

Crimping of 025 Tab Contact

The performance of applicable product is guaranteed only when processed by proper application tooling and condition described in this specification and/or AMP recognized ones. No product is guaranteed when processed with the other tool or condition.

1. Scope

This specification covers the requirements for crimping of 025 Tab Contact.

2. Applicable Contacts

AMP Part Numbers		Finish	Applicable Wires
Strip Form	Loose Piece		
1376109-1	1376607-1	Pre-Tin	AVSS/AVSSH 0.3~0.5 CAVS 0.22~0.5
1376109-2	1376607-2	Selective Gold	CAVUS 0.22~0.5 CHFUS 0.5, HFSS 0.5f

3. Nomenclature

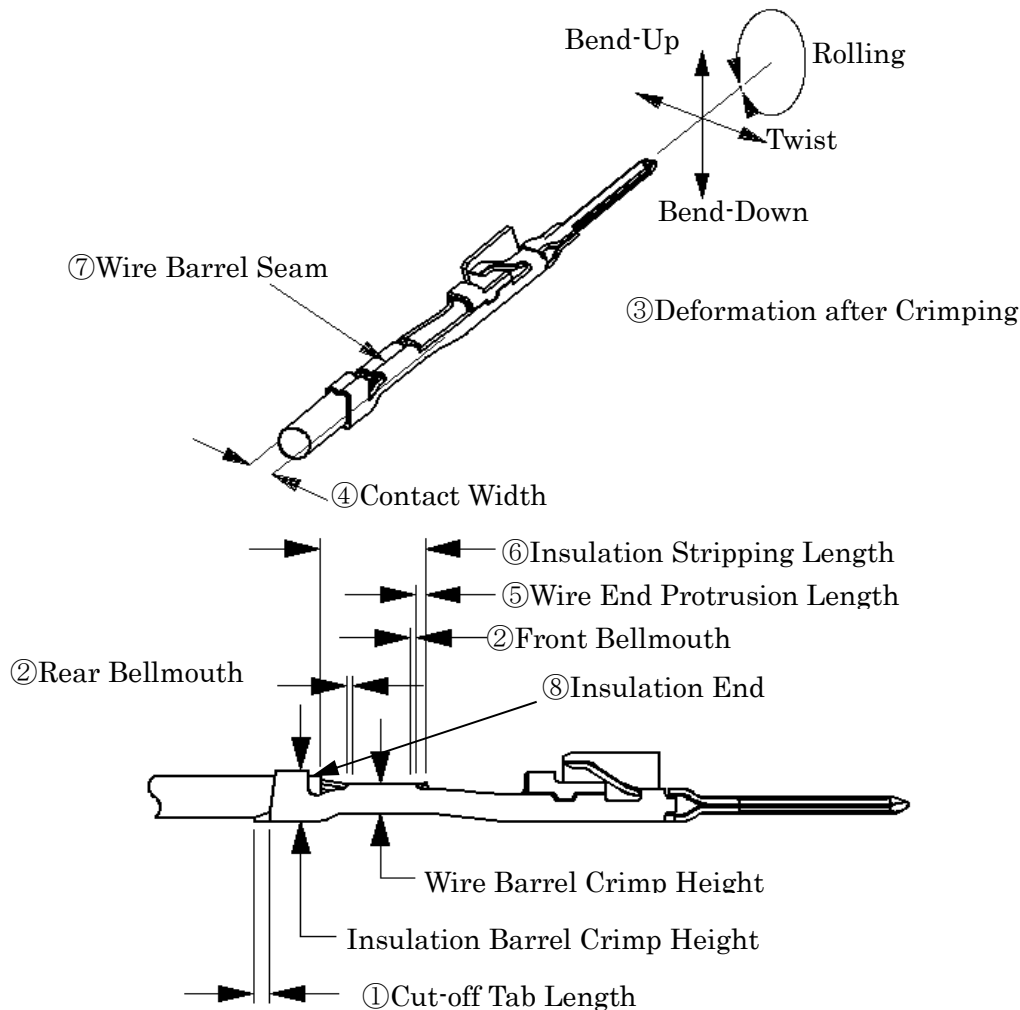


Fig.1

4. Crimping Condition

4.1 Applicator Crimp

Check Items		AVSS /AVSSH 0.3 CAVS 0.22~0.3 CAVUS 0.22~0.5	AVSS/AVSSH/CAVS 0.5 CHFUS 0.5 HFSS 0.5f	Remarks
1	Cut-off Tab Length	0.1~0.5 mm		Fig.1-①
2	Bellmouth	Front	0.2 mm Max.	Fig.1-②
		Rear	0.1~0.4 mm	
3	Deformation After Crimping	Bend	-1° , +2° Max.	Fig.1-③
		Twist	±4° Max.	
		Rolling	±10° Max.	
4	Contact Width after Crimping	1.6mm Max.	1.8mm Max.	Fig.1-④
5	Wire End Protrusion Length	0~1.0 mm		Fig.1-⑤
6	Insulation Stripping Length	3.0~3.5 mm		Fig.1-⑥
7	Wire Barrel Seam	Seam must be closed (No strand looses out of the seam)		Fig.1-⑦
8	Insulation End	Insulation End must be between Wire barrel and Insulation Barrel		Fig.1-⑧

