

APPLICATION SPECIFICATION

1. SCOPE

This specification covers the requirements for application of AMP* taper pin 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 4.

2. NOMENCLATURE

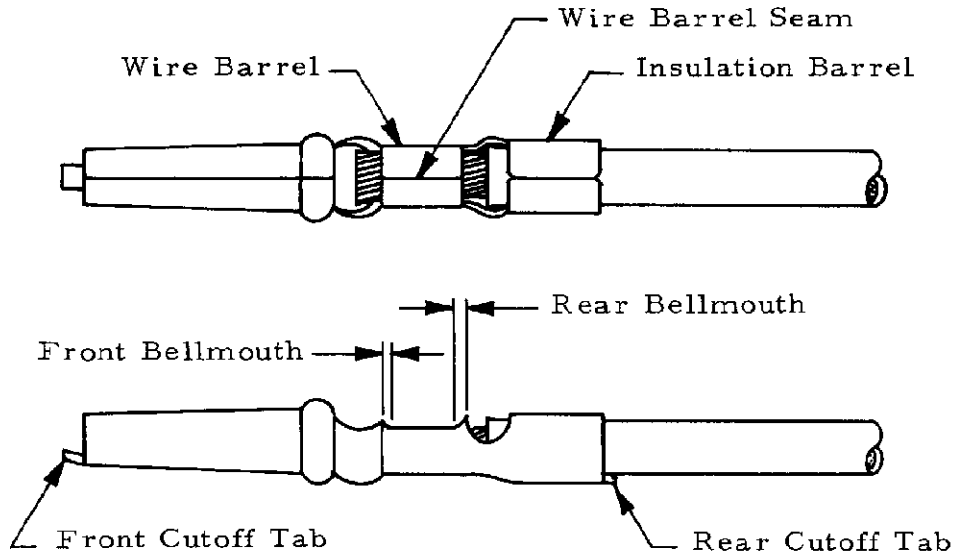


Figure 1

3. CRIMP AND DIMENSIONAL REQUIREMENTS

3.1. Wire Preparation

A. Strip Length

Insulation shall be stripped as indicated in Figure 4.

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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3.2. Carrier Cutoff Tab

- A. Front cutoff tab shall not exceed .020 and shall lie within the cone-shaped extension of the taper as indicated in Figure 2.

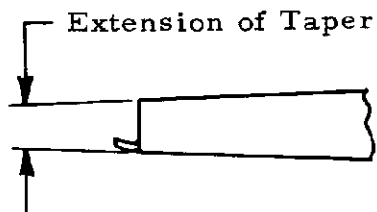


Figure 2

- B. Rear cutoff tab shall not exceed .020.

3.3. Wire Barrel Crimp

- A. Crimp Dimensions and Type

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

- B. 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.

- C. Bellmouth

- (1) Rear bellmouth length shall be .005 - .015.
- (2) Front bellmouth length shall not exceed .015.

- D. Conductor Location

- (1) End of the wire shall be flush with the front end of the wire barrel or extend .032 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, except insulation piercing contacts.

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3.4. Insulation Barrel Crimp

A. Crimp Dimensions and Type

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

B. Workmanship

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

3.5. Alignment

- A. Crimped product shall fall into an area defined by an "A" diameter tube, see Figure 4, whose length exceeds the total length of the crimped contact as indicated in Figure 3.

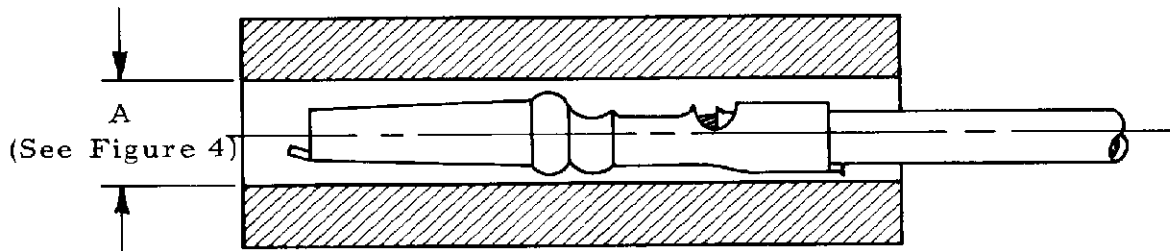


Figure 3

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	Wire		Insulation Diameter	Strip Length ±.015	Wire Barrel Crimp		Insulation Barrel Crimp		A (a)
	Qty	Size			Width	Type Crimper	Width	Type Crimper	
41278	1	24	.040-.055	.125	.070	F	.070	O	.105
41640	1	22							
41646	1	22	.055-.060	(b)	.080	O	—	—	.110
42600	1	22							
41496	1	24	.058-.062	(b)	.080	O	—	—	.123
41279	1	22							
41744	1	Tinsel #2049	.065-.080	.125	.070	F	.100	F or O	.136
41506	1	24							
41647	1	22							
41648	1	24							
41649	1	22	.040-.060	.156	.070	F	.070	O	.123
41222	1	22							
66266	1	24	.080-.100	.188	.080	F	.120	F or O	.154
41650	1	20							
41651	1	18	.060-.080	.218	.080	F	.100	F or O	.154
41652	1	18							
41991	1	20	.060-.080	.218	.080	F	.100	F or O	.154
42229	1	18							
66200	1	20	.050-.075	.218	.080	F	.090	O	.123
66267	1	18							
41653	1	18	.100-.140	.188	.090	F	—	—	.123
41656	1	16							
41657	1	18	.100-.140	.188	.090	F	.140	F or O	.165
41658	1	16							

Figure 4 (cont)

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Part No	Wire		Insulation Diameter	Strip Length \pm .015	Wire Barrel Crimp		Insulation Barrel Crimp		A (a)
	Qty	Size			Width	Height \pm .002	Type Crimper	Width	
66202	1	18	.100-.140	.188	.090	.056	F	F or O	.165
	1	16							
60066	1	18	.070-.100	.218	.090	.058 .063	F	F or O	.165
	1	16							
66268	1	18	.064-.087	.218	.090	.056	F	O	.136
	1	16							
42004	1	Tinsel #1895	.070-.076	(b)	.100	(c)	O	—	.123
66091	1	24	.040-.055	.125	.070	.034 .036	F	O	.105
66113	1	22	.040-.055	.125	.070	.043	F	O	.105
66186	1	22							

(a) See Para 3.5.A.

(b) Insulation piercing no stripping required.

(c) Until crimp barrel is tightly around the insulation depending on insulation diameter.

Figure 4 (end)

Automatic Machine Wire Crimp Dimensions

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