

# APPLICATION SPECIFICATION

## 1. SCOPE

### 1.1. Content

This specification covers the requirements for application of AMP\* bifurcated leaf contacts. These requirements are applicable to hand or automatic machine crimping tools. For specific wire and insulation ranges relative to the products covered in this specification see Figures 4 and 5.

### 1.2. Reference Specification

For applicable performance requirements see AMP Specification 108-1020.

## 2. NOMENCLATURE

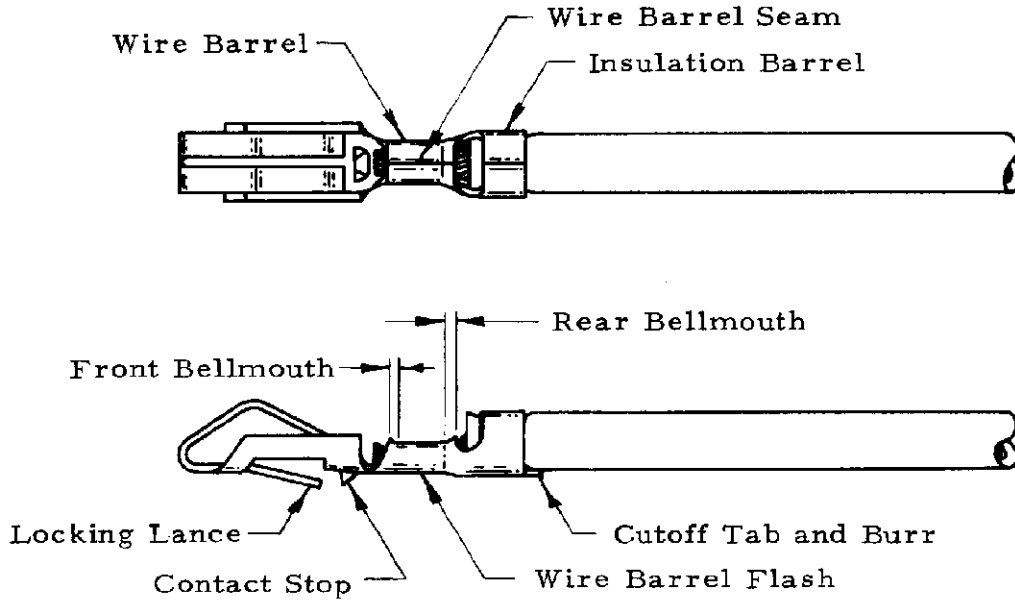


Figure 1

## 3. CRIMP AND DIMENSIONAL REQUIREMENTS

### 3.1. Wire Preparation

#### A. Strip Length

Insulation shall be stripped in Figure 4 and 5.

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NO 114-1015

DIST 1

				DR <i>P. E. Fitz</i> 6/28/77	<b>AMP INCORPORATED</b> Harrisburg, Pa.					
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				APP <i>R. Sunderman</i> 6-28-77	LOC B	A	NO 114-1015	REV 0		
				SHEET 1 OF 5		CONTACT, BIFURCATED LEAF, APPLICATION OF				
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B. Workmanship

Reasonable care shall be taken not to nick, scrape or cut any strands during the stripping operation.

3.2. Carrier Cutoff Tab and Burr

A. Cutoff Tab

Cutoff tab shall not exceed .015.

B. Burr

Burr on cutoff shall not exceed .003.

3.3. Wire Barrel Crimp

A. Crimp Dimensions and Type

Crimp height, width and type shall be as shown in Figures 4 and 5.

B. Tensile Strength

Crimp tensile strength shall be as shown in Figure 4.

C. Wire Barrel Flash

Wire barrel flash shall not exceed .005.

D. Wire Barrel Seam

Wire barrel seam shall be completely closed and there shall be no evidence of loose wire strands or wire strands visible in the seam.

E. Bellmouth

(1) Rear bellmouth length shall be .006-.018.

(2) Front bellmouth length shall be .006 maximum.

F. Conductor Location

(1) End of the wire shall be flush with the front end of the wire barrel or extend .031 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 Figures 4 and 5.



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B. Workmanship

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

3.5. Locking Lance

Locking lance shall not be deformed.

