

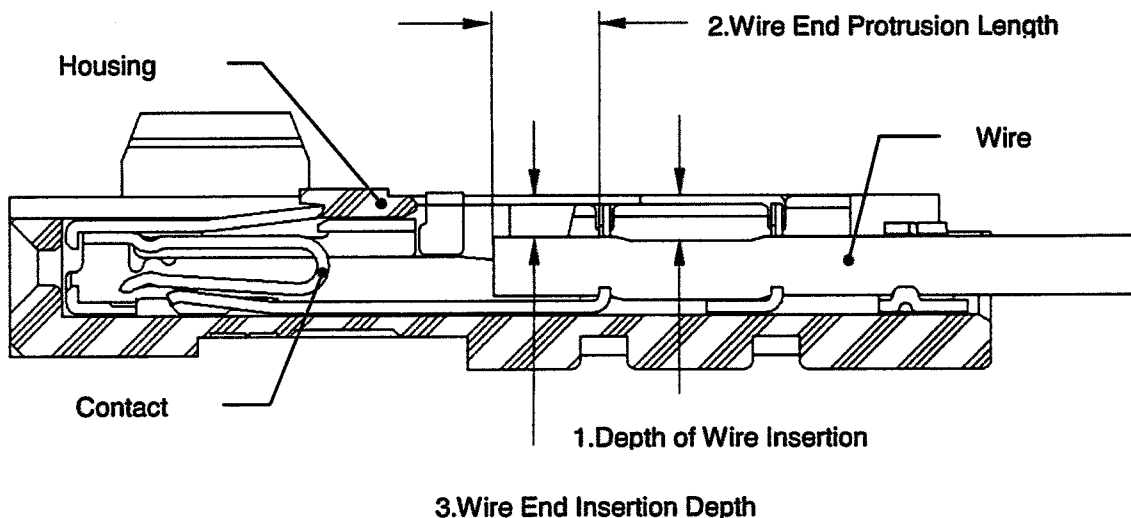
The performance of applicable product is guaranteed only when processed by proper application tooling described in this specification and/or AMP recognized ones.

1. Scope:

This specification covers the requirements for Insulation Displacement Termination of 025 IDC Connectors.

2. Product Names and Part Numbers

2.1 Product Names



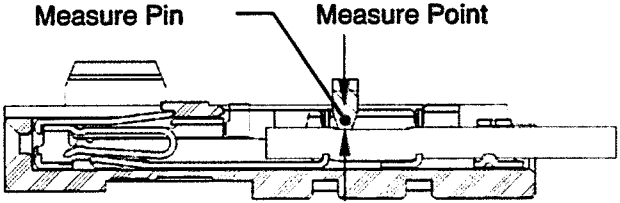
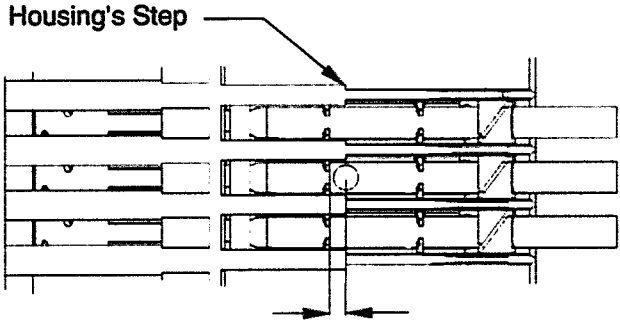
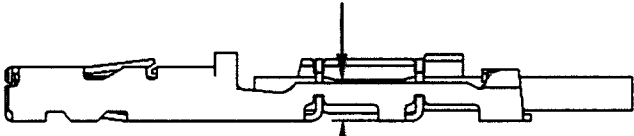
2.2 Part Numbers

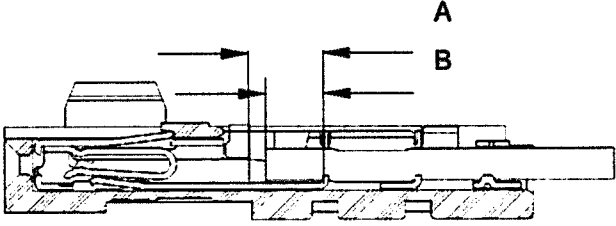
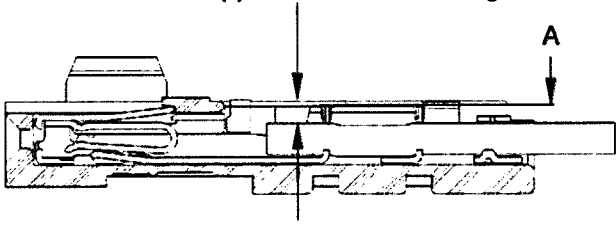
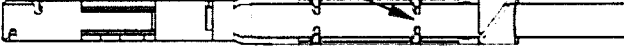
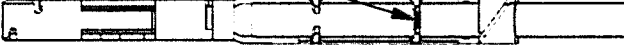
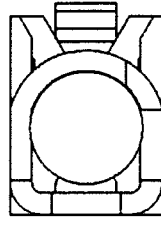
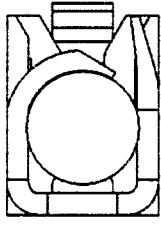
Name	Part Number*	Applicable Wire
8Positions Female Assembly	1318690	IDCUS,CAVUS, MCVUS 0.3~0.5mm ²
20Positions Female Assembly	1318691	

