

114-5124

NUMBER:

Customer Release

SECURITY CLASSIFICATION:

# Application Specification

114-5124

## Termination of AMPLIMITE .050 Series II Connectors

1. Scope :

This specification covers the requirements for termination of AMPLIMITE .050 Series II Connectors. (The part numbers of the applicable products are shown in Fig. 9)

This specification is applicable to the termination of both hand tool and automatic terminating machine applications. The part numbers of the tooling are also shown in Fig.

The wires to be used for termination shall be conforming to the requirements specified in Para. 3.

2. Nomenclature of the Products :

2.1 Type A : Cap Connector Kit

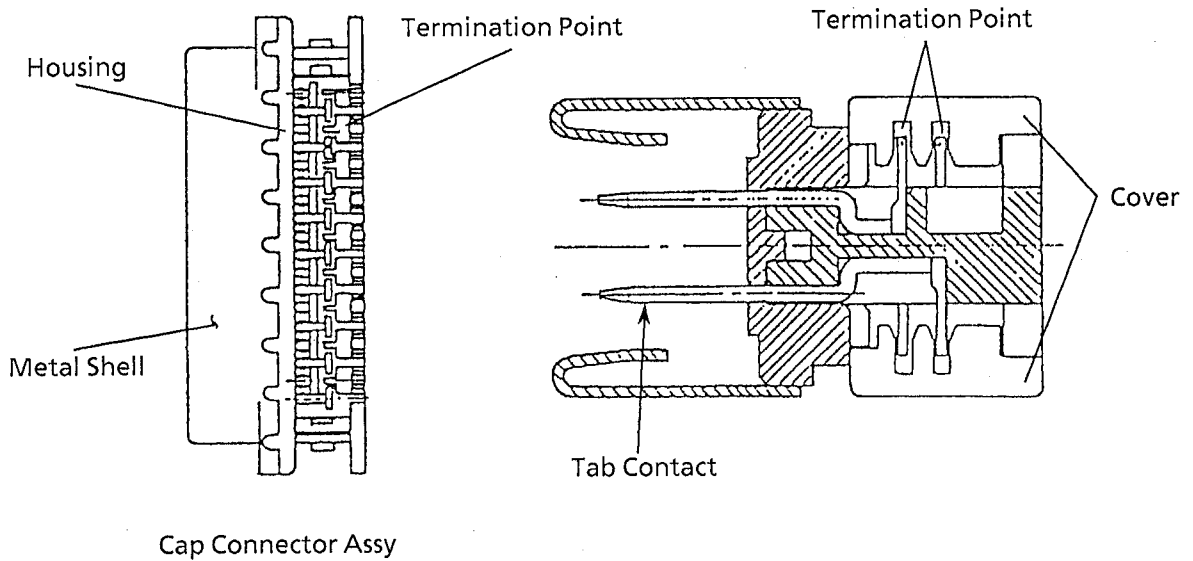


Fig. 1

PRINT	LTR	REVISION RECORD	DR	CHK	DATE	DR. 17 Jul 89 Y. Kashiwa CHK. 17 Jul 89 R. Nishimura APP. R. Nishimura	SHEET 1 OF 5	<b>AMP</b> AMP (Japan), Ltd. Kawasaki, Japan			LOC LOC NO. 114-5124 REV. F1
	C	REDRAWN W/CHANGE	R.N		5/30 '88						
	D	Revised RFA-1464	Y-K	Y-K	12-AUG '89						
	E	Revised RFA-1577	Y-K	Y-K	19-JAN '90						
	F	REVISED RFA-1806	<i>YK</i>	<i>RN</i>	6/11 '91						

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2.2 Type B : Plug Connector Kit