4.2 Hand Tool Crimp

Check Item		AVSS/CAVS/AVSSH 0.3 CAVUS 0.3~0.5	AVSS/CAVS/AVSSH 0.5	Remarks
1	Cut-off Tab Length	0.1~0.5 mm		Fig.1-①
2	Bellmouth	Front	0.2 mm Max.	Fig.1-②
		Rear	0.1~0.4 mm	
3	Deformation After Crimping	Bend	±4° Max.	Fig.1-③
		Twist	±4° Max.	
		Rolling	±10° Max.	
4	Contact Width after Crimping ⁽¹⁾	1.6mmMax.	1.8mm Max.	Fig.1-④
5	Wire End Protrusion Length	0~1.0 mm		Fig.1-⑤
6	Insulation Stripping Length	3.0~3.5 mm		Fig.1-⑥
7	Wire Barrel Seam	Seam must be closed (No strand looses out of the seam)		Fig.1-⑦
8	Insulation End	Insulation End must be between Wire Barrel and Insulation Barrel		Fig.1-⑧

NOTE (1)There is possibility of the dimension is different caused of the ability of operator.
Make sure the contact must be inserted smoothly into the Cap housing

5. Crimp Data

5.1 Applicator Crimp

Contact Part Number (Strip Form)	Wire Size (Nominal)	Applicator Part Number	Wire Barrel Crimp(mm)			Insulation Barrel Crimp (mm)			Crimp Tensile Strength (N)
			Width (2)	Height (1)	Disk Ltr.	Width (2)	Height (1)	Disk Ltr.	
1376109-1 1376109-2	0.22	1366787-2	1.4"F"	0.84	C	1.4"F"	See Para. 6	39Min. ⁽³⁾	
	0.3 0.3f			0.96	B			70Min. ⁽³⁾	
	0.5 0.5f			1.06	A			90 Min. ⁽³⁾	

NOTE (1)Wire Barrel Crimp Height to be within ± 0.05

(2)Crimp Width dimensions are not the product width after crimping , but given by the width of crimper slot for reference

(3) Crimp Tensile Strength includes the wire grip of insulation barrel crimp.

5.2 Hand Tool Crimp

Contact Part Number (Loose Piece)	Wire size (Nominal)	Hand Tool Part Number	Insulation Diameter (mm)	Crimp Symbol		Wire Barrel Crimp Height (mm) ⁽¹⁾	Crimp Tensile Strength (N)
				Wire	Insulation		
1376607-1 1376607-2	0.3 0.3f 0.5 0.5f	1463260-1	1.1-1.7	20-22	I N S	0.84-1.00	50Min. ⁽²⁾ 63Min.

NOTE (1)This tool is for maintenance. The different dimension may be caused according to the ability of operator. Except for the purpose above, you should use the applicator.

(2)Crimp Tensile Strength of 0.3 wire includes the wire grip of insulation barrel crimp.

6. Insulation Barrel Crimp Data

Contact Part Number (Strip Form)	Wire Size (Nominal)	AVSSH/AVSS		CAVS		CAVUS		CHFUS/HFSS	
		Height (1) (mm)	Disk Ltr. (Ref.)	Height (1) (mm)	Disk Ltr. (Ref.)	Height (1) (mm)	Disk Ltr. (Ref.)	Height (1) (mm)	Disk Ltr. (Ref.)
1376109-1 1376109-2	0.22	--	--	1.75	3	1.63	4	--	--
	0.3/0.3f	1.85	4	1.85	4	1.75	5	--	--
	0.5/0.5f					1.85	4	1.85	4

NOTE (1) Insulation Barrel Crimp Height to be within ± 0.1

7. Applicable Wire Data

Wire Size (Nominal)	Number/ Diameter of conductor (mm)	Calculated Cross sectional Area (mm ²)	Insulation Diameter (mm)									
			AVSSH/ AVSS		CAVS		CAVUS		CHFUS		HFSS	
			STD.	MAX.	STD.	MAX.	STD.	MAX.	STD.	MAX.	STD.	MAX.
0.22	7/Compressed	0.2199	—	—	1.25	1.35	0.95	1.05	—	—	—	—
0.3	7/0.26	0.3716	1.4	1.5	1.4	1.5	1.1	1.2	—	—	—	—
0.3f	19/0.16	0.3821	1.4	1.5	1.4	1.5	—	—	—	—	—	—
0.5	7/0.32	0.5629	1.6	1.7	1.6	1.7	1.3	1.4	—	—	—	—
	7/0.30	0.4948	—	—	—	—	—	—	1.25	1.4	—	—
0.5f	19/0.19	0.5387	1.6	1.7	1.6	1.7	—	—	—	—	—	—
	19/0.185	0.5107	—	—	—	—	—	—	—	—	1.5	1.7