

3.2. Carrier Cutoff Tab and Burr

A. Cutoff Tab

Cutoff tab shall not exceed .015.

B. Burr

Burr on cutoff tab shall not exceed .003.

3.3. Wire Barrel Crimp

A. Crimp Dimensions and Type

Crimp height, width and type shall be as shown in Figure 3 and 4.

B. Effective Crimp Length

Effective Crimp Length shall be .085 minimum, and is defined as that portion of the barrel, excluding bellmouth, fully formed by the crimping tool.

C. Wire Barrel Flash

Wire barrel flash shall not exceed .005.

D. Wire Barrel Seam

The wire barrel seam shall be closed adequately to confine all strands of the wire. There shall be no loose wire strands or wire strands embedded in the outside of the wire barrel.

E. Bellmouth

Rear bellmouth length shall be .005 minimum.

F. Conductor Location

- (1) End of the wire shall be flush with the front end of the wire barrel or extend .015 maximum after crimping.
- (2) Both insulation and conductor shall be visible between the insulation barrel and wire barrel. Care shall be taken not to allow insulation to be crimped in the wire barrel.

3.4. Insulation Barrel Crimp

A. Crimp Dimensions and Type

Crimp width and type shall be as shown in Figure 3 and 4.

B. Workmanship

Reasonable care shall be taken not to cut or break the insulation during the crimping operation.



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3.5. Locking Lance

Locking lance shall not be deformed.

3.6. Alignment

A. Straightness

The contact, including the cutoff tab and burr shall not be bent **above** the datum line or more than .015 below the datum line as shown in Figure 2.

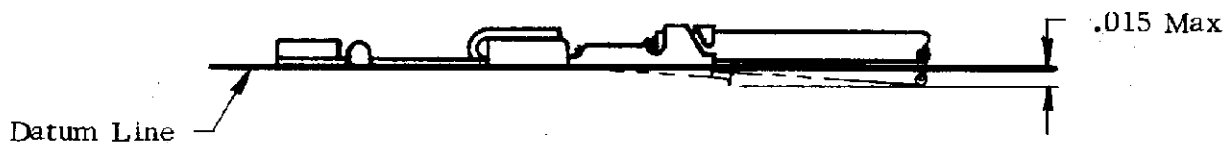



Figure 2

B. Twist or Roll

There shall be no twist or roll in crimped portion that will impair usage of the contact.

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Part No	Wires		Insulation Diameter	Strip Length ±.016	Wire Barrel Crimp		Insulation Barrel Crimp	
	Qty	Size			Width	Type Crimper	Width	Type Crimper
583259	1	20	.050 - .090	.156	.062	F	.100	O
	1	22						
	1	24						
583362	1	18	.070 - .110	.156	.070	F	.110	O
	1	20						
	1	24						
583497	1	24	.038 - .045	.156	.055	F	.070	O
	1	26						
	1	28						
	1	28	.030 - .045	.156	.055	F	.070	O

Figure 3

Automatic Machine Wire Crimp Dimensions

Part No	Wires		Insulation Diameter	Strip Length ±.016	Wire Barrel Crimp		Insulation Barrel Crimp		Hand Tool Part No
	Qty	Size			Width	Type Crimper	Width	Type Crimper	
583261	1	24-20	.050 - .090	.156	.062	F	.100	O	90215-1
583363	1	20-18	.070 - .110	.156	.070	F	.110	O	90215-1
	1	26-24	.038 - .045	.156	.055	F	.070	O	90253-1
583498	1	28	.030 - .045	.156	.055	F	.070	O	—
	1	24-20	.050 - .090	.156	.062	F	.100	O	90253-1

Figure 4

Hand Tool Wire Crimp Dimensions



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