NUMBER 114-5095

AMP SECURITY CLASSIFICATION Customer Release

Application Specification

114-5095

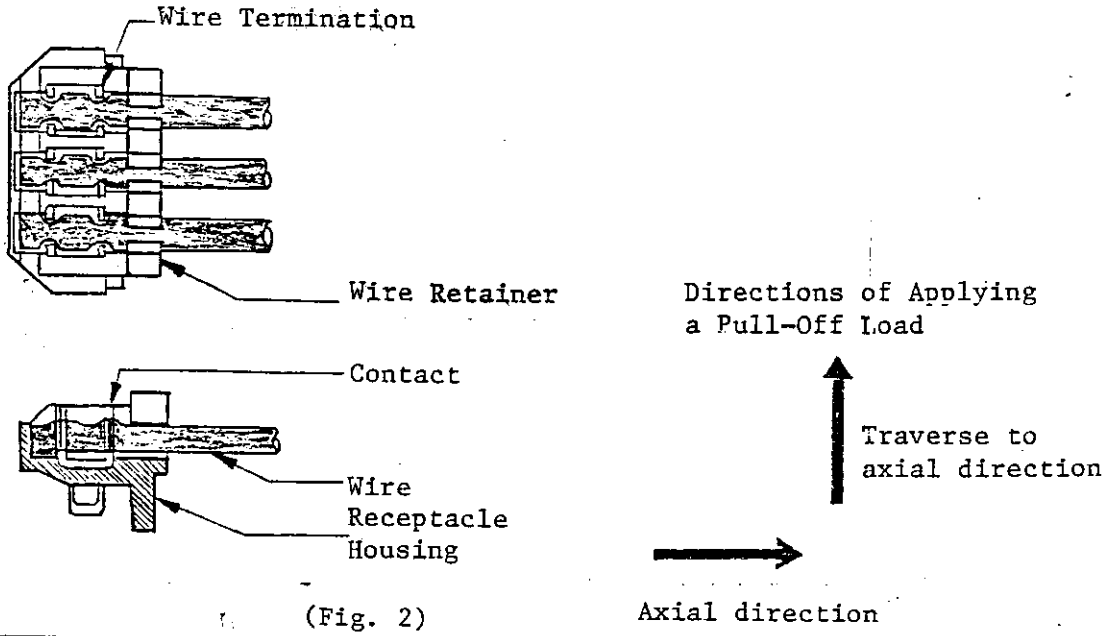
Termination of AMP-ULTREX 2mm Pitch M/T Type Connectors

1. Scope

This specification covers requirements for termination of the wires shown in Fig. 1 by the hand tool (Mini Press) or the automatic terminating machine (DECAM).

Product	Product No.	Applicable Wires	
Receptacle Assembly	173610 (2P thru 12P)	PVC Discrete Wires Tin Plated 7-Strand	AWG #26 (0.12 - 0.15 mm^2) (Insulation Diameter) 0.95mm - 1.10mm
			AWG #28 (0.08 - 0.09 mm^2) (Insulation Diameter) 0.88mm - 1.00mm

2. Name of Parts



(Fig. 2)

LTR	REVISION RECORD	DR	CHK	DATE
D	Revised RFA-1096		T.S	4/22'87
C	Revised RFA-1024		T.S	9/17'86
B	Revised RFA-940		T.S	11/25'85
A	Revised RFA-909	T.S	T.S	9/27'85
O	Released			6/4'85

DR Y. Nakamura 6/4'85
CHK Y. Fujita 6/4'85
APP

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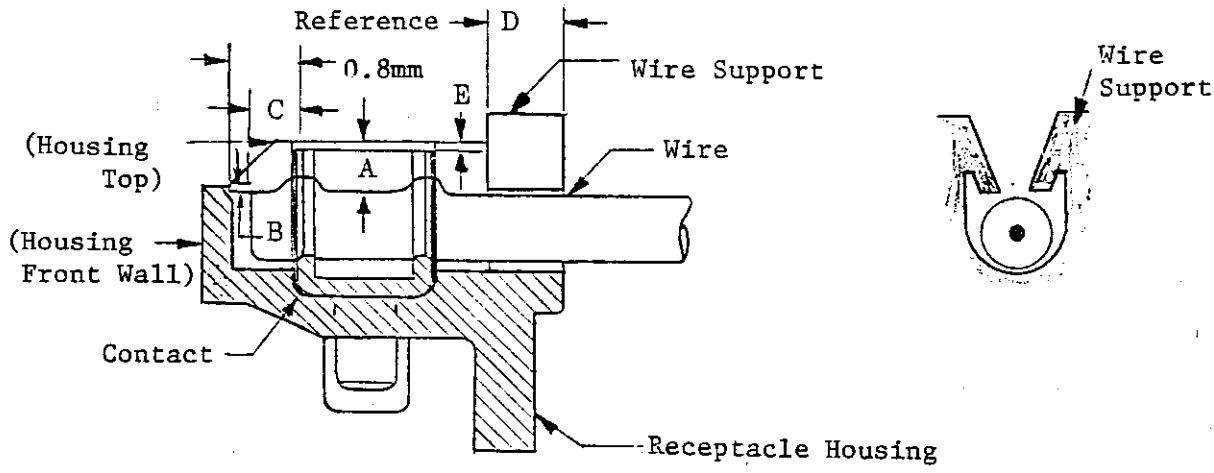
3. Termination Condition



(Fig. 3)

3.1 Wire Insertion Depths (A and B)

The distance "A" between the housing top and the tool mark on the wire insulation shall be in a range of 0.8 ± 0.1mm.

