

APPLICATION SPECIFICATION

1. SCOPE

This specification covers the requirements for application of 110, 187, 205 and 312 series FASTIN-FASTON* receptacle 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 refer to the appropriate AMP Customer Drawing.

2. NOMENCLATURE

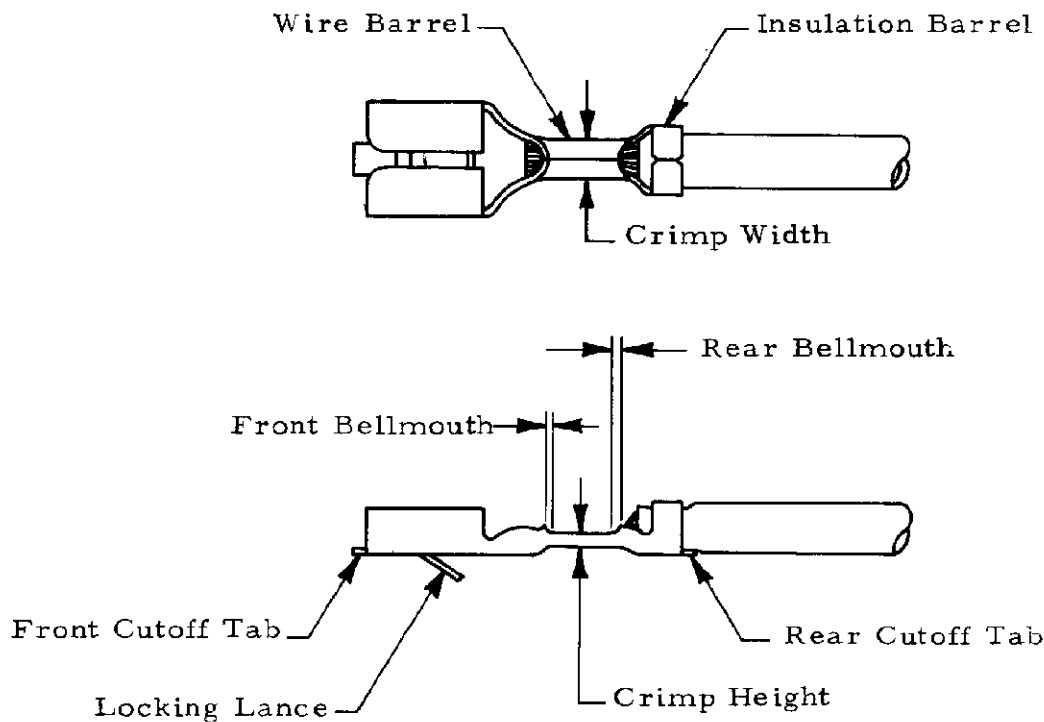


Figure 1

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				DR <i>R. E. Fitz</i> 12/3/81	AMP AMP INCORPORATED Harrisburg, Pa.		LOC B	NO A	REV 0
				CHK <i>J. Brown</i> 12-3-81					
				APP <i>J. Karbunsky</i> 12-4-81					
0 Was SDF 1C-4 &				SHEET 1 OF 4	CONTACT, RECEPTACLE, FASTIN-FASTON, 110, 187, 205 AND 312 SERIES, APPLICATION OF				
1C-4a									
DIST 02	LTR	REVISION RECORD	APP	DATE					

3. CRIMP AND DIMENSIONAL REQUIREMENTS

3.1. Wire Preparation

A. Strip Length

Insulation shall be stripped as indicated in Figure 2 and is based on wire barrel length.

Wire Barrel Length	Wire Strip Length, nominal
.093 - .108	1/8
.109 - .141	5/32
.142 - .174	3/16
.175 - .207	7/32
.208 - .240	1/4
.241 - .273	9/32

Figure 2

B. Workmanship

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

3.2. Carrier Cutoff Tab

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 the appropriate Applicator Log Sheet for machine applications or the Instruction Sheet for hand tool applications.

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 not exceed .025.

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SHEET

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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

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. 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 3.

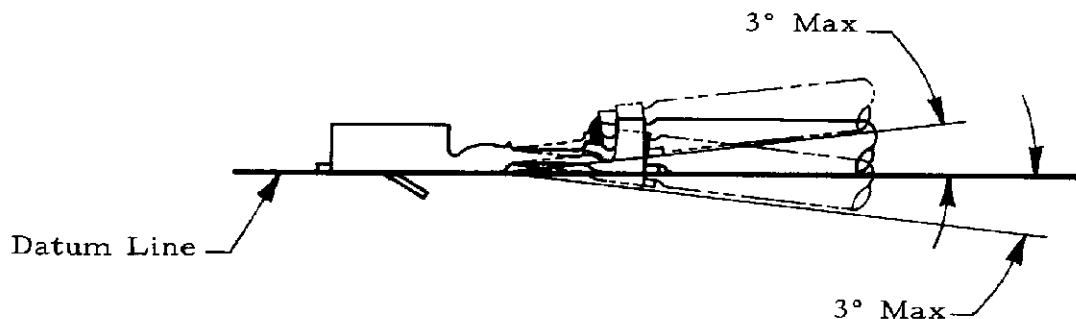


Figure 3

SHEET 3 OF 4	AMP AMP INCORPORATED Harrisburg, Pa.		
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- (2) The side to side bending of the contact shall not exceed the limits specified in Figure 4.

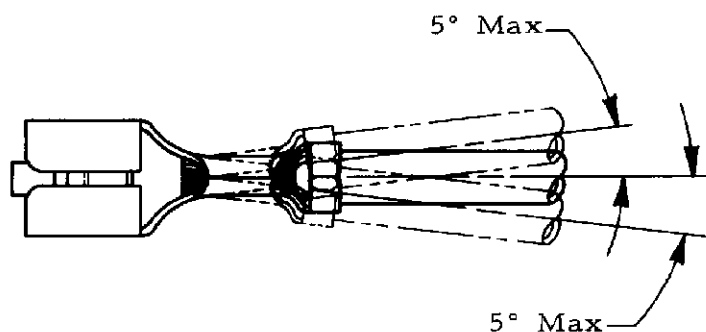


Figure 4

B. Twist or Roll

Twist or roll of the crimped contact shall not exceed the limits specified in Figure 5.

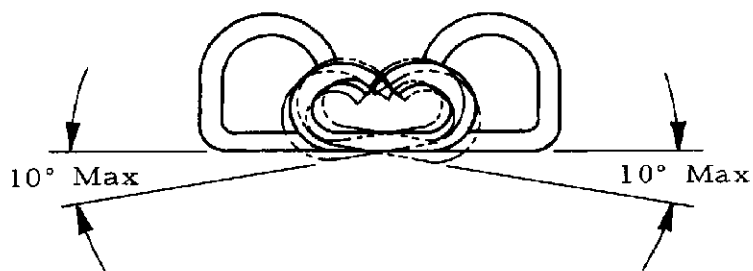


Figure 5

AMP		AMP INCORPORATED Harrisburg, Pa.		SHEET <u>4</u> OF <u>4</u>	
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