	24	0.89-1.65 [.035-.065]	2.54-3.18 [.100-.125]	1.07 [.042]	0.86-0.76 [.034-.030]	1.78 [.070]
	22	0.89-1.65 [.035-.065]	2.54-3.18 [.100-.125]	1.07 [.042]	0.91-0.81 [.036-.032]	1.78 [.070]
	26-22	0.89-1.65 [.035-.065]	2.54-3.18 [.100-.125]	1.07 [.042]	0.84-0.74 [.033-.029]	1.78 [.070]

Figure 2

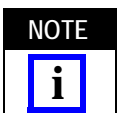
3.3. Crimped Contact Requirements

Locate the contact to be crimped in the appropriate tooling according to the instructions packaged with that tooling. Detailed instructions covering the placement of contacts in the tooling and the use of such tooling is packaged with each tool.

Terminate the contact according to the directions shipped with the appropriate tooling. See Section 5, TOOLING.



Wire insulation shall NOT be cut or broken during the crimping operation, nor shall the insulation be crimped into the contact wire barrel. Reasonable care should be taken by tooling operators to provide undamaged wire terminations.



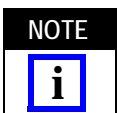
Periodic inspections must be made to ensure crimped contact formation is consistent as shown in Figure 3.

A. Crimp Height

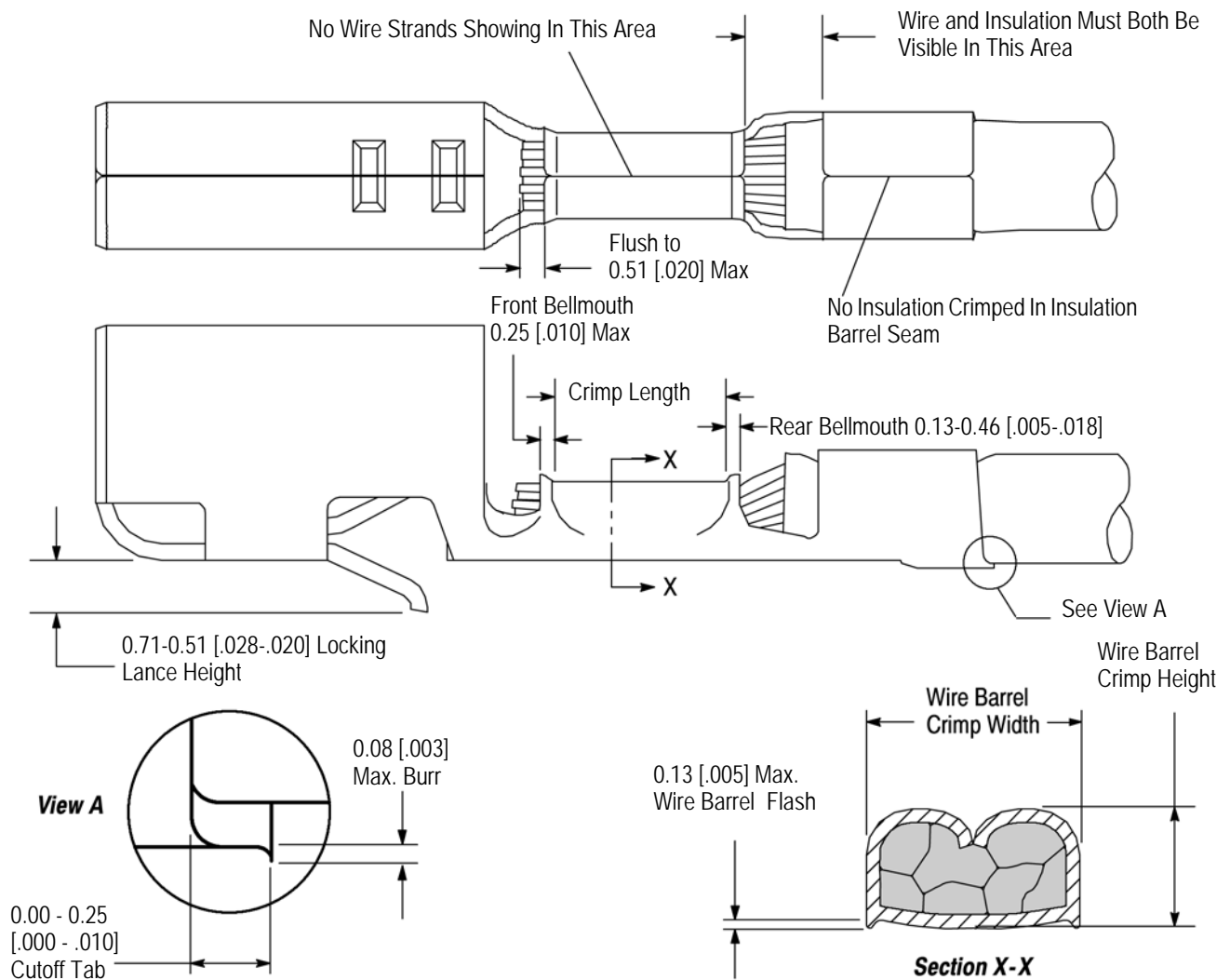
The crimp applied to the wire portion of the contact is the most compressed area and is most critical in ensuring optimum electrical and mechanical performance of the crimped contact. The crimp height must be within the dimensions provided in Figure 3.

