

Application Specification

Crimping of AMP-MODU MOD. IV, Crimp, Snap-in Contact

1. Scope:

This specification covers requirements for crimping of AMP-MODU MOD. IV contacts of the following part numbers.

2. Applicable Part Numbers:

Contact Numbers:

Strip Form	Loose Piece Form	Wire Size		Insulation Diameter (mm)
		mm <sup>2</sup>	(AWG)	
170230-1	170259-1	0.13-0.08	(#26-#28)	1.11 - 1.45
170231-1	170260-1	0.5 -0.2	(#20-#24)	1.4 - 2.1
170433-X	170434-X	0.13-0.08	(#26-#28)	0.89 - 1.27
170435-X	170436-X	0.5 -0.2	(#20-#24)	1.45 - 1.77
170437-X	170438-X	0.5 -0.2	(#20-#24)	1.17 - 1.45
171275-1/-2/-3	171276-1/-2/-3	0.5 -0.2	(#20-#24)	1.27 - 1.45

3. Nomenclature:

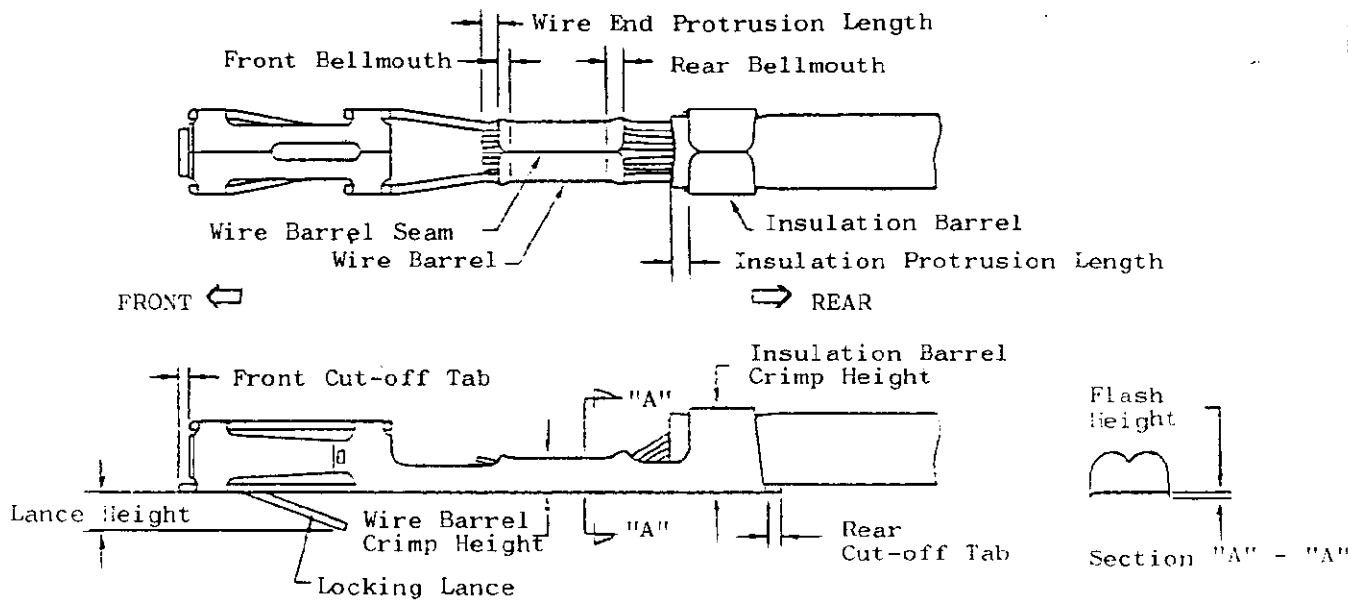


Fig. 1

Note: Figures shown below illustrate feature of insulation barrel of contact P/N 170231.



		DR <i>[Signature]</i> 2-9-81				AMP (Japan), Ltd.			
		CHK <i>[Signature]</i> 2-9-81				TOKYO, JAPAN			
C1	Revised RFA-1814	<i>[Signature]</i>	6-7-81	LOC	J A	NO	114-5026	REV	C1
C	Revised per RFA-602	<i>[Signature]</i>	10-23-82	NAME Application Specification					
C	Revised per RFA-472	<i>[Signature]</i>	2-8-81	Crimping of AMP-MODU MOD. IV, Crimp, Snap-in Contact					
REVISION RECORD		DR	CHK	DATE	SHEET 1 OF 4				

Wire Size		Wire Strand Composition		Calculated Cross-sectional Area (mm <sup>2</sup> )
mm <sup>2</sup>	(AWG)	Number of Strands	Diameter of a Strand (mm)	
0.08	(#28)	7	0.12	0.079
		7	0.127	0.089
0.14	(#26)	7	0.16	0.141
		19	0.12	0.215
0.2	(#24)	7	0.20	0.220
		11	0.16	0.221
		12	0.18	0.305
0.3	(#22)	17	0.16	0.342
		7	0.26	0.372
		19	0.18	0.483
0.5	(#20)	20	0.18	0.509

5. Crimp Data:

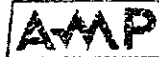
5.1 Applicator Crimp:

