

APPLICATION SPECIFICATION

1. SCOPE

This specification covers the requirements for application of AMPLIVAR* subminiature pigtail splices. These requirements are applicable to automatic machine crimping tools. For specific CMA (circular mil area) ranges relative to the products covered in this specification, see Figure 4.

2. NOMENCLATURE

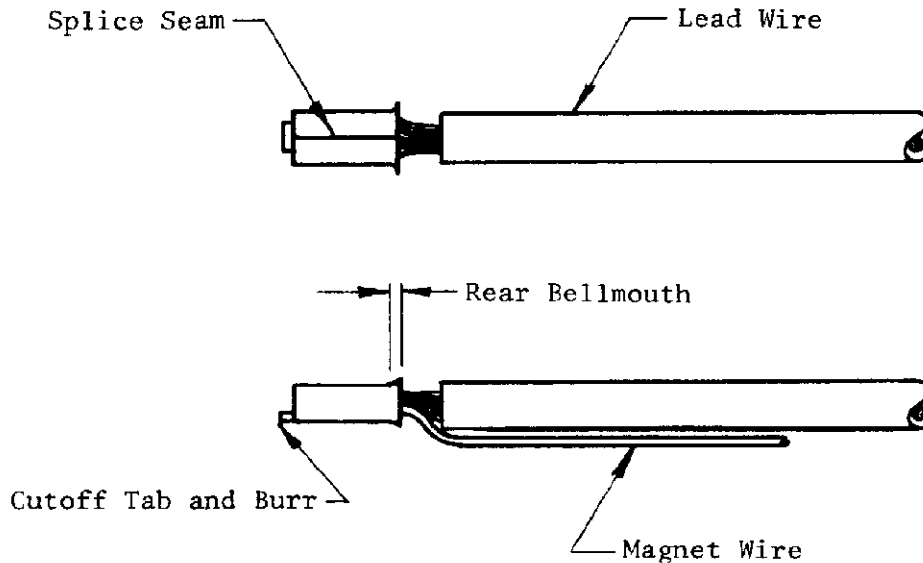


Figure 1

3. CRIMP AND DIMENSIONAL REQUIREMENTS

3.1. Wire Preparation

A. Magnet Wire

No preparation required.

B. Lead Wire

- (1) Insulation shall be stripped as indicated in Figure 4.
- (2) Reasonable care shall be taken not to nick, scrape or cut any strands or the solid wire during the stripping operation.

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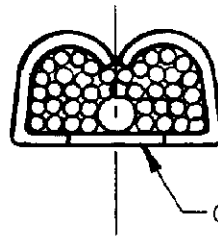
NO 114-2006

				DR <i>C.E. Fint</i> 6/9/75	AMP INCORPORATED Harrisburg, Pa.				
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				APP <i>C.E. Reynolds</i> 6/9/75	LOC B	A	NO 114-2006	REV B	
B	Revise per	<i>AOE</i>	<i>12/1/75</i>	NAME SHEET SPLICE, PIGTAIL, SUBMINIATURE, AMPLIVAR, APPLICATION OF 1 OF 3					
	ECN AF-1480								
A	Revise Figure 3	<i>AOE</i>	<i>4/5/73</i>						
LTR	REVISION RECORD	APP	DATE						

3.2. Carrier Cutoff Tab and Burr

A. Cutoff Tab

- (1) Cutoff tab shall not exceed .010.
- (2) Cutoff tab shall be centered within the limits shown in Figure 2.



Cutoff tab centered with centerline of splice within .015 TIR.

Figure 2

B. Burr

Burr on cutoff shall not exceed .008.

3.3. Splice Crimp

A. Crimp Dimensions

- (1) Crimp width shall be as shown in Figure 4.
- (2) Consult AMP Engineering for specific crimp heights. Crimp heights specified by AMP Engineering shall be measured at the location shown in Figure 3, with a tolerance of $\pm .002$ unless otherwise specified.

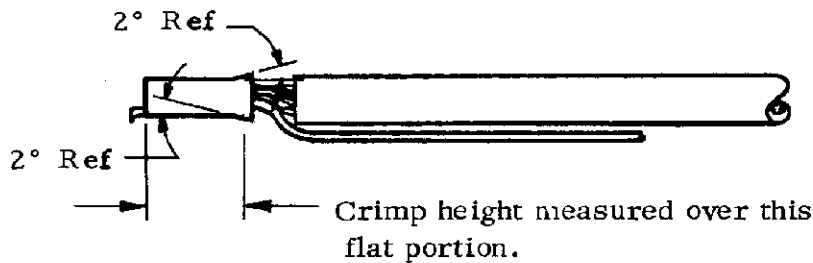


Figure 3

B. Tensile Strength

Crimp tensile strength shall be 70% of the wire tensile strength.

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C. Splice Seam

Splice seam shall be completely closed and there shall be no evidence of loose wire strands or wire strands visible in the seam.

D. Bellmouth


Rear bellmouth permissible.

E. Conductor Location

- (1) Wires shall extend thru the splice before crimping.
- (2) Wire shall be cut off clean at the front end of the splice after crimping
- (3) Conductors shall be visible between the lead wire insulation and the rear of the splice.
- (4) Magnet wire(s) shall lie in the bottom of the splice.

Part Number	Wire CMA	Lead Wire Strip Length	Splice Crimp	
			Width	Type
62194	400-1600	.150 ± .031	.070	F

Figure 4

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