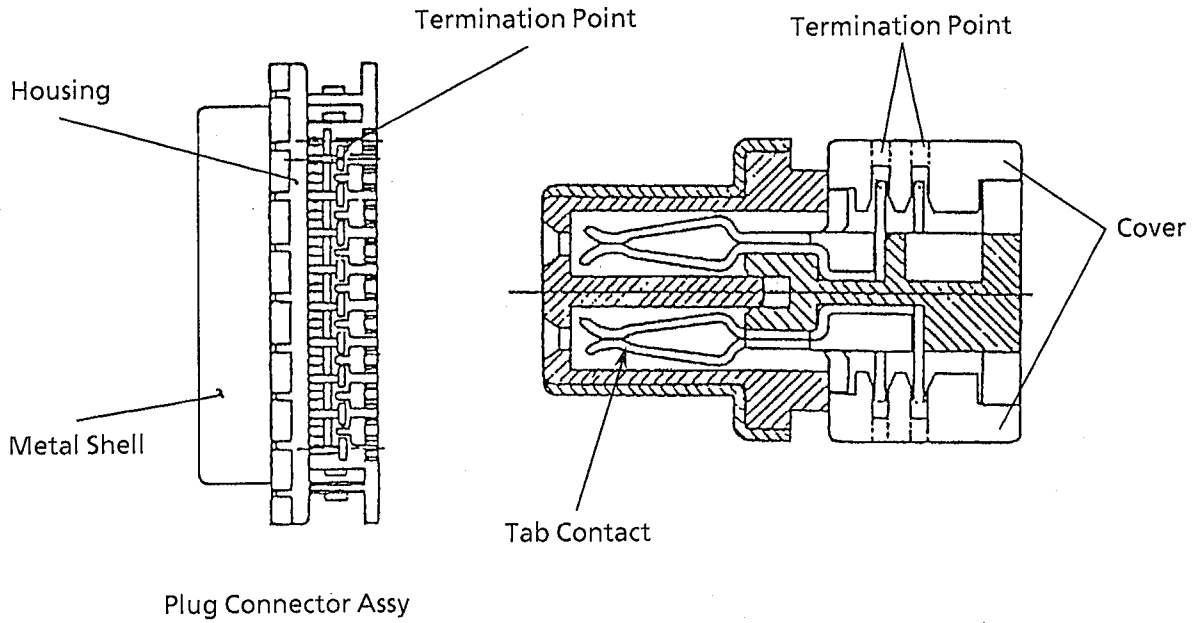


Fig. 2

3. Application Wires :

3.1 Composition of the Wires :

		Size :	
		#30 AWG	#28 AWG
Conductor	Material	Tin-Plated Copper Soft Wire	
	Composition	7 / 0.1	7 / 0.127
	Diameter (mm)	0.3	0.38
Insulator	Material	PVC or Equivalent	
	Diameter (mm)	TYPE A : 0.5~0.88 TYPE B : 0.5~0.75	

- \* Recommended Cable : See Conform Cable Table.
- \* The pitch of the conductor thread must be within 6.0 mm.

Fig. 3

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4. Preparation of Wires :

4.1 Jacketed Wire :

- (1) Jacketed Wires shall be prepared by stripping the shield insulation to the length specified in Fig. 10, prior to terminating operation.
- (2) During the stripping operation of the shield jacket insulation, proper care must be taken not to cut or nick the inside conductors.
- (3) Other preparation must be performed according to the drawing prepared separately from this specification.

5. Requirements :

5.1 Wire-End Protrusion Length : (Refer to Para. 5.6.)

The terminated wire end must be protruding 0.5 mm min. from the contact end, and its feature shall be conforming to the condition, shown below.