3.6. Contact Stop Height

Contact stop height shall be  $.025 \pm .015$ .

3.7. Alignment

A. Straightness

(1) The contact, including the cutoff tab and burr shall not be bent above or below the datum line more than the amount shown in Figure 2.

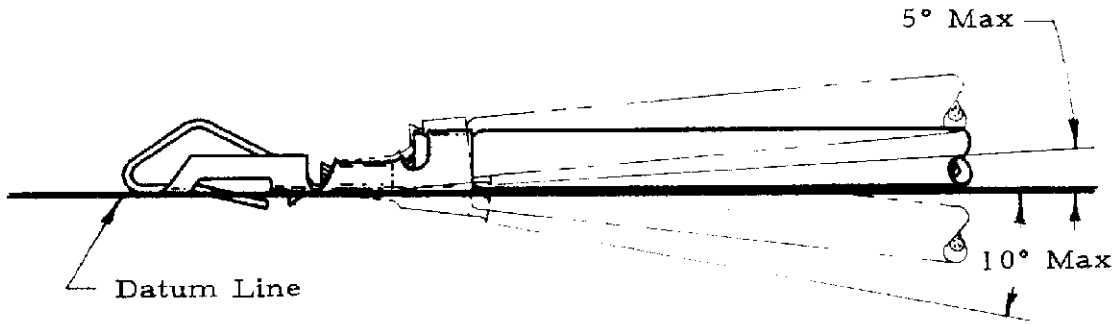


Figure 2

(2) The side to side bending of the contact shall not exceed the limits specified in Figure 3.

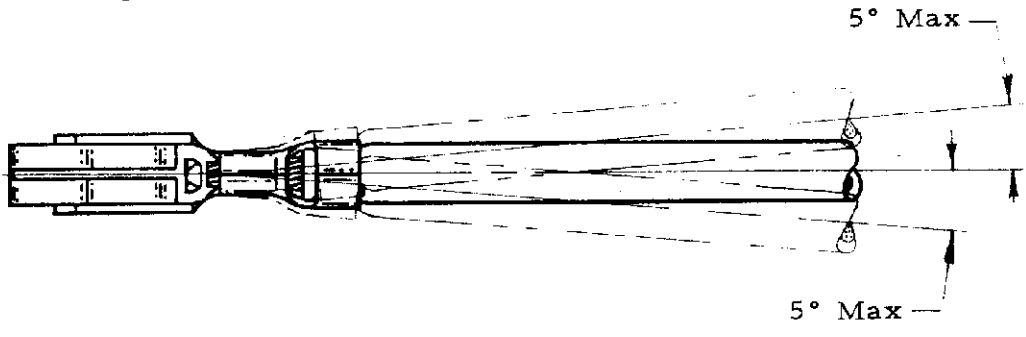



Figure 3

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 $\pm .015$	Wire Barrel Crimp			Insulation Barrel Crimp	
	No	Size			Width	Height $\pm .002$	Type Crimper	Tensile Strength Pounds	Width
61668	1	24	.100 max	.156	.070	F	10	.100	F
		22							
		20							
		18							
350194	1	24	.100 max	.156	.070	F	10	.100	F
		22							
		20							
		18							
640020	1	30	.040-.060	.156	.055	F	10	.090	F
		28							
		26							
		24							

Figure 4  
Automatic Machine Wire Crimp Dimensions



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Part No	Wires		Insulation Diameter	Strip Length	Hand Tool (a)	
	No	Size			Part No	Nest
61668 350011	1	24	.060-.100	.156	90123-2	B
		22				
		20				
		18				
	1	24	.043-.075	.156	90123-5	B
		22				
		20				
		18				
350194	1	24	.060-.085	.156	90274-2	22-20
		22	.060-.100	.156	90123-2	B
	20					
	18					
	1	22	.043-.075	.156	90123-5	B
		20				
		18				
		18				
640020	1	30	.040-.057	.156	90066	26-24
		28				
		26				
		24				
	1	30	.040-.057	.156	90066-5	A
		28				
		26				
		24				

(a) Listed tools are best available.

Figure 5  
Hand Tool Wire Crimp Dimensions

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