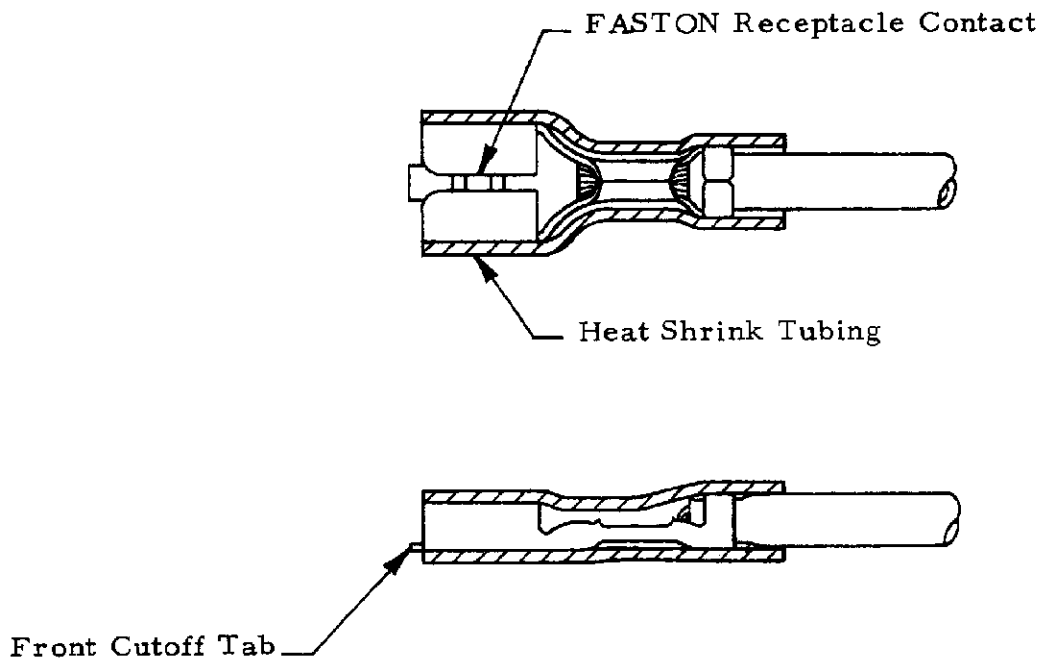


APPLICATION SPECIFICATION

1. SCOPE

This specification covers the requirements for application of AMP* HST (Heat Shrink Tubing) to FASTON* receptacle contacts. For specific part numbers relative to the products covered in this specification see Figure 5.

2. NOMENCLATURE



3. REQUIREMENTS

3.1. Contact

Receptacle contacts shall be product which has been applied in accordance with AMP Specification 114-2036.

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				DR <i>W. E. Felt</i> 2/24/82	AMP AMP INCORPORATED Harrisburg, Pa.				
				CHK <i>RW Prescott</i> 7/24/82					
				APP <i>SR Deane</i> 2/24/82	LOC B	NO A	114-31000		REV 0
				SHEET 1 OF 3	HEAT SHRINK TUBING, APPLICATION OF				
DIST 31	LTR	REVISION RECORD	APP	DATE					

3.2. Assembly

- A. Heat shrink tubing specified in Figure 5 shall be placed over the receptacle contact as indicated in Figure 2.

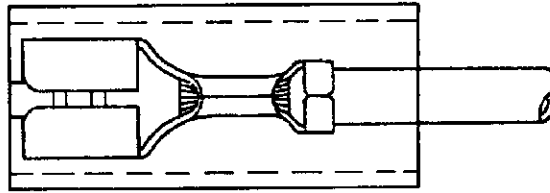
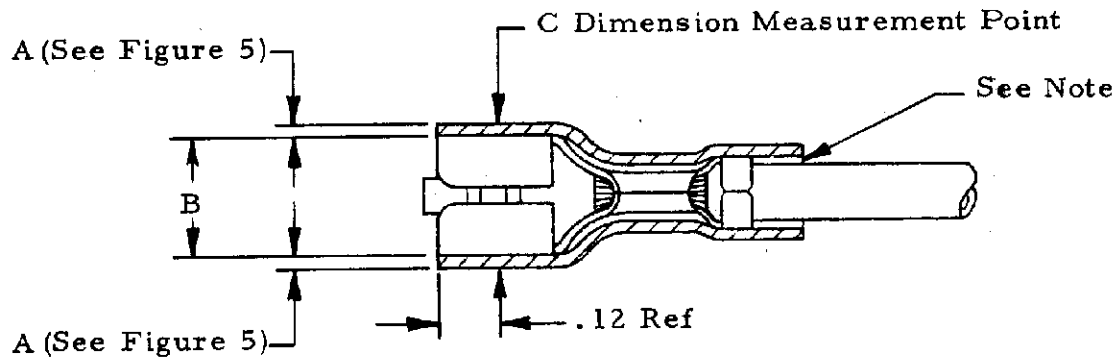


Figure 2.

- B. Heat shrink tubing shall be shrunk onto the receptacle contact using appropriate heat shrink equipment.
- C. Tubing shall conform to the shape of the receptacle contact, as closely as possible, after shrinking and meet the requirements of Figure 3.



Where:

- A = Heat shrink tubing wall thickness, fully recovered over receptacle contact
- B = Actual measured width of receptacle
- C_m = Actual measured value
- $C_c = 2A + B$

and: $C_m \leq C_c$

Note: Heat shrink tubing might not contact wire insulation on small wire although tubing is fully recovered.

Figure 3

AMP		AMP INCORPORATED Harrisburg, Pa.		SHEET	
				2 OF 3	
LOC B	NO A	NO 114-31000	REV 0		
NAME HEAT SHRINK TUBING, APPLICATION OF					

D. Heat shrink tubing shall be flush with front of contact within the limits shown in Figure 4.

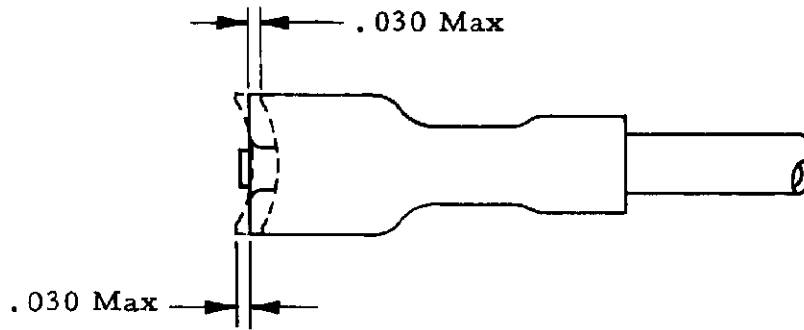


Figure 4

3.3. Workmanship

There shall be no cracks, splits or material degradation after shrinking that will impair usage of the completed assembly.

Part Number		Contact Tab Size, ref	Expanded Tubing Size, ref		A (See Figure 3)
Tubing	Contact		Inside Diameter	Length	
1-938016-9	42660	.250	.250	1.00	.016
	42400	.250	.250	1.00	.016
		.205	.250	1.00	.024
1-938015-9	42452	.187	.187	.88	.024
	60742	.187	.187	.88	.024
1-938014-3		.110	.125	.88	.016

Figure 5
Part Numbers

SHEET 3 OF 3	AMP		AMP INCORPORATED Harrisburg, Pa.	
	LOC B	A	NO 114-31000	REV 0

NAME

HEAT SHRINK TUBING,
APPLICATION OF