

114 - 5003

Application Specification

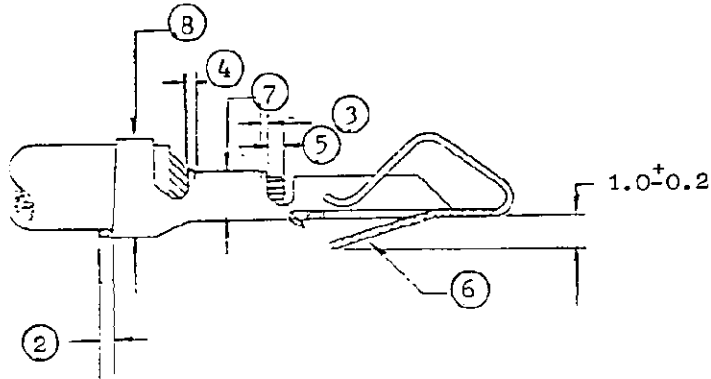
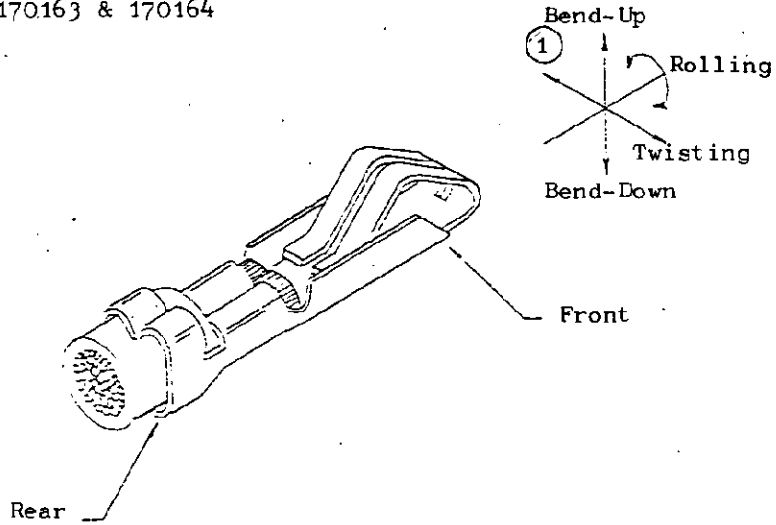
Crimping of AMP-UNYT* Contact for 13-Position, REP Connector

1. Scope:

This specification covers the requirements for crimping of AMP-UNYT* 13-Position, REP Connector (P/N 171372.)

2. Applicable Contacts:

Part Nos. 170163 & 170164



Cross-sectional View of Front Frictional Contact Area

Fig. 1

PRINT	DST.	B	Revised	FJ00-0643-9	S.M.	5-24	1994	APP.	DR.	SHEET	1	OF	3	AMP			REV.
														AMP (Japan), Ltd. Kawasaki, Japan			
LTR	REVISION RECORD	DR	CHK	DATE	29 MAY 1994			CHK.	LOC	J	A	NO.	114 - 5003				
NAME										Application Specification							
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NUMER:

Customer Release

SECURITY CLASSIFICATION:

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- 3.1 After crimping, the contact shall be conforming to the following requirements, when evaluated from the datum line at rear bottom surface of the front side. (Fig. 1 (1))
- 3.1.1 Bending Down: 5° max. (Fig. 2)
 - 3.1.2 Bending-Up 3° max. (Fig. 2)
 - 3.1.3 Twisting 5° max. (Fig. 3)
 - 3.1.4 Rolling 5° max. (Fig. 4)
- 3.2 The length of cut-off tab shall be 0.5mm max.
- 3.3 Front bellmouth of wire barrel (Fig. 1 (3))
- 3.4 Rear bellmouth of wire barrel to be within the range of 0.2 - 0.7mm. (Fig. 1 (4))
- 3.5 Wire end protrusion length beyond the wire barrel front edge shall be 1.0mm max. (Fig. 1 (5))
- 3.6 Locking lance height shall be within the range of 1.0⁺0.2mm. (Fig. 1 (6))
- 3.7 Crimp Data:
- Crimp data are shown below. The tolerance of applicator crimp height shall be within $\pm 0.05\text{mm}$ ($\pm .002$). The crimp height control of the applicable hand application tooling shall be performed by using the gage specified below.

Contact Part No.	Applicable Wires	Wire Size (mm ²)	Wire Crimp			Insulation Crimp		Crimp Tensile Strength (kg)(min.)	Applicator Number
			Width	Height	DISC Ltr.	Width	Height		
170163	JIS C 3406 (For Auto-motive Use)	0.5	(.090)	(.046) 1.17mm	D	(.130)	3.1mm (max.)	6.0	721372-1
		0.85	2.29mm "F"	(.050) 1.27mm	C			9.0	
		1.25		(.056) 1.42mm	B	3.30 mm "F"	13.0	721372-2	
		2.0		(.068) 1.73mm	A		20.0		

Contact Part No.	Applicable Wires	Wire Size (mm ²)	Wire Crimp			Insulation Crimp		Crimp Tensile Strength (kg)(min.)	Hand Tool Number
			Gage No.	Height (Ref.)	Crimp Symbol	Gage No.	Height (Ref.)		
170164	JIS C 3406 (For Auto-motive Use)	0.5	289901	1.24	A	289901	2.20	6.0	722935-1
		0.85	-269			-271		9.0	
		1.25	289901	1.60	B	289901	2.70	13.0	
		2.0	-270			-272		20.0	

- 3.8 A slight gap may appear when using on 2.0mm² wire size. However, this will result no problem without allowing wire conductor loose out.
- 3.9 The test specimens to be used by this specification, shall be prepared by using the specified applicator or hand application tooling.

