

3.2. Carrier Cutoff Tab and Burr

A. Cutoff Tab

Cutoff tab shall not exceed .015.

B. Burr

Burr on cutoff shall not exceed .005.

3.3. Wire Barrel Crimp

A. Crimp Dimensions and Type

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

B. Wire Barrel Flash

Wire barrel flash shall not exceed .005.

C. 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.

D. Bellmouth

(1) Rear bellmouth length shall be .015-.025.

(2) Front bellmouth length shall be .020 maximum.

E. Conductor Location

(1) End of the wire shall be flush with the front end of the wire barrel or extend .030 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.

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.

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3.6. Stabilizer

After crimping the stabilizer width shall be as indicated in Figure 2.

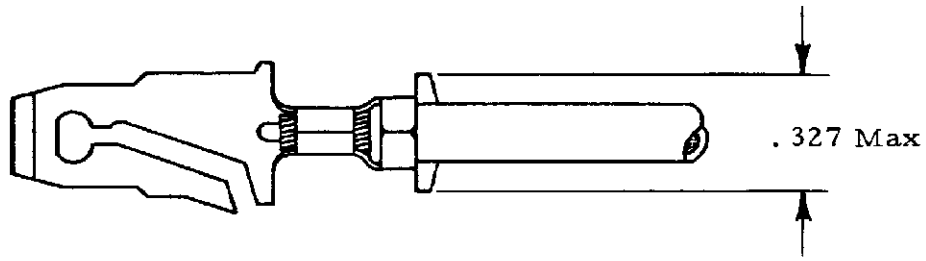


Figure 2

3.7. Alignment


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

Part No	Wires		Insulation Diameter	Strip Length	Wire Barrel Crimp			Insulation Barrel Crimp	
	No	Size			Width	Height ±.002	Type Crimper	Width	Type Crimper
60112	1	20	.080-.110	.235	.130	.076	F	.180	O
		18				.079			
60113	1	16	.090-.130	.235	.130	.095	F	.180	O
		14		.250		.103			
60794	1	16	.090-.130	.235	.130	.095	F	.180	O
		14		.250		.103			
60856	1	20	.080-.110	.235	.130	.076	F	.180	O
		18				.079			
61194	1	20	.080-.110	.235	.130	.076	F	.180	O
		18				.079			
61195	1	16	.090-.130	.235	.130	.095	F	.180	O
		14		.250		.103			
61618	1	20	.080-.110	.235	.110	.060	F	.180	O
		18				.063			
62046 (a)	1	18	.090-.140	.235	.130	.092	F	.180	O
		16		.235		.095			
		14		.250		.103			

(a) No stabilizer ears.

Figure 3

Automatic Machine Wire Crimp Dimensions

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