

DESIGN OBJECTIVES

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JUNIOR POWER TIMER CONTACT FOR SINGLE WIRE SEALING

SCOPE

This specification covers the requirements for application of Junior Power Timer Contact P/N 929937-1/-3 and 929939-1/-3 for single wire sealing P/N 828905-1 and P/N 828904-1.

GENERAL

These contacts are suitable for 0.5-2.5 mm² wire, with single wire seal.

Each wire is inserted into a discrete wire seal prior to being crimped into the contact.

The insulation barrel is crimped so that the wire seal is gripped sufficiently to stop any movement of the seal on the wire.

The contacts are only suitable for single wires.

1. CRIMPING

The following information contains nomenclature, crimping conditions, crimp data for mini-applicators, installation of rubber seals on cables, correction or replacement of parts and checks.

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				DR R. Martini <i>R.M.</i> - 10 June 91	AMP AMP ITALIA S.p.A. Corso F.lli Cervi, 15 COLLEGNO (TORINO)
				CHK <i>Sjai</i> 11. 7. 91	
				APP.	LOC. NO I 114-20042
A	"Superseded by 114-18050-1 with ET00-0192-98 <i>M.P.</i>			16-JUL 198	REV. A
0	SHEET 1 OF 6		NAME APPLICATION SPECIFICATION FOR JUNIOR POWER TIMER CONTACT FOR SINGLE WIRE SEALING.		
REV LTR	REVISION RECORD	DR	DATE		