B. Crimp Length

For optimum crimp effectiveness, the crimp must be within the area shown and must meet the crimp dimensions provided in Figure 2. Effective crimp length shall be defined as that portion of the wire barrel, excluding bellmouth(s), fully formed by the crimping tool. Instructions for adjusting, repairing, and inspecting tools are packaged with the tools. See Figure 8.



The effective crimp length is given for tooling design only, and should not be used for inspection criteria.



Note: F-Crimp Terminal Shown.

Figure 3

C. Bellmouths

Front and rear bellmouths shall be evident and conform to the dimensions given in Figure 3.

D. Cutoff Tab

The cutoff tab shall be cut to the dimensions shown in Figure 3 in View A.

E. Burrs

The cutoff burr shall not exceed the dimensions shown in Figure 3 in View A.

F. Wire Barrel Flash

The wire barrel flash shall not exceed the dimensions shown in Figure 3 in Section X-X.

G. Wire Location

After crimping, the wire conductor and insulation must be visible in the transition area between the wire and insulation barrels.

H. Conductor Location

The conductor may extend beyond the wire barrel to the maximum shown in Figure 3.

I. Locking Lance

Locking lance height must not change during termination. Refer to specific product customer drawing for exact dimensional requirements.

J. Wire Barrel Seam

The wire barrel seam must be closed with no evidence of loose wire strands visible in the seam.

K. Twist and Roll

There shall be no twist, roll, deformation, or other damage to the mating portion of the crimped contact that will prevent proper mating.

L. Straightness

The force applied during crimping may cause some bending between the crimped wire barrel and the mating portion of the contact. Such deformation is acceptable within the following limits.

- 1) **Up and Down** -- The crimped contact, including cutoff tab and burr, shall not be bent above or below the datum line more than the amount shown in Figure 4.
- 2) **Side to Side** -- The side-to-side bending of the contact may not exceed the limits provided in Figure 4.