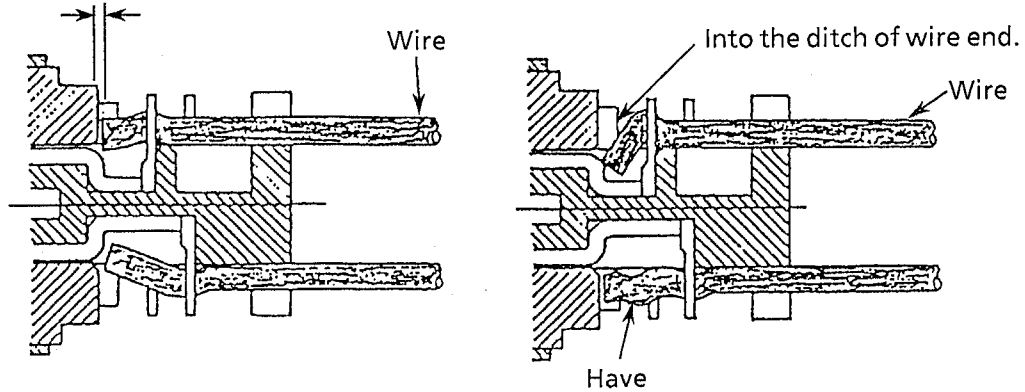


Fig. 4

5.2 Squash and Damaging of Wire :

Squashing and damaging of the wires after terminating are tolerable within the range as specified in Para. 5.4. (Within "A" Dimension)

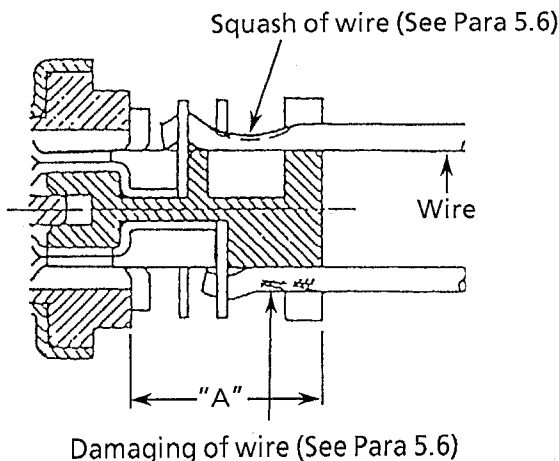


Fig. 5

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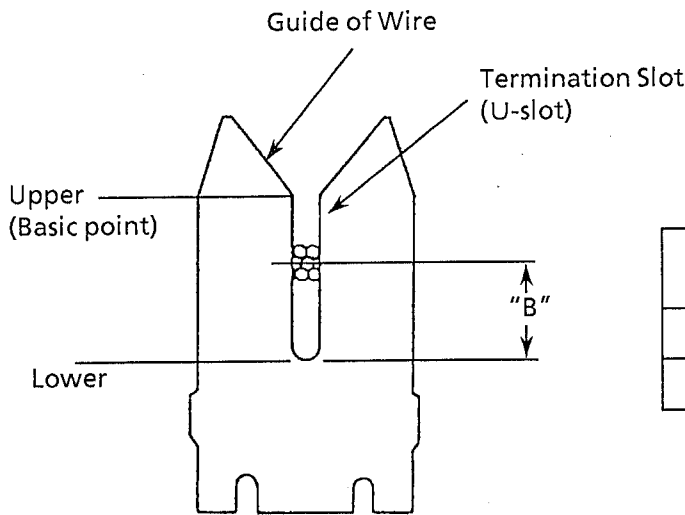
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5.3 Deformation of Contact :

After termination the contacts shall be free from the deformation and / or flaw.

5.4 Depth of Termination of Wire :

The terminated wires must be securely gripped in the contact slot to the depth as specified below.