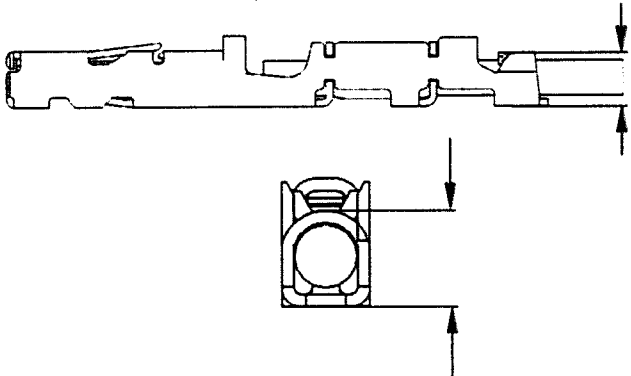

* Note :Part number is consisted from listed base number and 1 digit numeric prefix and suffix with dash. Refer to catalog or customer drawing for specific part numbers for each base number. When prefix is zero, zero and dash are omitted.

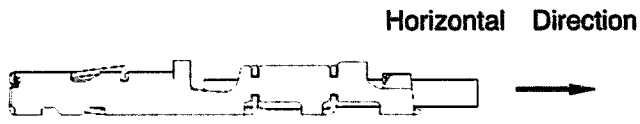
3.Requirement and Standard Criteria for Acceptance

Note: For termination tooling call local AMP.

No.	Check Item	Requirement and Standard Criteria for Acceptance
1	Depth of Wire Insertion	<p>Wire insertion depth shall be controlled within $0.7^{+0.3}_0$mm, when measured from the top edge of housing to the tool mark on the inserted wire.</p>   <p>Measure Point (0.7~1.1mm From Slot)</p> <p>Contact Only: $1.9^{0}_{-0.3}$mm From Bottom Surface</p>  <p>Note 1)Measure Tool Head Shapes, $\phi 0.5 \sim \phi 1$mm Measure Pressure 1.96N MAX</p>

No.	Check Item	Requirement and Standard Criteria for Acceptance
2	Wire End Protrusion Length	<p>Wire Protrusion B size above the half with A size(1.5~3.0mm)</p> 
3	Wire End Insertion Depth	<p>Insulation of wire end shall be inserted lower than the A surface of housing. (0.5mmMIN from upper surface of housing)</p> 
4	Exposure of Wire Conductor	<p>Insulation is tightly closed OK</p>  <p>Broken hole of insulation NG</p> 
5	Wire Retention over the Cavity	<p>Inserted wires shall be retained in hold under insulation Barrel of the contact.</p> <div style="display: flex; justify-content: space-around;"> <div style="text-align: center;"> <p><u>Acceptable</u></p>  <p>OK</p> </div> <div style="text-align: center;"> <p><u>Rejectable</u></p>  <p>NG</p> </div> </div>

No	Check Item	Requirement and Standard Criteria for Acceptance													
6	Insulation Barrel Height	<p>Barrel Height : 1.8 ± 0.1mm</p> <p>But Item 9 tensile strength of wire termination satisfy.</p> <p>(Reference)</p> <table border="1" data-bbox="802 533 1382 831"> <thead> <tr> <th>Wire</th> <th>Insulation Diameter mm</th> <th>Barrel Height mm</th> </tr> </thead> <tbody> <tr> <td rowspan="2">0.3 mm²</td> <td>$\phi 1.10$</td> <td>$1.80^{+0.05}_{-0.10}$</td> </tr> <tr> <td>$\phi 1.15$</td> <td>$1.85^{+0.05}_{-0.10}$</td> </tr> <tr> <td rowspan="2">0.5 mm²</td> <td>$\phi 1.30$</td> <td>$1.80^{+0.05}_{-0.10}$</td> </tr> <tr> <td>$\phi 1.35$</td> <td>$1.85^{+0.05}_{-0.10}$</td> </tr> </tbody> </table>  <p>Note: Measure at Caliper</p>	Wire	Insulation Diameter mm	Barrel Height mm	0.3 mm ²	$\phi 1.10$	$1.80^{+0.05}_{-0.10}$	$\phi 1.15$	$1.85^{+0.05}_{-0.10}$	0.5 mm ²	$\phi 1.30$	$1.80^{+0.05}_{-0.10}$	$\phi 1.35$	$1.85^{+0.05}_{-0.10}$
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7	Position Uniformity of Upper Edges of Contact Slot.	<p>After termination, deviation not exceeding Contact thickness(0.25mm)is allowable.</p> 													
8	Damage of Contact and Housing	<p>After termination, contact slot shall appear intact without evidence of tool mark of insertion tooling.</p> <p>However, tool mark and scraping on contact insulation Barrel shall be allowable.</p> <p>(Plated surface is not peeled off)</p>													

No	Check Item	Requirement and Standard Criteria for Acceptance
9	Tensile strength of wire termination	<p>0.3 mm²=55N MIN 0.5 mm²=80N MIN</p> <p>-Procedures- Measure the force. Operation Speed : 100mm/min.</p> 
10	After termination, opening of contact	After termination, about the opening of contact permits the range which doesn't bring about hinderance to mating-unmating contact.
11	Others	Any contact once terminated, shall be not reused.

4.Applicable Wire

Wire Size	No of conductors/ Diameter of a Conductor	Calculated Cross-sectional Are (mm ²)	Insulation Diameter (mm)	
			Nominal	Max
IDCUS,CAVUS,MCVUS 0.3 mm ²	7/0.26	0.37	1.1	1.2
IDCUS,CAVUS,MCVUS 0.5 mm ²	7/0.32	0.56	1.3	1.4