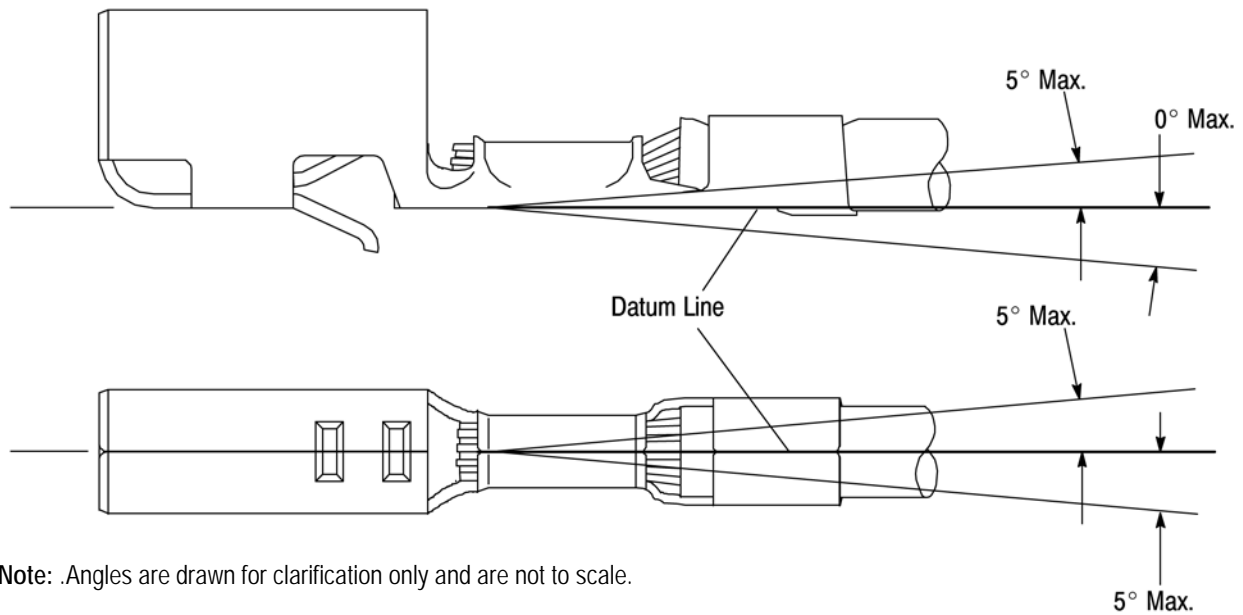


Figure 4

3.4. Housings

CST-100 Housings are available in 2 through 28 positions. They are available in a natural color nylon and consist of a 94V-0 flame retardant material. See Figure 5.

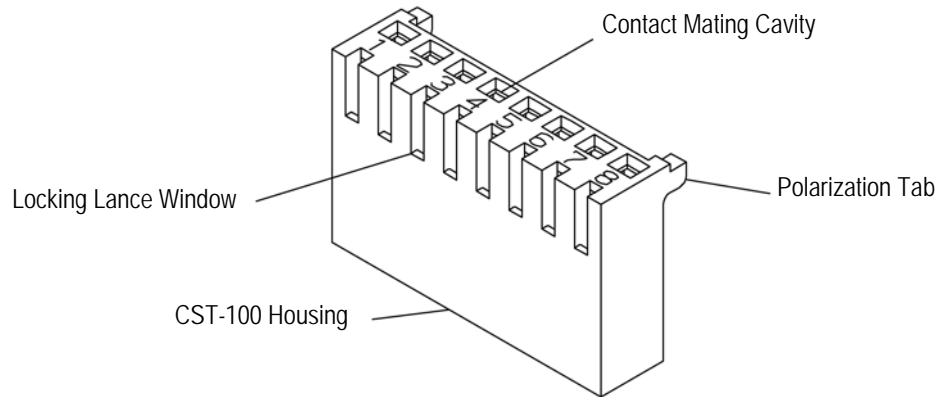


Figure 5

3.5. Contact Insertion

Orient crimped contact so that the locking lance aligns with the housing slots as shown in Figure 6. Insert contact into housing until it bottoms, and a click is heard or felt. Pull back lightly on wire to ensure retention of crimped contact in housing.