Diameter of Insulation	"B" Dimension
0.5~0.65	Basic Point / 0.35
0.65~0.88	Basic Point / 0.45

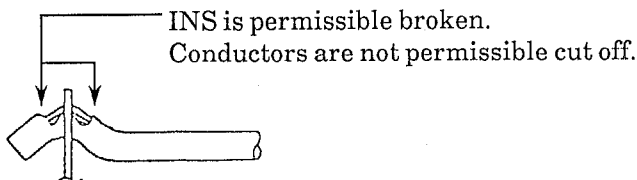
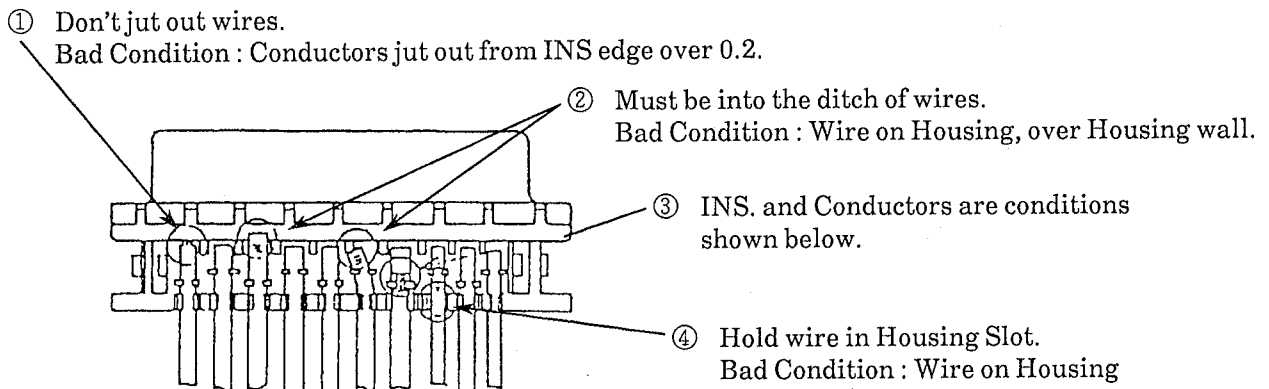
Fig. 6

5.5 Appearance of Housing after Termination :

Housing shall appear without abnormalities such as flaws chipping that are detrimental to connector functions.

5.6 Appearance of Terminated Wires :

The terminated wires shall appear normal with any sign of the conditions shown below.



Mating side

Fig. 7

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Type	Kit Part No.	Connector Part No.	No. of Pos.	Diameter of Wire (mm)
Cap Connector Type A (0.5)	174731-1	174730-1	20	0.5 mm ~ 0.65 mm
	174731-2	174730-2	28	
	174731-3	174730-3	36	
	174731-4	174730-4	50	
	174731-5	174730-5	68	
	N/A	N/A	96	
Cap Connector Type A (0.8)	2-174731-1	2-174730-1	20	0.65 mm ~ 0.88 mm
	2-174731-2	2-174730-2	28	
	2-174731-3	2-174730-3	36	
	2-174731-4	2-174730-4	50	
	2-174731-5	2-174730-5	68	
	N/A	N/A	96	
Cap Connector Type B (0.5)	174340-1	174539-1	20	0.5 mm ~ 0.65 mm
	174340-2	174539-2	28	
	174340-3	174539-3	36	
	174340-4	174539-4	50	
	174340-5	174539-5	68	
	N/A	N/A	96	
Cap Connector Type B (0.8)	2-174340-1	2-174539-1	20	0.65 mm ~ 0.75 mm
	2-174340-2	2-174539-2	28	
	2-174340-3	2-174539-3	36	
	2-174340-4	2-174539-4	50	
	2-174340-5	2-174539-5	68	
	N/A	N/A	96	

Fig. 8

Part No.	Nomenclature	Number. of Termination/ Cycle	Applicable Length of Wire (mm)	maximum Number of Positions
911122-1	Palm-Grip Tool Terminating Each one Position	1	50 mm min.	—//—
911123-1	Hand Press Assy	Half No. of Positions	70 mm min.	50
911149-1	Manual Mini-Press	Half No. Positions	70 mm min.	96
911125-1	Semi-automatic Programmable Terminator	All No. of Positions	80~100 mm	96

Fig. 9

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