

**AMP 2.0mm Pitch EMIX  
Economic Metric Interconnect Series  
Wire-To-Board System.**

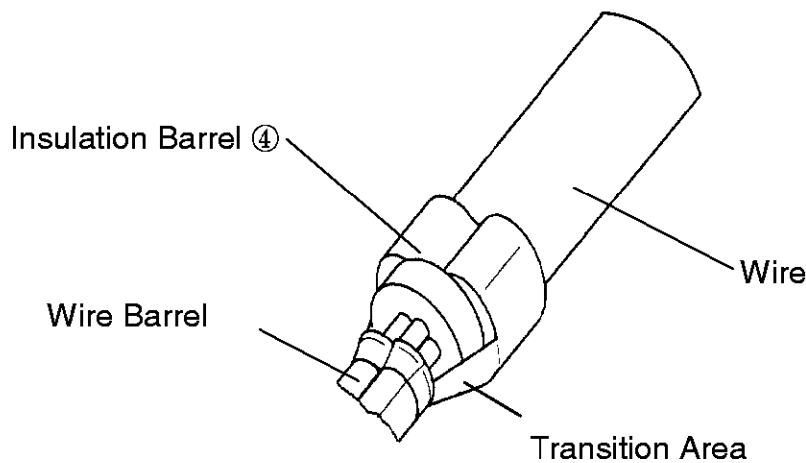
**1. SCOPE**

This specification covers the requirements for crimping of 2.0mm pitch EMIX (Economic Metric Interconnect Series, Crimp Type, Wire-To-Board System) Connector. These requirements are applicable to specific tools. For specific wire and products covers in this specification refer to the appropriate AMP customer drawing.

**2. APPLICABLE PRODUCT**

Contact Form	Product Part Number	Crimping Tool	Wire Size (SQ mm)	Ins. Diameter (mm)
Strip Terminal	0-1470106-1	Applicator	0.05 ~ 0.23mm <sup>2</sup> (AWG #28 ~ #22)	φ 0.9 ~ φ 1.5mm

**3. NOMENCLATURE**



DR	DATE	APVD	DATE
Oblic Hu	18-Aug-2003	Jerry Cheng	18-Aug-2003
			FZ00-0183-03

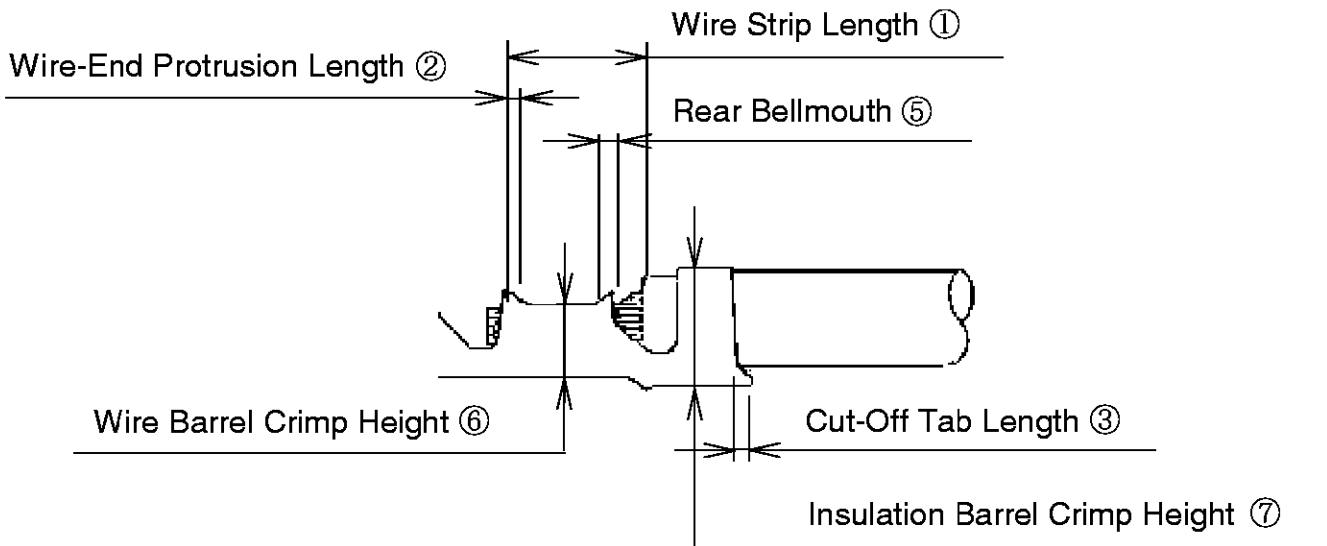
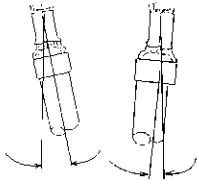
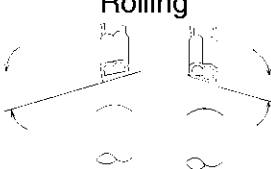


FIG 1.