1.1 NOMENCLATURE

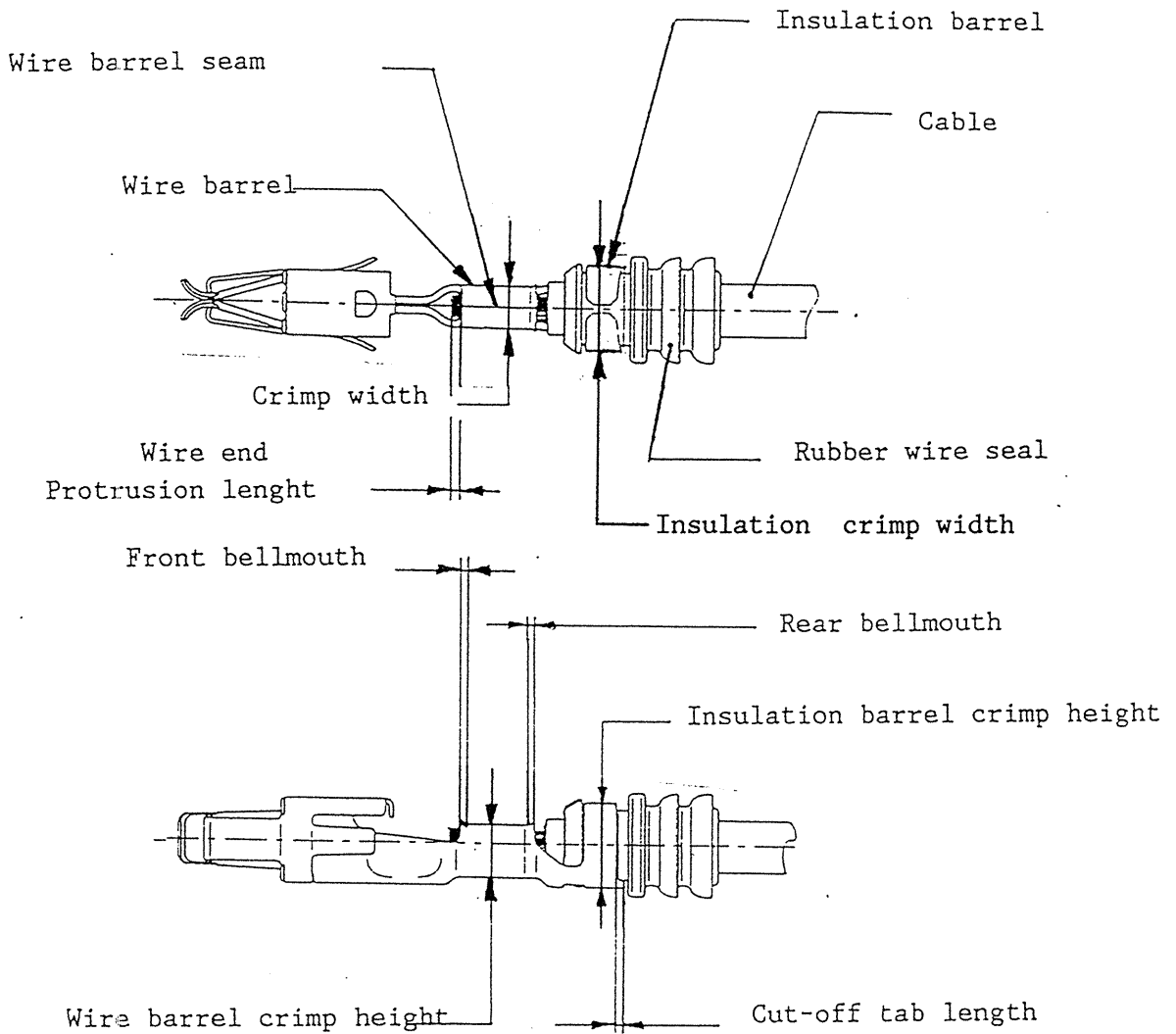


Fig. 1

2. CRIMPING CONDITIONS

Refere to nomenclature (Clause 1.1) see Fig. 1
Fig. 2 and Fig. 3.

- | | |
|---|------------------------------|
| 1. Cut-off tab length | 0,5 mm max |
| 2. _____ | 929937-1/-3 929939-1/-3 |
| Front bellmouth | not present 0,12x60°min |
| Rear bellmouth | 0,4x60° min 0,25x60°min |
| 3. Bend up | 5° max |
| Bend down | 5° max |
| Bend right | 5° max |
| Bend left | 5° max |
| Rolling | 5° max |
| 4. Cable end protrusion length (brush length) | 0,2 to 1,0 mm |
| 5. Insulation stripping length | 4,0 to 4,5 mm |
| 6. Wire barrel seam must be neatly closed. | |

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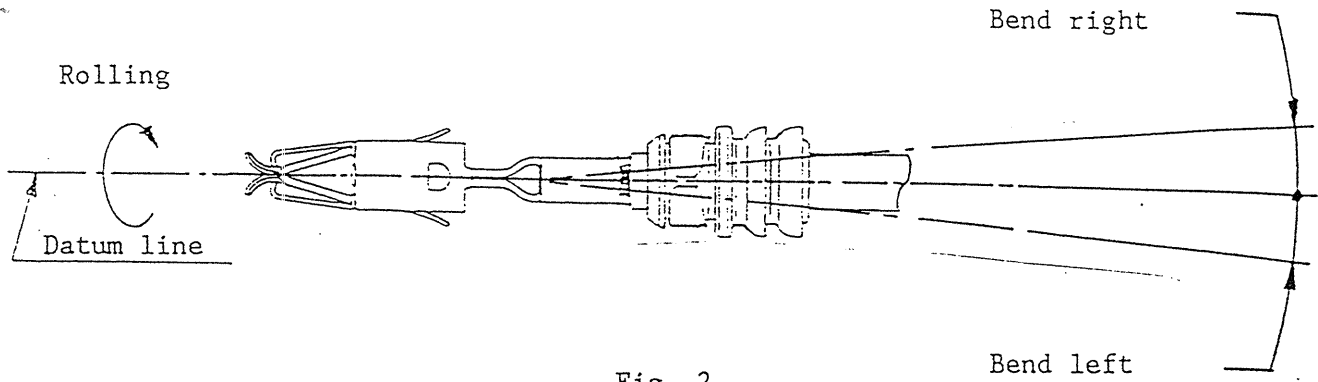


