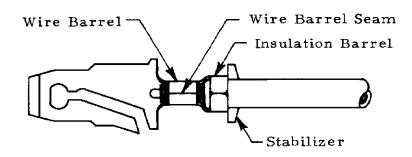
APPLICATION SPECIFICATION

1. SCOPE

This specification covers the requirements for application of AMP* automotive type tab contacts. These requirements are applicable to automatic machine crimping tools. For specific wire and insulation ranges relative to the products covered in this specification see Figure 3.

2. NOMENCLATURE



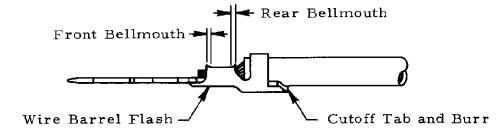


Figure 1

3. CRIMP AND DIMENSIONAL REQUIREMENTS

3.1. Wire Preparation

A. Strip Length

Insulation shall be stripped as indicated in Figure 3.

B. Workmanship

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

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					V. Karaban	Of 1/20/27 B A NO 114-2029 REV 0			
DIST					SHEET	CONTACT, TAB, AUTOMOTIVE TYPE, APPLICATION OF			
2	0 LTR	Was SDF 1C-12 REVISION RECORD	APP	DATE	1 OF <u>3</u>				

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

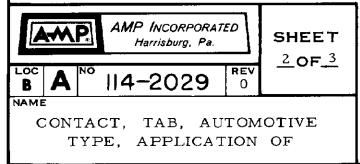
Crimp width and type shall be as shown in Figure 3.

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.



3.6. Stabilizer

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

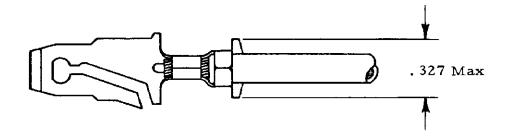


Figure 2

3.7. Alignment

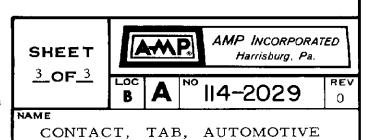
There shall be no twist or roll in crimped portion that will impair usage of the contact.

Dont	Don't Wires		Tlotion	C++in	Wire Barrel Crimp Insulation Barrel Crimp				
Part No	No	Size	Insulation Diameter	Strip Length	Width	Height ±.002	Type Crim p er	Width	Type Crimper
60112	1	20 18	.080110	. 235	.130	.076	F	.180	0
60113	1	16 14	.090130	.235	.130	.095	F	.180	0
60794	1	16 14	.090130	. 235 . 250	.130	.095	F	.180	0
60856	1	20 18	.080110	. 235	.130	.076	F	.180	0
61194	1	20 18	.080110	. 235	.130	.076 .079	F	. 180	0
61195	1	16 14	.090130	.235	.130	.095	F	. 180	0
61618	1	20 18	.080110	. 235	.110	.060	F	.180	0
62046 (a)	1	18 16 14	.090140	. 235 . 235 . 250	.130	.092 .095 .103	F	.180	0

(a) No stabilizer ears.

Figure 3

Automatic Machine Wire Crimp Dimensions



TYPE, APPLICATION OF