

APPLICATION SPECIFICATION

1. SCOPE

This specification covers the requirements for application of AMP-LEAF* 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 5 and 6.

2. NOMENCLATURE

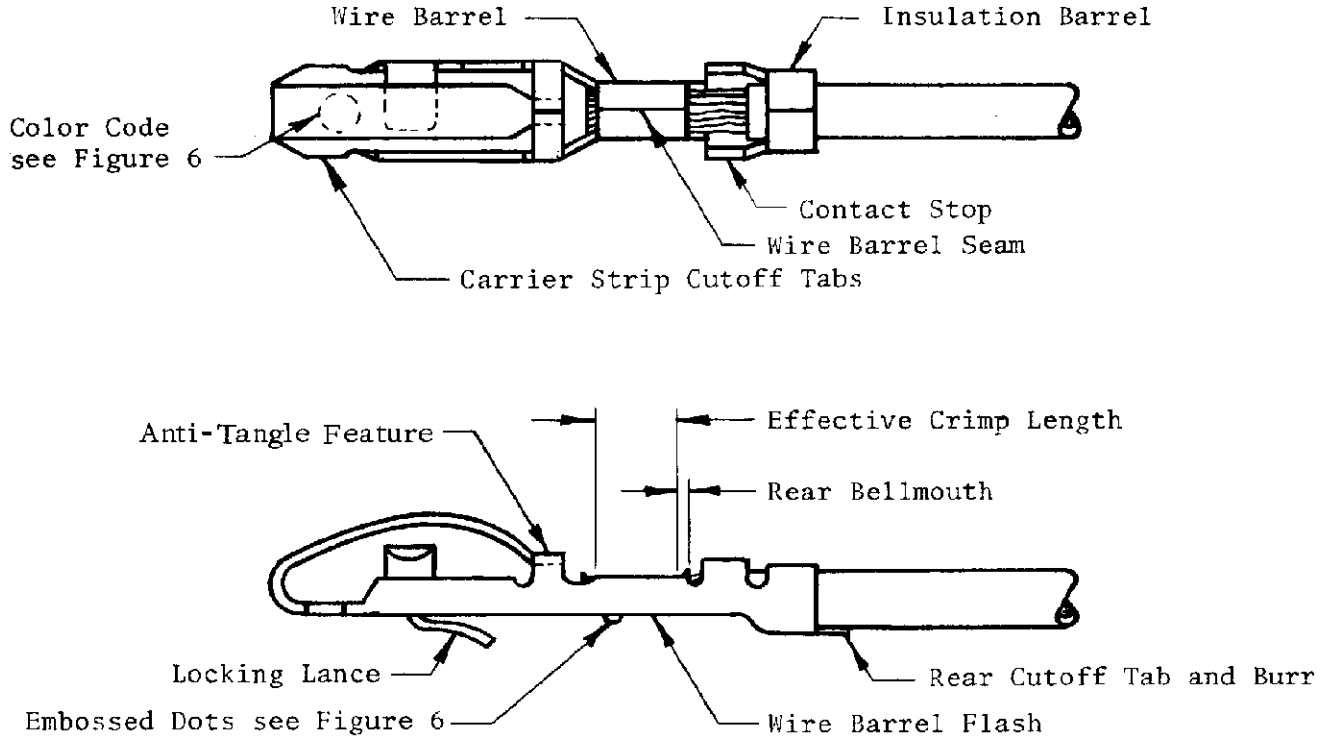


Figure 1

3. CRIMP AND DIMENSIONAL REQUIREMENTS

3.1. Wire Preparation


A. Strip Length

Insulation shall be stripped as indicated in Figure 5 and 6.

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NO 114-9003

				DR <i>C. E. Fitz</i> 9-4-75	 AMP INCORPORATED Harrisburg, Pa.			
				CHK <i>D. Bushey</i> 9-4-75				
				APP <i>R. Showman</i> 9-4-75	LOC B	A	NO 114-9003	REV 0
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DIST	0	Was 108-9205						
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B. Workmanship

Reasonable care shall be taken not to nick, scrape or cut any strands or the solid wire during the stripping operation.