The wire end shall be below the top of the housing front wall. (B = 0 mm or over)

3.2 Wire End Protrusion Length (C)

The distance "C" between the edge of the contact and the tip of the appearing conductor shall be, 0.4 mm minimum.

3.3 Wire Support (D)

The wire shall be inserted completely into the wire support along the full thickness "D" of the support.

3.4 Contact Position (E)

After termination, the top of the contact shall not protrude above the top edge of the housing. (E = 0 mm or over)

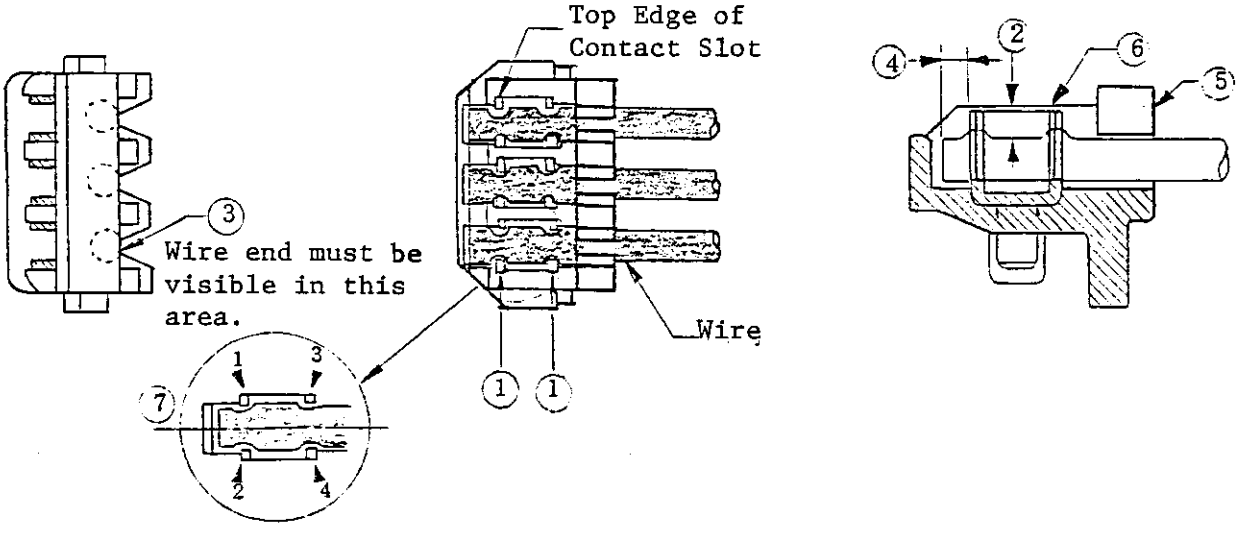
4. Wire Termination Tensile Strength

The traverse and axial wire tensile strengths, defined in Fig. 2, shall satisfy the values shown in the following table.

Wire Size	Tensile Strength (Traverse Direction)	Tensile Strength (Axial Direction)	Insulation Diameter
AWG #26	1.5 kg Min.	2.5 kg Min.	0.95mm - 1.10mm
AWG #28	1.0 kg Min.	1.5 kg Min.	0.88mm - 1.00mm

(Fig. 4)

5. Termination Condition Check Items



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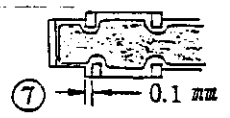
No.	Check Item	Criterion
①	Alignment of Contact Top Edges after Termination	· All the tops of the contacts shall be lined straight. · The maximum tolerance of misalignment between the contact top edges is 0.1 mm. 
②	Wire Insertion Depth	· The wire insertion depth shall be 0.8 $\pm$0.1mm.
③	Wire Tip Position	· The tips of wires shall not protrude above the housing front.
④	Wire End Protrusion Length	· The wire end protrusion length shall be 0.4 mm min.
⑤	Wire Support	· The wires shall be completely inserted into the support.
⑥	Contact Top Position	· The contact top shall not protrude outside the housing.
⑦	Conductor Position	· The terminated wires shall be located in the centers of the contacts. · The top four edges along the contact slot shall be visible evenly.
⑧	Damage to Housing and Contacts	· The terminated housing and contact slot section shall be free from the evidence of damage by the termination tool.

(Fig. 5)