

114 - 5024

Application Specification

Crimping of MATE-N-LOK* Pin Contact

1. Scope:

This specification covers the requirements for crimping of dual lanced, MATE-N-LOK* Pin Contact by applicator tooling.

2. Applicable Part Number:

Product Part No. 170218-1 (MATE-N-LOK* Pin Contacts)

3. Nomenclature:

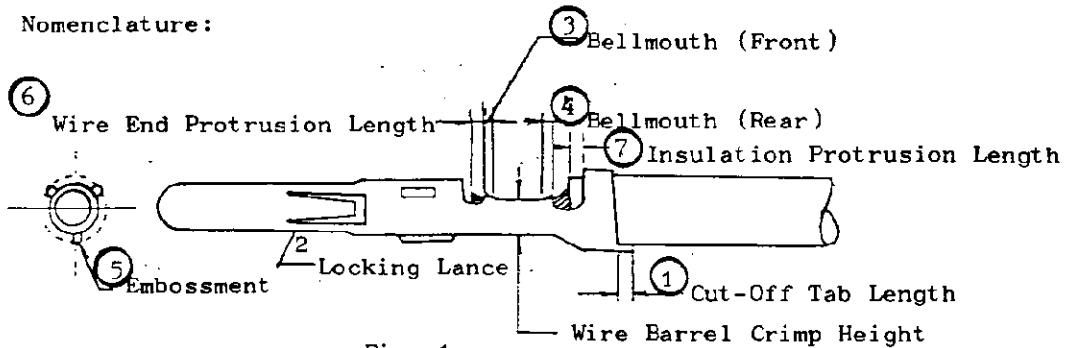


Fig. 1

4. Crimp Data and Crimping Requirements:

4.1 Crimp Data:

Contact Part No.	Wire Size (mm ²) (AWG)	Applicator Number	Wire Barrel Crimp				Insulation Barrel Crimp	
			Width (mm)	Type	Crimp Height ± 0.05mm	Disc Ltr.	Width (mm)	Type
170218-1	0.5 (#20)	722707-2	2.28	F	1.19	D	3.30	F
	0.75 (#18)				1.32	C		
	1.25 (#16)				1.50	B		
	2.0 (#14)				1.75	A		

4.2 Crimp Tensile Strength:

After crimping, wire barrel crimp shall have tensile strength greater than the value specified in the following.

Wire Size (mm ²) (AWG)	Crimp Tensile Strength(kg)
0.5 (#20)	7.0 min.
0.75 (#18)	9.0 "
1.25 (#16)	12.0 "
2.0 (#14)	16.0 "

DR. *[Signature]*
 CHK. *[Signature]* 5/13/94
 APP. *[Signature]*

SHEET 1 OF 2

AMP
 AMP (Japan), Ltd.
 Kawasaki, Japan

LOC J A NO. 114 - 5024 REV. 0

NAME Crimp of MATE-N-LOK* Pin Contact

SECURITY CLASSIFICATION: Customer Release NUMBER: 114 - 5024

PRINT	0	Released RFA-278	USA	5/23/94
LTR		REVISION RECORD	DR	CHK

114 - 5024

NUMBER:

Customer Release

SECURITY CLASSIFICATION:

4.3 Applicable Wires:

Wire Size (Nominal) mm ² (AWG)	Number of Dia- Conduc- tors of a Con- ductor (mm)	Calculated Cross-sectional Area (mm ²)	Finished Insulation Diameter (mm)	Applicable Wire Specification	Remarks
0.5 (#20)	20 / 0.18	0.51	2.6		
0.75 (#18)	30 / 0.18	0.76	2.8		VSF
			3.8 (Note)		/- Conductor Ribbon
1.25 (#16)	50 / 0.18	1.27	3.1		
2.0 (#14)	37 / 0.26	1.96	3.4 (Note)		VSF
			4.0 (Note)		/- Conductor Ribbon

(Note) When crimping the wires marked (Note) in the listing above, slight cut-in of insulation barrel into the wire insulation is permissible.

4.4 Crimping Requirements:

Wire pre-treatment and crimped contact shall be conforming to the requirements specified below.

No.	Check Items	Place	Crimping Requirements	Remarks
1	Insulation Stripping Length	For one-wire Crimp	3.5 - 4.5mm	
2	Allowable Deformation after Crimping	Bending	Up	4° max.
			Down	4° max.
		Twisting	5° max.	
3	Cut-Off Tab Length		0.4mm max.	Fig. 1 (1)
4	Locking Lance		No deformation allowed	Fig. 1 (2)
5	Length of Bellmouths	Front Bellmouth		Fig. 1 (3)
		Rear Bellmouth	0.2mm min.	Fig. 1 (4)
6	Flare out of Embossment Diameter		Must pass through, 2.87mm dia. check hole after crimping.	Fig. 1 (5)
7	Wire-End Protrusion Length	Measure from front edge of wire barrel.	0.5 - 1.0mm	Fig. 1 (6)
8	Wire-End Protrusion Length	Measure from front edge of insulation barrel.	1.0 Approx.	Fig. 1 (7)