3.2. Rear Cutoff Tab and Burr

A. Cutoff Tab

Cutoff tab shall not exceed .015.

B. Burr

Burr on cutoff shall not exceed .003.

3.3. Carrier Strip Cutoff Tabs

Carrier strip cutoff tabs shall not exceed the limits specified in Figure 2. There shall be no damage to the contact during the cutoff operation.

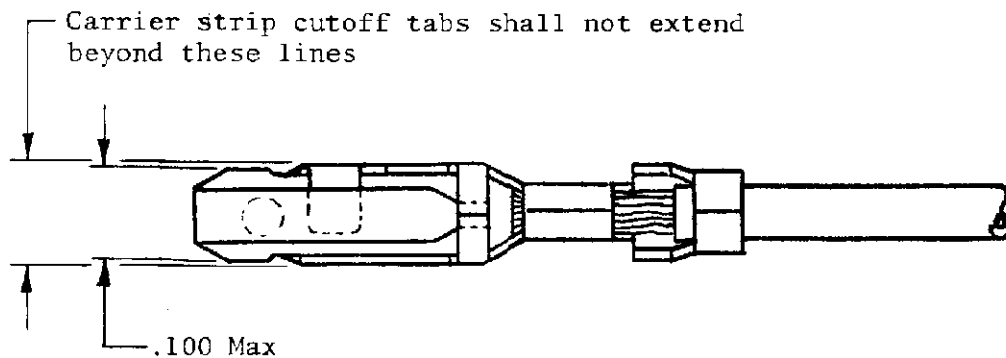


Figure 2

3.4. Wire Barrel Crimp

A. Crimp Dimensions and Type

Crimp height, width and type shall be as shown in Figure 5 and 6, and are based on average wire size in each range.

B. Effective Crimp Length

Effective crimp length shall be .085 min, and is defined as that portion of the barrel, excluding bellmouth, fully formed by the crimping tool.

C. Wire Barrel Flash

Wire barrel flash shall not exceed .005.



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D. 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.

E. Bellmouth

(1) Rear bellmouth length shall be .005 min.

F. Conductor Location

- (1) End of the wire shall be flush with the front end of the wire barrel or extend .010 max after crimping.
- (2) Both insulation and conductor shall be visible between the insulation barrel and wire barrel. Care shall be taken not to allow insulation to be crimped in the wire barrel.

3.5. Insulation Barrel Crimp

A. Crimp Type

Crimp type shall be as shown in Figure 5 and 6.

B. Workmanship

Reasonable care shall be taken not to cut or break the insulation during the crimping operation.

3.6. Locking Lance

Locking lance shall not be deformed.


3.7. Contact Stop

A. Width

Contact stop width shall be .105 - .114, when measured nearest the wire barrel.

B. Height

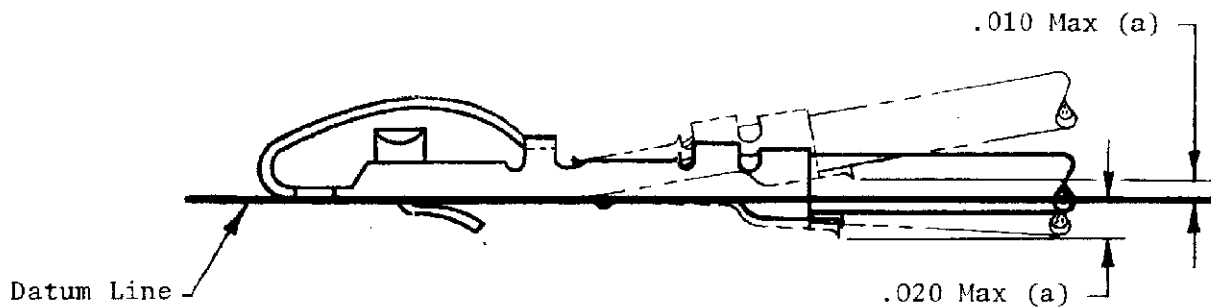
Contact stop height shall not exceed .114, when measured from the datum line shown in Figure 3.