Fig. 2

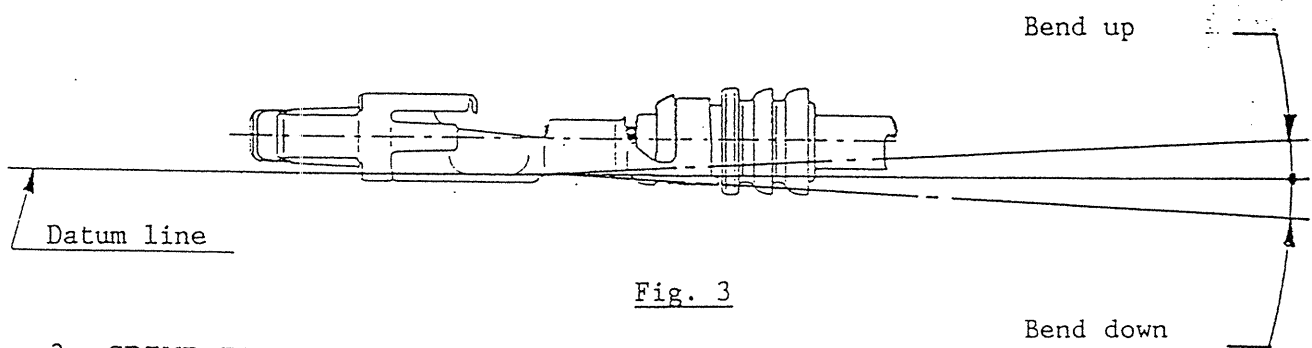


Fig. 3

3. CRIMP DATA

3.1 For applicator crimping see Fig. 7.

4. INSTALLATION OF RUBBER WIRE SEAL ON THE CABLE

When the rubber seal is installed on the cable, the end of the cable insulation shall be positioned +1,0 to -0,5 mm from the edge of the rubber seal, as shown in Fig. 4. This length is common regardless of cable size.

NOTE: Seals are supplied lubricated. This lubrication must not be removed.

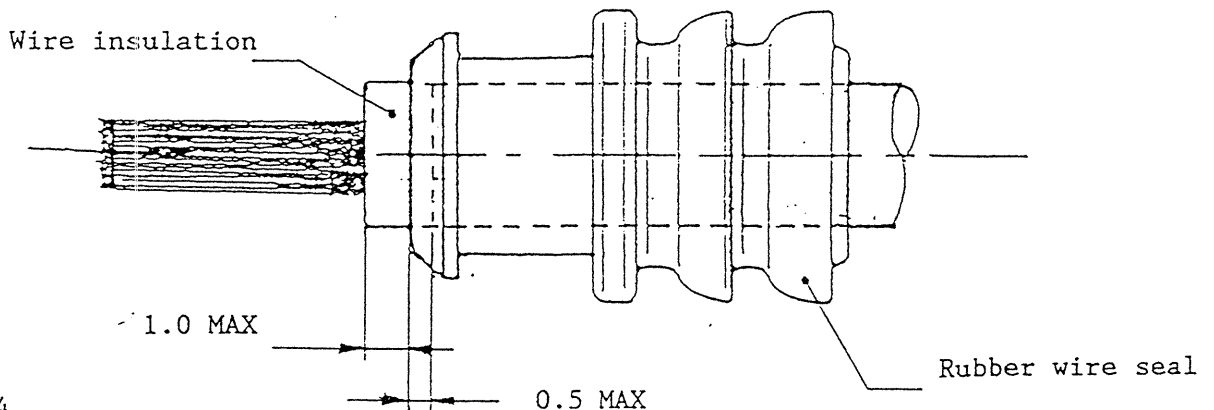


Fig. 4

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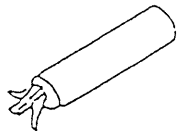
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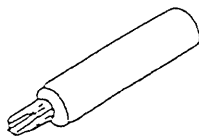
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5. CORRECTION OR REPLACEMENT OF PARTS

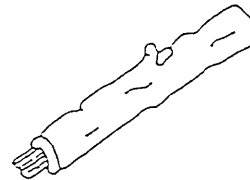
When defects and/or improper applications are found on parts to be installed, as shown in Figure 5, rework to reform properly, or replace with new part.



