

APPLICATION SPECIFICATION

1. SCOPE

This specification covers the requirements for application of AMPLIVAR* bobbin tabs to bobbin cavities. These requirements are applicable to automatic machine crimping tools. For specific magnet wire ranges relative to the products covered in this specification, see Figure 5.

2. NOMENCLATURE

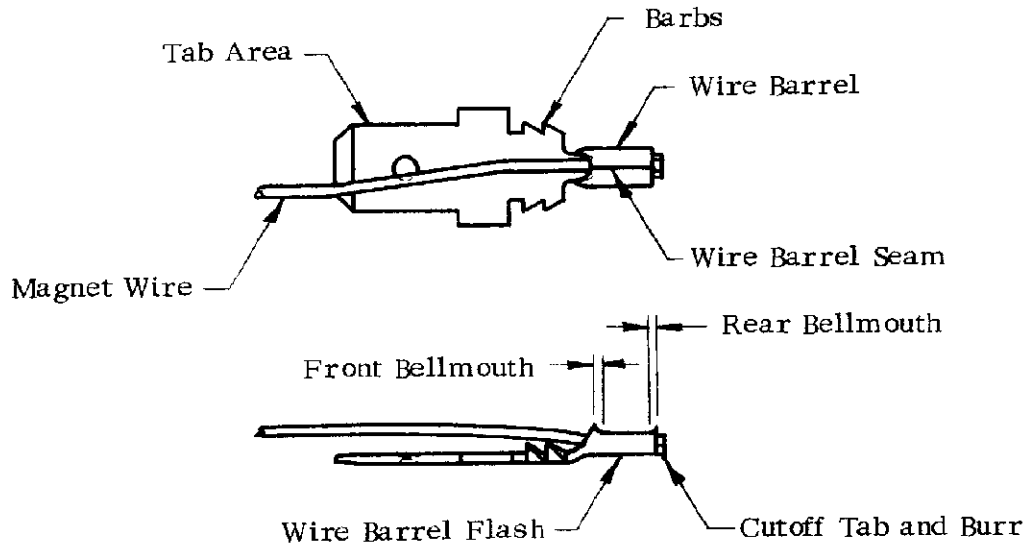


Figure 1
Bobbin Tab

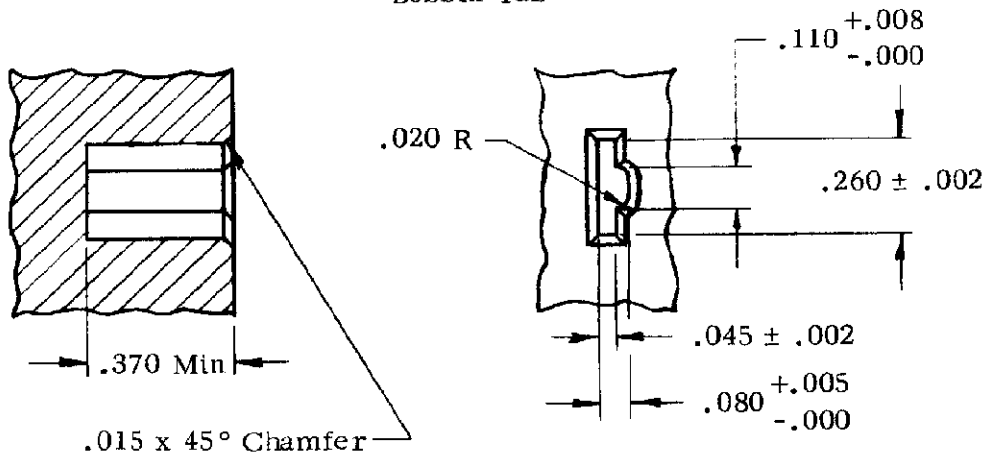


Figure 2
Bobbin Cavity

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NO 114-2018

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DIST 2	LTR REVISION RECORD	APP	DATE				

3. CRIMP AND DIMENSIONAL REQUIREMENTS

3.1. Wire Preparation

A. Magnet Wire

No preparation required.

B. Workmanship

Reasonable care shall be taken not to nick, scrape or break magnet wire.

3.2. Cutoff Tab and Burr

A. Cutoff Tab

Cutoff tab shall not exceed .006.

B. Burr

Burr on cutoff shall not exceed .005.

3.3. Wire Barrel Crimp

A. Crimp Dimensions and Type

(1) Crimp height, width and type shall be shown in Figure 5.

(2) Crimp heights shall be measured at the location shown in Figure 3.

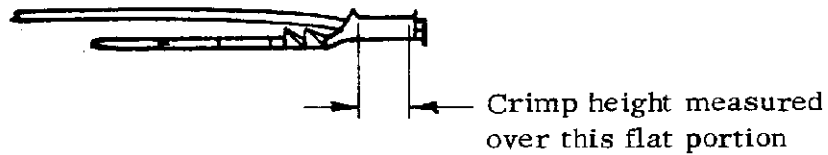



Figure 3

B. Tensile Strength

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

C. Wire Barrel Flash

Wire barrel flash shall not exceed the limits shown in Figure 4.

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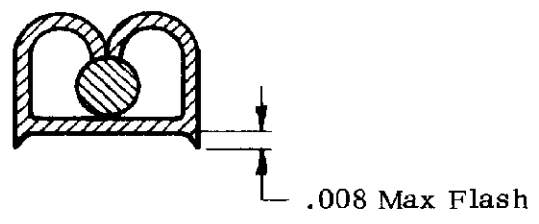


Figure 4

D. Wire Barrel Seam

Wire barrel seam shall be completely closed.

E. Bellmouth

Bellmouth required on both front and rear end of wire barrel.

F. Conductor Location

- (1) Magnet wire shall lie across the tab area as shown in Figure 1 and extend thru the wire barrel before crimping.
- (2) Wires shall be cut off clean at the rear end of the wire barrel after crimping.

Part No	Magnet Wire		Wire Barrel Crimp		
	Size, AWG	CMA, Ref	Width	Height ±.001	Type
61598 62017	23	566	.100	.060	"F" or "O"
	24	455			
	25	361			
	26	289			
	27	231			
	28	185		.058	
	29	144			
	30	112			
	31	85			
	32	71			

Figure 5

Automatic Machine Wire Crimp Dimensions

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