

APPLICATION SPECIFICATION

1. SCOPE

This specification covers the requirements for application of AMP* .031 X .062 locking clip 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 see Figure 4 and 5.

2. NOMENCLATURE

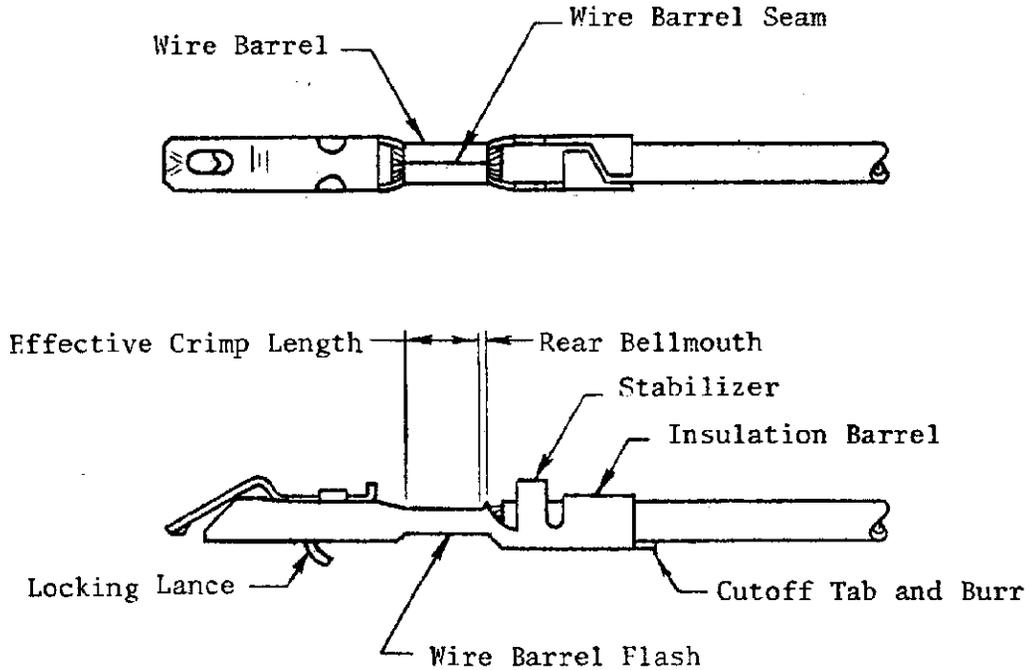


Figure 1

3. CRIMP AND DIMENSIONAL REQUIREMENTS

3.1. Wire Preparation

A. Strip Length

Insulation shall be stripped as indicated in Figure 4 and 5.

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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NO 114-25008

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				A
				NO 114-25008
				REV A
DIST		SHEET		CONTACT, .031 X .062 LOCKING CLIP, APPLICATION OF
25		1 OF 4		
A	Rev Fig 4 and 5	<i>CF</i>	10-4 -76	
LTR	REVISION RECORD	APP	DATE	

3.2. Carrier Cutoff Tab and Burr

A. Cutoff Tab

Cutoff tab shall not exceed .008.

B. Burr

Burr on cutoff tab shall not exceed .003.

3.3. Wire Barrel Crimp

A. Crimp Dimensions and Type

Crimp height, width and type shall be as shown in Figure 4 and 5.

B. Tensile Strength

Crimp tensile strength shall be as shown in Figure 4 and 5.

C. Effective Crimp Length

Effective crimp length shall be .090 min, and is defined as that portion of the barrel, excluding bellmouth, fully formed by the crimping tool.

D. Wire Barrel Flash

Wire barrel flash shall not exceed .008.

E. 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.

F. Bellmouth

Rear bellmouth length shall be .006 min.

G. Conductor Location

(1) End of the wire shall be flush with the front end of the wire barrel or extend .015 max after crimping.

(2) Both insulation and conductor shall be visible between the stabilizer barrel and wire barrel. Care shall be taken not to allow insulation to be crimped in the wire barrel.

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3.4. Insulation Barrel Crimp

A. Crimp Dimensions and Type

Crimp height, width and type shall be as shown in Figure 4 and 5.

B. Workmanship

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. Stabilizer

After crimping the stabilizer shall not be deformed.

3.7. Alignment

A. Straightness

- (1) The contact, including the cutoff tab and burr shall not be bent below the datum line more than the amount shown in Figure 2.

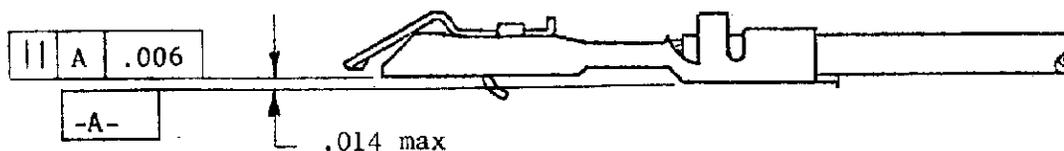


Figure 2

- (2) The side to side bending of the contact shall not exceed the limits specified in Figure 3.

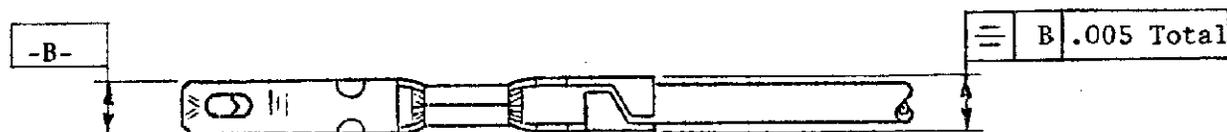


Figure 3

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 Size	Insulation Diameter	Strip Length	Wire Barrel Crimp			Insulation Barrel Crimp			
				Width	Height ±.002	Crimper Type	Tensile Strength, lbs	Width	Height, max	Crimper Type
87269	18	.050-.100	.156	.070	.048	F	25.0	.110	.105	0
	20							.110		
	22							.110		

Figure 4
Automatic Machine Wire Crimp Dimensions

Part No	Wire Size	Insulation Diameter	Strip Length	Wire Barrel Crimp			Insulation Barrel Crimp			Hand Tool Part No
				Width	Height ±.002	Crimper Type	Tensile Strength, lbs	Width	Height, max	
87278	18	.050-.100	.156	.070	.048	F	25.0	.110	.105	90308-1
	20						17.5			
	22						11.0			

Figure 5
Hand Tool Wire Crimp Dimensions



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