

114-61001

Application Specification

Crimping Multi-interlock (MIC) Connector

Mark II, Tab Contact

1. Scope:

This specification covers crimping requirements for Multi-interlock (MIC), Mark II, tab contacts of the part numbers specified in Para. 2, manufactured by AMP (Japan), Ltd.

2. Applicable Part Numbers:

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

85035 . 85034
172780 172778

Tab Contact, Strip Form
" " Loose Piece

3. Nomenclature:

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

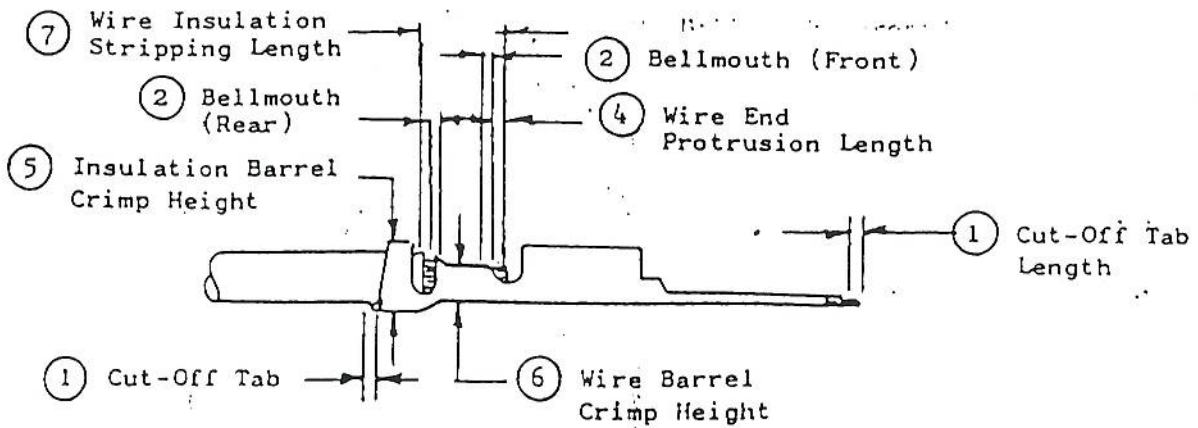
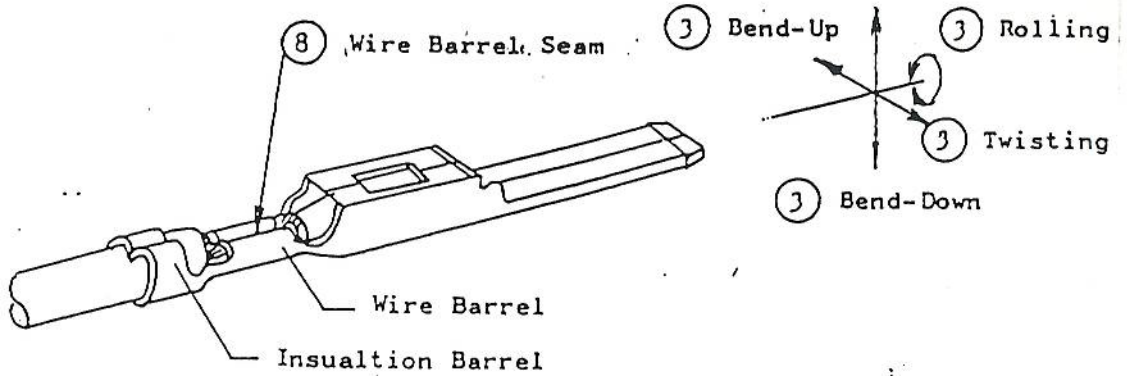
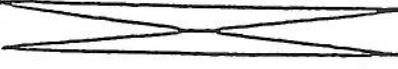


Fig. 1

1	RELEASED	ORG	AMP AMP MFG KOREA		
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		APP	CS Lee	NO 114-61001	REV 1
LTR	REVISION RECORD	APP	DATE	PAGE 1 OF 3	TITLE CRIMPING MULTI-INTER LOCK MARK II, TAB CONTACT