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Bend-Down: 5° max.
 Bend-Up: 3° max.

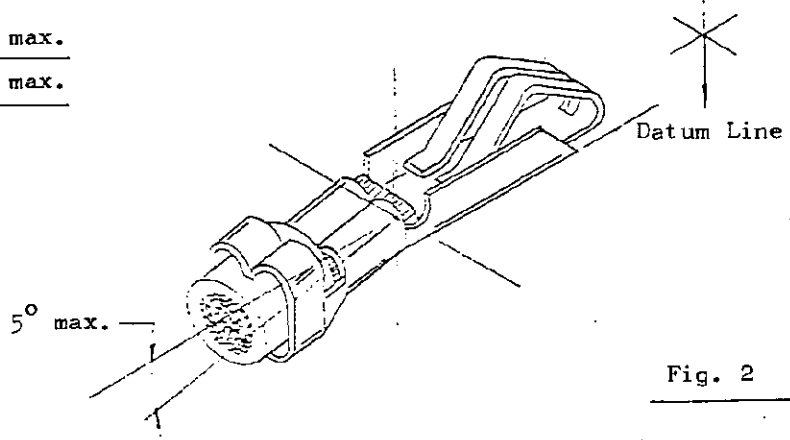


Fig. 2

Twisting:

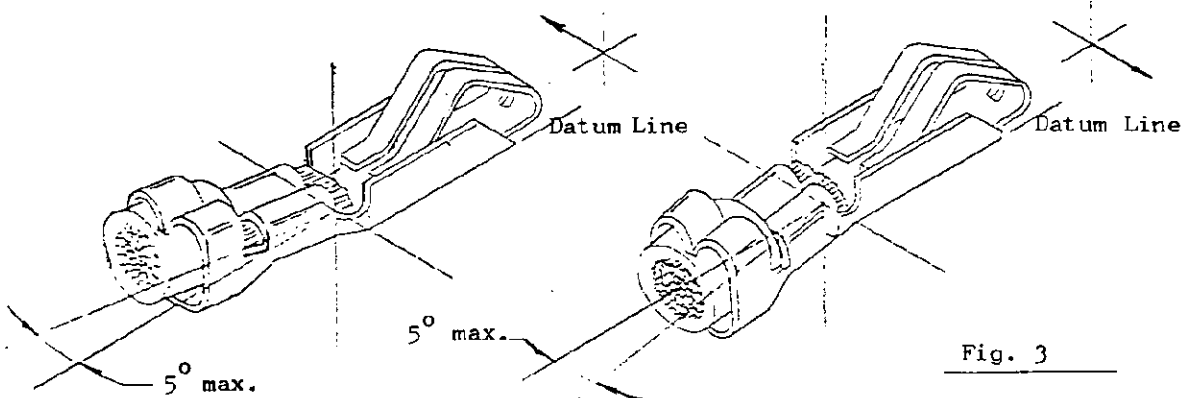


Fig. 3

Rolling:

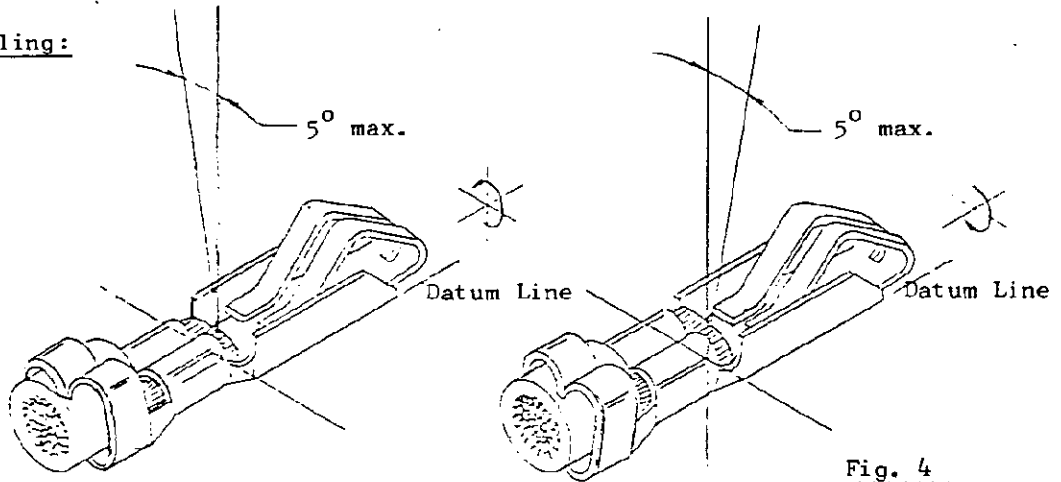


Fig. 4

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