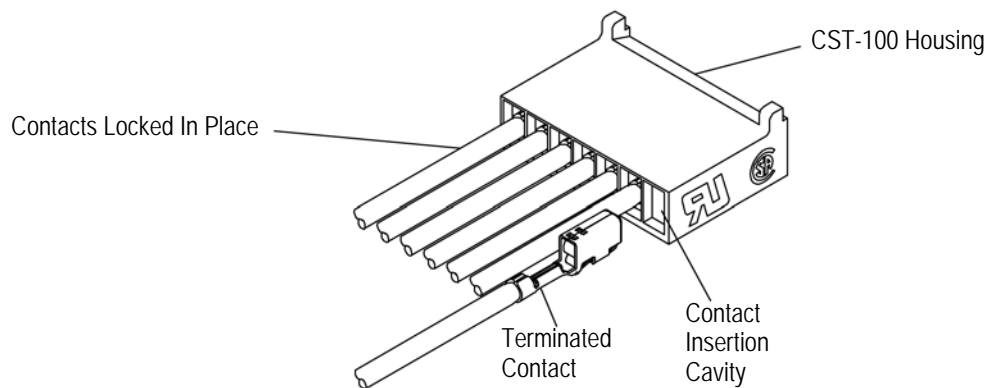
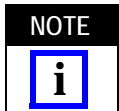


Figure 6

3.6. Repair/Contact Replacement

Use Extraction Tool 91302-1 to remove individual contacts from housings for replacement or for relocation to another housing cavity. See Figure 7. Damaged or worn contacts may be replaced provided there is sufficient slack, after re-stripping the wire, to insert the new contact. Damaged connectors must also be replaced.



NOTE DO NOT re-use damaged or worn contacts. Instead, replace them with new contacts and discard the old ones.

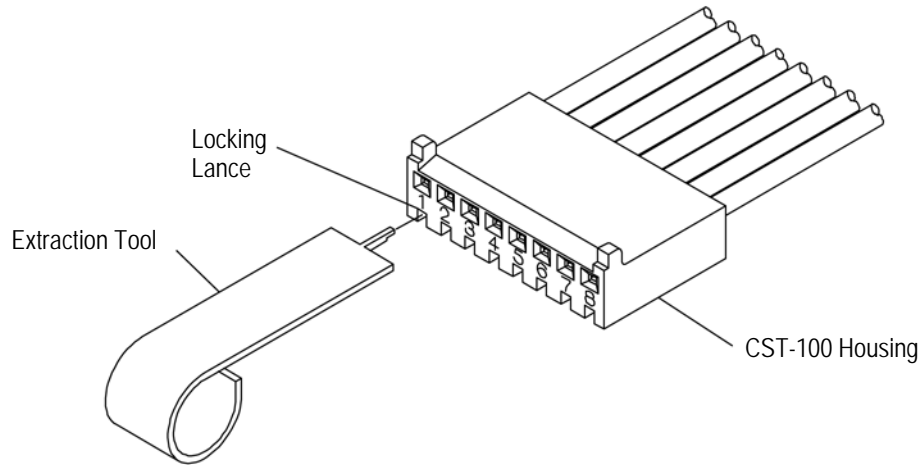


Figure 7

4. QUALIFICATION

CST-100 Connectors are listed by Underwriters Laboratories Inc. (UL) in File Number E28476, and certified by Canadian Standards Association (CSA), in File Number LR7189.

5. TOOLING

This section provides a selection of tools for various application requirements. They include hand tools for manual application of loose piece contacts, and semi-automatic machines for power assisted application of strip form contacts. Modified designs and additional tooling concepts may be available to meet other application requirements. For additional information, contact one of the service groups at the bottom of page 1. A sample of tooling recommendations is provided in Figure 8.

- **Hand Crimping Tools**

Hand crimping tools that accommodate the full wire size range are designed for prototype and low-volume applications such as repair of damaged contacts.

- **Extraction Tools**

Extraction tools are designed to release the contacts inside the connector without damaging the housing or contacts. Refer to Paragraph 3.6.

- **Applicators**

Applicators are designed for the full wire size range of strip-fed, precision formed contacts, and provide for high volume, heavy duty production requirements. The applicators can be used in bench or floor model power units.

NOTE



Each applicator is shipped with a metal identification tag attached. DO NOT remove this tag or disregard the information on it. Also, a packet of associated paperwork is included in each applicator shipment. This information should be read before using the applicator; then it should be stored in a clean, dry area near the applicator for future reference. Some changes may have to be made to the applicators to run in all related power units. Contact the Tooling Assistance Center number at the bottom of page 1 for specific changes.