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3.8. Alignment

A. Straightness

- (1) The contact, including the cutoff tab and burr shall not be bent above or below the datum line more than the amount shown in Figure 3.



- (a) Except PN 42702, 42702LP, 42839, 60029, 66063, 583204, 583267, 583267LP, 583268, 583586, 583990 and 583992 which may be bent .020 max above the datum line and .015 max below.

Figure 3

- (2) The side to side bending of the contact shall not exceed the limits specified in Figure 4.

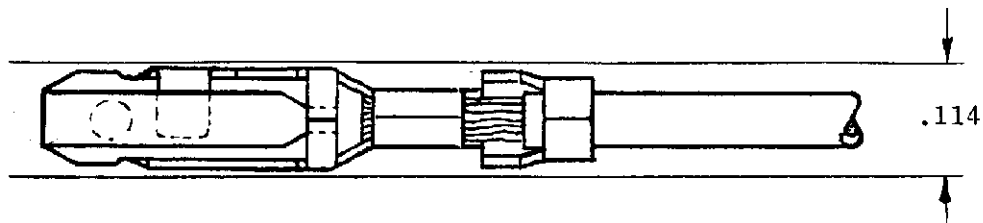



Figure 4

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B. Twist or Roll


There shall be no twist or roll in crimped portion that will impair usage of the contact.

Part No	Wires		Strip Length	Wire Barrel Crimp		Insulation Barrel Crimp							
	No	Size		Width	Height ±.002		Crimper Type						
42702	1	26	.156 .125	.055	.029	F	F or O						
60029 (a)		24			.030								
66063 (a)		22			.033								
583204		26			.032								
583267													
583586													
42717	1	22		.156 .125	.062			.037	F	F or O			
60030 (a)		20						.041					
583271		18						.047					
583361		24						.039					
583555		22	.043										
60151	2	20	.156 .125		.080	.054	F	F or O					
583269		18				.063							
583622													
60151	1	16			.156 .125	.090					.052	F	F or O

(a) Without anti-tangle feature.

Figure 5

Automatic Machine Wire Crimp Dimensions

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Part Number		Wires		Strip Length	Wire Barrel Crimp		Color Code	Insulation Barrel Crimp	Hand Tool Part No	
		With Anti-Tangle	Without Anti-Tangle		No	Size			Height +.002	Crimper Type
583989 583994	42717 LP 42840 583271 LP 583272	2	22				Green (a) Green (a) Green (b) Green (b)		90017-2 or 90017-2	90017 or 90017-2
		1	18							
		1	22							
		1	20							
583990 583992	42702 LP 42839 583267 LP 583268	1	26				Orange		90028-2 or 90028-2	90028 or 90028-2
		1	24							
		1	22							
583989 583994	42717 LP 42840 583271 LP 583272	2	24	.156 / .125			Green	F or O	90028-2 or 90028-2	90028 or 90028-2
		2	22							
		1	20							
		1	18							
583991 583993	60151 LP 66029 583269 LP 583270	2	18				Violet		90031-6 or 90031-6	90031 or 90031-6
		1	20							
583994 583989	42717 LP 42840	1	20				Green		90101-2 or 90101-2	90101 or 90101-2
		2	20							
583991 583993	60151 LP 66028 583269 LP 583270	1	16				Violet		90031-5 or 90031-7	90031-5 or 90031-7
		2	20							
		1	16							

(a) Coded by 2 embossed dots on bottom of wire barrel.
 (b) Coded by 1 embossed dot on bottom of wire barrel.

Figure 6
Hand Tool Wire Crimp Dimensions



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