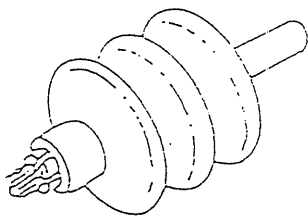
The end of the cut wire shall appear neat without disorder and bend of stranded conductor



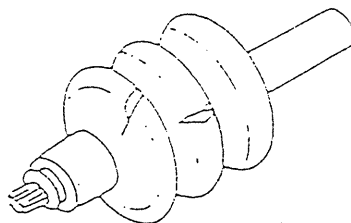
The conductor shall be free from nick, cut and scrape.



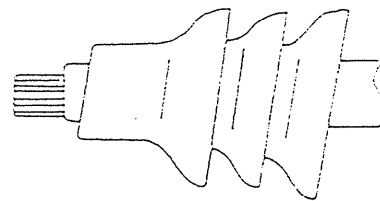
The wire insulation must have intact and smooth surface in a round form without damage, groove or recessed surface.



The end of the wire shall be straight without bend and disorder after it passed through the rubber plug. The bent wire shall be checked out.



The flanges of the rubber plug shall be free from cut and damage. Any plug having such defects shall be discarded, and replaced with new part.



Installation of rubber plug shall be done straight and evenly. If flanges are in tilt condition, the plug must be corrected so that flanges are perpendicular to contact axis.

Figure 5

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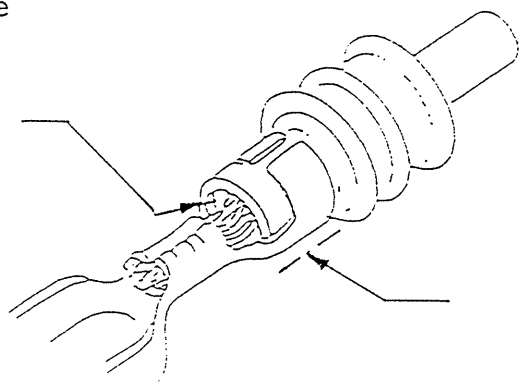
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5.1 After crimping, that part of the insulation of the cable that is inside the seal shall be in good condition and still be within the parameters shown in Figure 3. Check by visual inspection in the transition area (between wire and insulation barrel), as indicated in Figure 5.

After crimping, the rubber seal must protrude from the insulation crimp without damage



Check to see if the insulation is in the correct position.