- **Power Units**

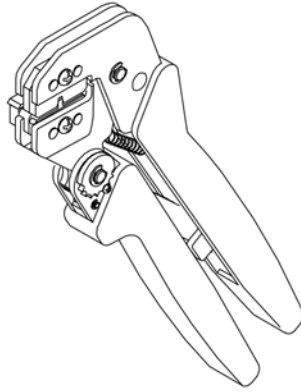
A power unit is an automatic or semi-automatic device used to assist in the application of a product. Power unit includes the power source used to supply the force or power to an applicator.

NOTE

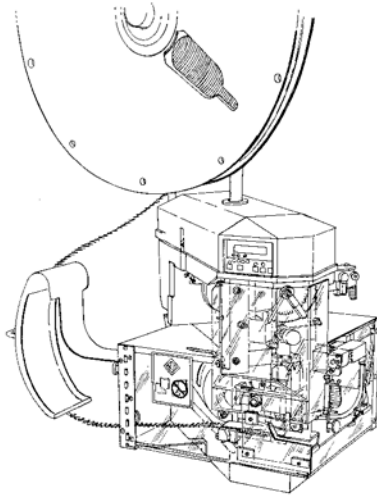
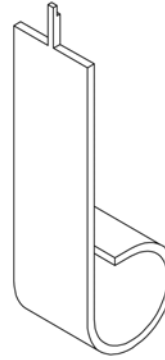


The Model "K" AMP-O-LECTRIC Terminating Machine Part Number 565435-5 (409-5128) has been superseded by the Model "G" Terminating Machine Part Number 354500-1 (409-5842) for new applications. For existing applications, the Model "K" is still recommended because of the large number of installed machines.

Hand Tool Assembly 58517-[]
(408-4064)

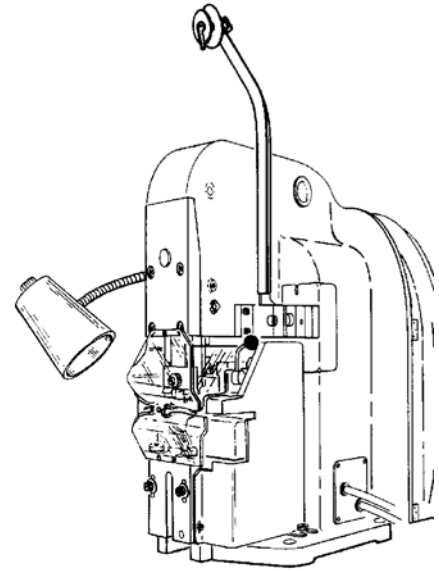
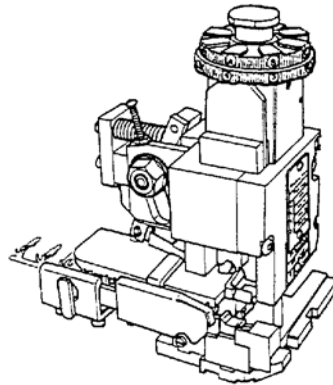


Extraction Tool 91302-1



AMP-O-LECTRIC Model "G"
Terminating Machine
354500-[] (409-5842)

Heavy Duty Miniature
Quick-Change Side Feed
Applicator (Typ)



AMP-O-LECTRIC Model "K"
Terminating Machine
565435-[] (409-5128)

NOTE: Not to scale.

WIRE SIZE (AWG)	INSULATION DIAMETER	APPLICATOR (DOCUMENT)	POWER UNIT (DOCUMENT)	HAND CRIMPING TOOL ASSEMBLY (DOCUMENT)
26-22	0.89-1.65 [.035-.065]	567373-2 (408-8040)	565435-5 (409-5128)	58517-[] (408-4064)
			354500-1 (409-5842)	
		567373-3 (408-8040)	354500-[] (409-5842)	

Figure 8

6. VISUAL AID

The illustration below shows a typical application of CST-100 Connectors. This illustration should be used by production personnel to ensure a correctly applied product. Applications which DO NOT appear correct should be inspected using the information in the preceding pages of this specification and in the instructional material shipped with the product or tooling.