**4. CRIMPING REQUIREMENT**

No.	Check Items	Crimping Requirements		Remarks	
		Applicator	Hand Tool		
1	Wire Strip Length	1.5 ~ 2.0 mm		Fig.1-①	
2	Wire-End Protrusion Length	0.1 ~ 1.0 mm		Fig.1-②	
3	Cut-Off Tab Length	0.0 ~ 0.3 mm		Fig.1-③	
4	Rear Bellmouth	0.2 ~ 0.4 mm		Fig.1-⑤	
5	Wire Barrel Crimp	Refer Table.1		Fig.1-⑥	
6	Insulation Barrel	Refer Table.1		Fig.1-④	
7	Insulation Barrel Crimp Height	Refer Table.1		Fig.1-⑦	
8	Allowable Deviation after Crimping	Bend-Up 	6° Max.	6° Max.	
9		Bend-Down 	6° Max.	6° Max.	

10		<p>Twisting</p> 	5° Max.	5° Max.	/
11		<p>Rolling</p> 	7° Max.	7° Max.	

**5. CRIMPING DATA**

Table.1

Contact Part Number	Applicator Part Number	Wire Size		Insulation Strip Length	Wire Barrel		Insulation Barrel	
		Number of Wire	Size		Crimp Width (D)	Crimp Height (C)	Crimp Width (B)	Crimp Height (A)
X-1470106-X	X-1470106-X	1	0.23mm <sup>2</sup> (#22)	2.5~3.0 mm	1.35mm	0.80mm	1.75mm	1.60mm
		1	0.21mm <sup>2</sup> (#24)		1.35mm	0.70mm	1.75mm	1.50mm
		1	0.13mm <sup>2</sup> (#26)		1.35mm	0.65mm	1.70mm	1.45mm
		1	0.08mm <sup>2</sup> (#28)		1.30mm	0.60mm	1.70mm	1.40mm

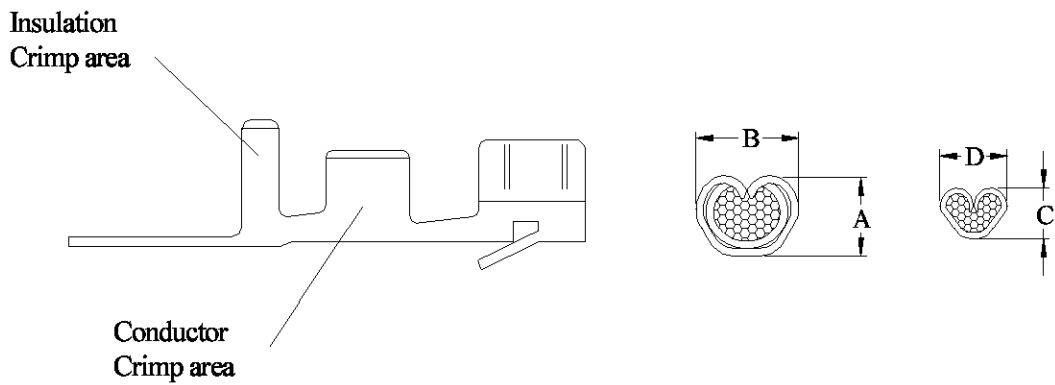


Table.2

Wire Size		Crimp Tensile Strength
mm <sup>2</sup>	AWG#	N (kgf) Min.
0.22	22	34.3 (3.5)
0.21	24	29.4 (3.0)
0.13	26	24.5 (2.5)
0.08	28	19.6 (2.0)

- Note: (a) Tool mark is allowable at crimped areas and transition areas only.  
 (b) The dimensions of crimp width of wire barrel and insulation barrel are the dimensions of crimping tool.