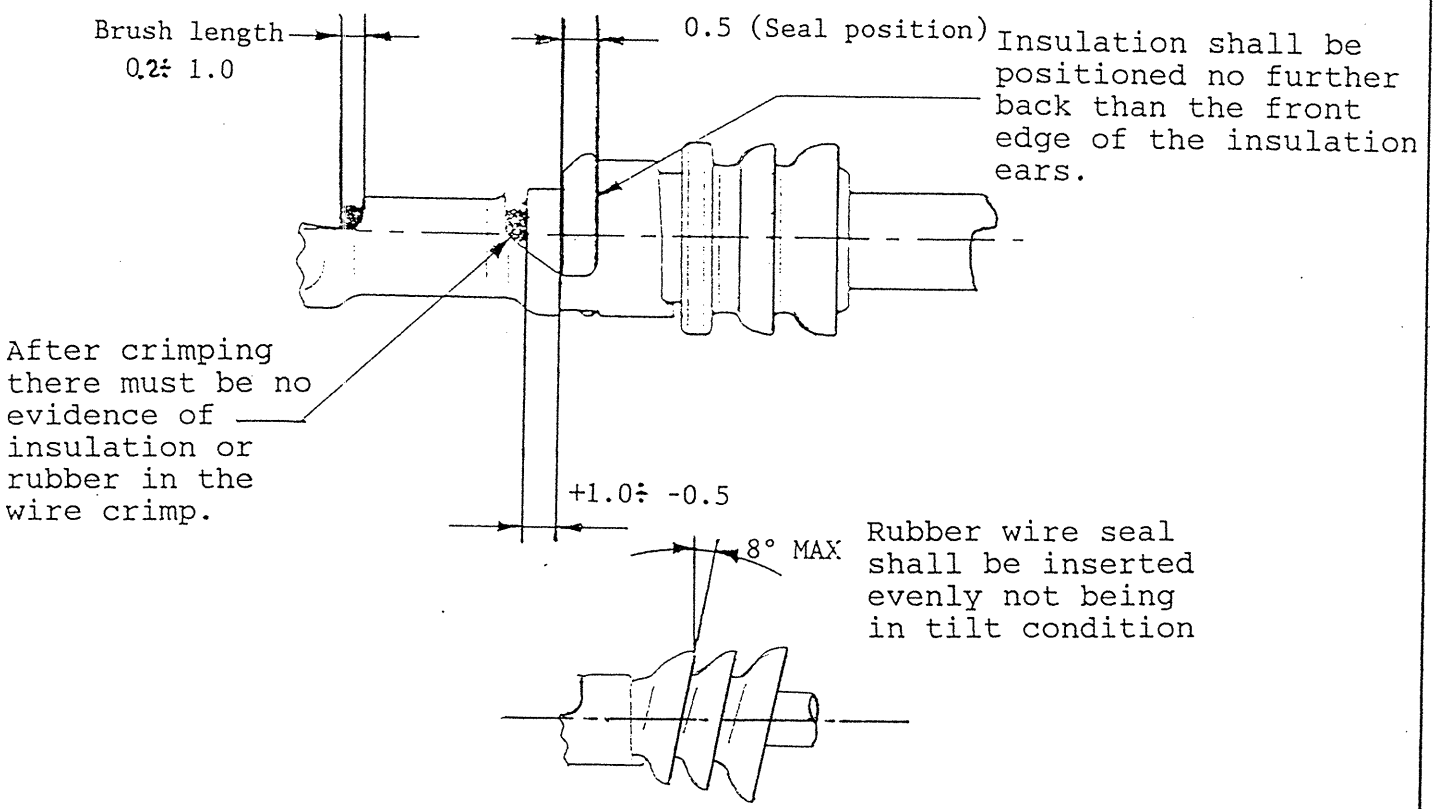


Fig. 6

5.2 Crimped contacts should appear as illustrated in Clause 1.1 (Nomenclature).

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PART. No.	WIRE SIZE mm ²	INS. DIA.	STRIP LENGTH	WIRE BARREL CRIMP				INS. BARREL CRIMP		
				HEIGHT ± 0.05	WIDTH (REF.)	TYPE CRIMPER	-	WIDTH (REF.)	TYPE CRIMPER	-
CONTACT 929939-1/-3	1.0	1.9-2.1	4.0-4.5	1.36	2.03	F	-	3.7	0	-
WIRE SEAL 828904-1	-	-	-	-	-	-	-	-	-	-
	0.5	1.5-1.7	4.0-4.5	1.18	2.03	F	-	3.7	0	-

PART. No.	WIRE SIZE mm ²	INS. DIA.	STRIP LENGTH	WIRE BARREL CRIMP				INS. BARREL CRIMP		
				HEIGHT ± 0.05	WIDTH (REF.)	TYPE CRIMPER	-	WIDTH (REF.)	TYPE CRIMPER	-
CONTACT 929937-1/-3	2.5	2.7-3.0	4.0-4.5	1.77	2.79	F	-	3.7	0	-
WIRE SEAL 828905-1	-	-	-	-	-	-	-	-	-	-
	1.5	2.2-2.4	4.0-4.5	1.51	2.79	F	-	3.7	0	-

(Dimensions are in mm)

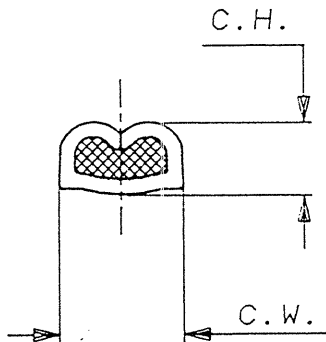


Fig. 7

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