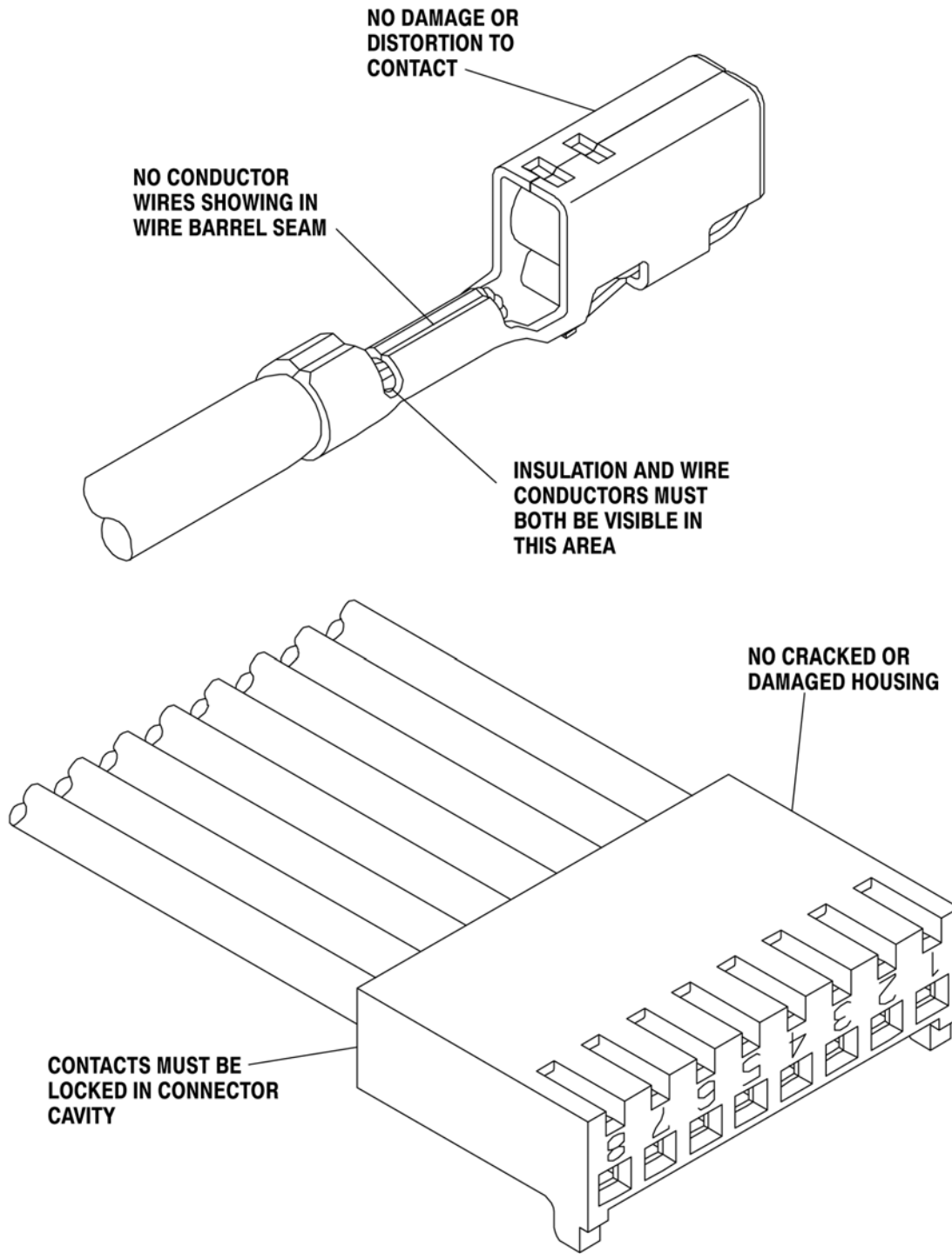


FIGURE 9. VISUAL AID