Terminal Number	Wire Size		Hand Tool Number & (IS Number)	Wire Width (mm)	Crimp Data		Disc Ltr.	Insulation Crimp	
	mm <sup>2</sup>	(AWG)			Type	Crimp Height (mm)		Width (mm)	Type
170230	0.08	(#28)	722724-2	1.07	"F"	0.62 ± 0.05	B	1.68	"F"
170433	0.14	(#26)				0.66 ± 0.05	A		
170231	0.3	(#22)	722725-2	1.40	"F"	0.78 ± 0.05	B	2.29	"O"
	0.5	(#20)				0.90 ± 0.05	A		
170435	0.2	(#24)	724974-2	1.40	"F"	0.69 ± 0.05	C	1.68	"F"
170437	0.3	(#22)				0.79 ± 0.05	B		
	0.5	(#20)				0.89 ± 0.05	A		
171275	0.2	(#24)	722755-2	1.40	"F"	0.69 ± 0.05	C	1.575	"O"
	0.3	(#22)				0.79 ± 0.05	B		
	0.5	(#20)				0.89 ± 0.05	A		

5.2 Hand Tool Crimp:

170259	0.08	(#28)	721580-1 (IS-064J)	1.07	"F"	0.55 - 0.65	A	1.68	"F"
	0.13	(#26)				0.61 - 0.71	B		
170434	0.08	(#28)	724744-1 (IS-134J)	1.40	"F"	0.52 - 0.65	A	1.68	"F"
	0.13	(#26)							
170436	0.2	(#24)							
170438	0.3	(#22)							
	0.5	(#20)							
170260	0.3	(#22)	721581-1 (IS-065J)	1.40	"F"	0.68 - 0.78	A	2.29	"O"
	0.5	(#20)				0.83 - 0.93	B		
171276	0.2	(#24)	724647-2 (IS-7538)	1.40	"F"	0.775 ± 0.05	24-20	1.575	"O"
	0.3	(#22)							
	0.5	(#20)							

SHEET



AMP Japan, Inc  
TORONTO, CANADA

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LOC J

A

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Snap-in Contact

5.2 Requirements for Crimped Shape of Contact:

Crimped shaped of contact must comply with the requirements specified in Table 3, and crimp tensile strength must meet the value specified in Table 4.

No.	Check Points	Crimping Application					
		170230 170433	170259 170434	170231 170435 170437	170260 170436 170438	171275	171276
		Appli- cator	Hand Tool	Appli- cator	Hand Tool	Appli- cator	Hand Tool
1	Insulation Stripping Length	3.5 - 4.5 mm		3.5 - 4.5 mm		3.5-4.4mm	3.9-4.8mm
2	Limits of Deviation after Crimping	Bend-Up	3.5° max.	3.0° max.	3.0° max.	3.0° max.	3.0° max.
		Bend-Down	2.5° max.	3.0° max.	3.0° max.	3.0° max.	3.0° max.
		Twisting	5.0° max.	5.0° max.	5.0° max.	5.0° max.	5.0° max.
		Rolling	3.0 max.	Not Specified	Not Specified	Not Specified	Not Specified
3	Cut-off Tab Length	Front: 0.3 mm max.			Rear: 0.5 mm max.		
4	Bellmouth Length	Front	Not Specified				
		Rear	0.2 mm min.	Must be visually identified.	0.2 mm min.	Must be visually identified.	0.2 mm min.
5	Wire End Protrusion Length	0 - 0.8 mm					
6	Wire Insulation Protrusion Length	0.7 mm (Ave.)	Not Specified	0.7 mm (Ave.)	Not Specified	0.7 mm (Ave.)	Not Specified
7	Wire Barrel Seam Closure	Seam must appear firmly closed without allowing any strands seen or sticking out from between the barrel.					
8	Flash Height	0.3 mm max.					


Table 3

5.3 Crimp Tensile Strength:

Crimp tensile strength must be not less than the value specified in Table 4.

Wire Size		Crimp Tensile Strength	
mm <sup>2</sup>	(AWG)	kg (min)	lbs. (min.)
0.08	(#28)	1.2	( 2.65)
0.14	(#26)	1.8	( 3.97)
0.2	(#24)	3.0	( 6.61)
0.3	(#22)	5.0	(11.02)
0.5	(#20)	8.0	(17.64)

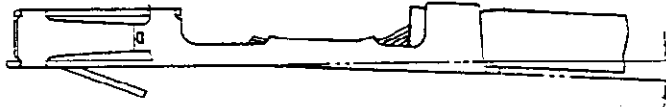
Table 4

SHEET				AMP (Japan), Ltd. TOKYO, JAPAN	
3 OF 4		LOC J	NO A	114-5026	
NAME		Application Specification Crimping of AMP-MODU* MOD. IV, Crimp Snap-in Contact			
				REV C1	

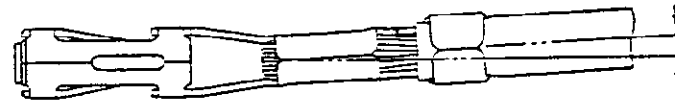
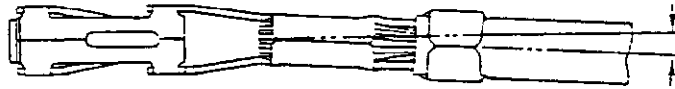
Bend-Up



Bend-Down



Twisting



Rolling

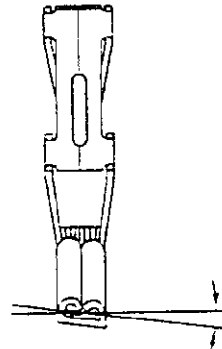
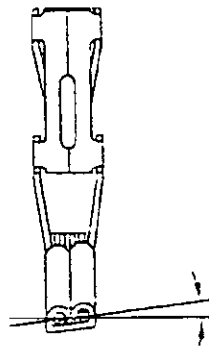
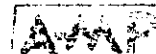


Fig. 3 Deformation of Contact after Crimping

SHEET				AMP Security Classification	
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		J	A	C1	
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