4. Crimping Conditions and Crimp Data:

4.1 Crimping Conditions:

Product Part Numbers		Crimping Conditions		Remarks	
Work Points		85034, 172778	85035, 172780		
1	Cut-Off Tab Length	0.5 mm Max.		Fig.1-①	
2	Bellmouth	Front		Must be visually confirmed.	
		Rear	0.15 - 0.65mm For hand tool crimping, rear bellmouth should be visually confirmed.		Fig.1-②
3	Deformation of Contact After Crimping	Bend: Up/Down	5° Max.		Fig.1-③
		Twisting	5° Max.		
		Rolling	8° Max.		
4	Wire End Protrusion Length	0 - 1 mm		Fig.1-④	
5	Insulation Stripping Length	3.5 - 4.5 mm	3.0 - 4.0 mm	Fig.1-⑦	
6	Wire Barrel Seam	After crimping, wire barrel seam must appear neatly closed. A slight opening may be permissible if strands are tightly gripped within wire barrel.		Fig.1-⑧	

4.2 Crimp Data: Fig. 2

4.2.1 Crimping by Applicator:

Contact Part No. Strip	Wire Size (Nominal)		Applicator Number	Wire Barrel Crimp (mm)			Insulation Barrel Crimping (mm)			Crimp Tensile Strength (kg)
	mm ²	(AWG)		Width	Height ±0.05mm (Fig.1-7)	Disc Ltr.	Width	Height See Fig.1-6	Disc (Ref.)	
85034	0.5	(#20)	752839-1	2.3 "F"	1.30	D	4.06 "F"	3.5 Max.	4	9.0 Min.
	0.85	(#18)			1.34	C			4	13.0 Min.
	1.25	(#16)	752839-2		1.50	B			4	18.0 Min.
	2.0	(#14)			1.78	A			5	27.0 Min.
	0.5+0.5	(#20)X2	752839-2		1.50	B			3	9.0 Min.
	0.5+0.85	(#20)+(#18)			1.50	B			3	9.0 Min.
85035	0.3	(#22)	752841-1	1.78 "F"	1.17	C	3.3 "F"	3.1 Max.	5	5.0 Min.
	0.5	(#20)	752841-2		1.27	B			5	9.0 Min.
	0.89	(#18)			1.41	A			5	13.0 Min.

Notes: (1) Tolerance of wire barrel crimp to be plus minus 0.05mm.

(2) Unless otherwise noted, all dimensions are in metric system.

Fig. 3

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4.2.2 Crimping by Hand Tool :

Contact Part Number	Wire Size		Hand Tool Part No.	Insulation Diameter mm	Crimp Symbol	Wire Barrel Crimp Height mm	Crimp Height Check Gage Number	Crimp Tensile Strength (kg)
	mm ²	(AWG)						
172778	0.5	(#20)	755402-1	2.1-3.0	A	1.25-1.37	N/A	7.0 Min.
	0.85	(#18)						11.0 Min.
	0.5 + 0.5 (#20) + (#20)							7.0 Min.
	1.25	(#16)				16.0 Min.		
	2.0	(#14)				23.0 Min.		
	0.5 + 0.85 (#20) + (#18)			2.6-3.4	B	1.45-1.65	N/A	7.0 Min.
172780	0.3	(#22)	724682-1	1.5-2.4	A	1.06-1.19	N/A	5.0 Min.
	0.5	(#20)						7.0 Min.
	0.8	(#18)		2.2-2.6	B	1.28-1.45		11.0 Min.

- Notes: (1) The insulation range shown in the table, shall be applied to one-wire crimp only. For two-wire crimp, applicable outer diameter range may vary largely. Therefore, the value range has been omitted.
 (2) Unless otherwise noted, all dimensions are in metric system.

Fig. 4

5. Applicable Wire Specifications:

Wire Size (Nominal)	Strand Composition	Calculated Cross-sectional Area	Insulation Diameter (mm)	Applicable Specification
mm (AWG)	No. of Strands / Diameter of a Strand	(mm ²)		
0.3 (#22)	12 / 0.18	0.31	1.5 Std.	JCS 246 Vinyl Insulated Wire for Communication Equipment
0.5 (#22)	7 / 0.26	0.37	1.6 or 1.8 Std.	(Low Voltage Wire for Automobiles)
0.5 (#20)	7 / 0.32	0.56	2.2 Std.	JIS C 3406
0.5 (#18)	11 / 0.32	0.88	2.4 Std.	Low Voltage Wire for Automobiles
1.25 (#16)	16 / 1.29	1.29	2.7 Std.	
2.0 (#14)	26 / 0.32	2.09	3.1 Std.	

Fig. 5

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