

NUMBER 114-5014

Customer Release

AMP SECURITY CLASSIFICATION

114-5014

Application Specification

Crimping of Miniature AMP-IN* Terminals

1. Scope:

This specification covers requirements for crimping of Miniature AMP-IN* Terminals.

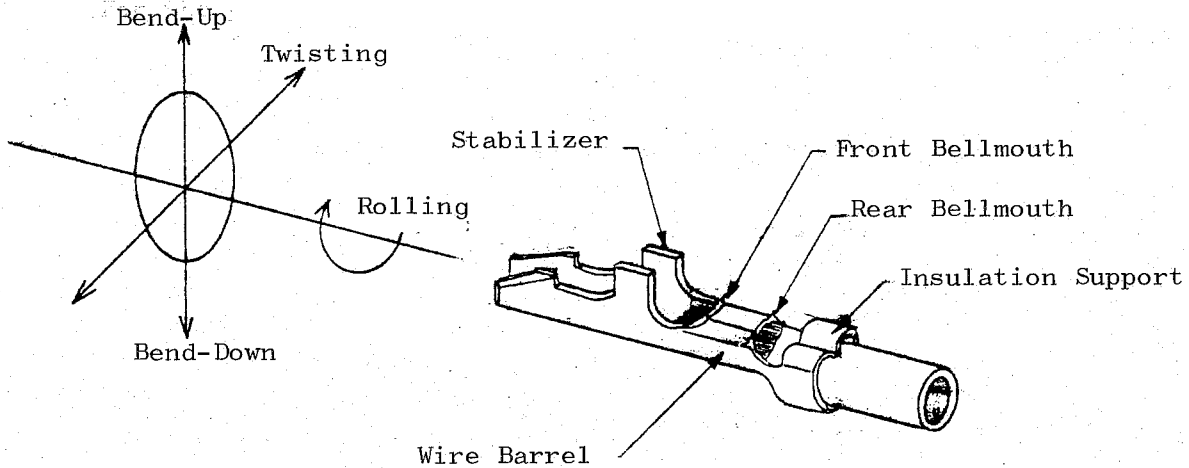
2. Applicable Terminal Part Numbers and Wire Sizes:

The products of the following part numbers in the specified application shall be governed under this specification.

Part Number	Wire Size	Insulation Diameter
170197-1	0.2 - 0.56 mm ² (#24-#20 AWG)	1.6 - 2.3 mm
170198-1	0.05 - 0.15 mm (#30-#26 AWG)	0.66 - 1.22 mm

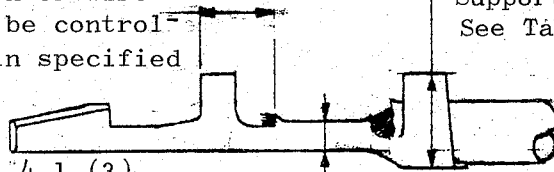
3. Terms:

For the purpose of this specification, the following terms shall apply.



Protrusion of wire end must be controlled within specified range. See Para. 4.1.(3)

Crimping of Insulation Support Barrel See Table 2.



Wire Crimp Height Refer to Table 2.

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				APP <i>[Signature]</i> 5-26-81	LOC J A	NO 114-5014			
O1	Revised RFA-1814	<i>[Signature]</i>	<i>[Signature]</i>	SHEET 1 OF 2		NAME Application Specification			
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LTR	REVISION RECORD	DR	CHK	DATE					

4. Crimping Requirements:

4.1 Application and Deformation Allowance after Crimping:

4.1.1 Insulation Stripping Length: 4.0 ± 0.5 mm

4.1.2 Allowable Limit of Deformation after Crimping:

Bend-Up and Bend-Down: 10° Max.

Rolling and Twisting: 8° Max.

4.1.3 Wire End Protrusion Length:

Wire end must be protruding beyond front edge of wire barrel, but it must not extend over stabilizers. (Fig. 1)

4.1.4 Bellmouth:

Front and rear bellmouths must be crimped to form a uniform crescent evenly in an approximately same size.

4.2 Crimp Data:

Terminal Number	Applicator Number	Wire Size		Wire Barrel Crimp		Insulation Barrel Crimp	Crimp (kg) Tensile (Min.)
		mm ²	(AWG)	Width	Crimp Height		
170197-1	721374-2	0.2	(#24)	1.4 "F" (.055")	0.97	3.05 "F" (.12")	3.0
		0.3	(#22)		1.04		4.5
		0.5	(#20)		1.14		7.5
170198-1	721375-2	0.05	(#30)	1.07 "F" (.042)	0.81	1.78 "F" (.07")	0.55
		0.08	(#28)		0.81		0.7
		0.13	(#26)		0.86		2.0


4.3 General Requirements:

4.3.1 Care must be taken not to nick, scrape, damage and cut the wire strands when stripping the wire insulation. Strands must be neatly arranged.

4.3.2 Wire strands must be all captured within wire barrel, and no wire strands must not loose out from between the wire barrel seam.

4.3.3 Any part of wire insulation must not be crimped within wire barrel.

4.3.4 After crimping, insulation support crimping barrel must be gripping the wire tightly without resulting damage of insulation.

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