

3.2. Carrier Cutoff Tab and Burr

A. Cutoff Tab

Cutoff tab shall not exceed .020.

B. Burr

Burr on cutoff shall not exceed .005.

3.3. Wire Barrel Crimp

A. Crimp Dimensions and Type

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

B. Effective Crimp Length

Effective crimp length shall be .250 minimum, 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 .020.

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 .030 min.
- (2) Front bellmouth length shall be .030 max.

F. Conductor Location

- (1) End of the wire shall be flush with the front end of the wire barrel or extend .093 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.

3.4. Insulation Barrel Crimp

A. Crimp Dimensions and Type

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

B. Workmanship

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



AMP INCORPORATED
Harrisburg, Pa.

SHEET
2 OF 4

LOC B	NO A	NO 114-1004	REV 0
----------	---------	----------------	----------

NAME
CONTACT, HIGH CURRENT CONNECTOR,
APPLICATION OF

3.5. Locking Lance

Locking lance shall not be deformed.

3.6. Alignment

A. Straightness

- (1) The contact shall not be bent above or below the datum line more than the amount shown in Figure 2.

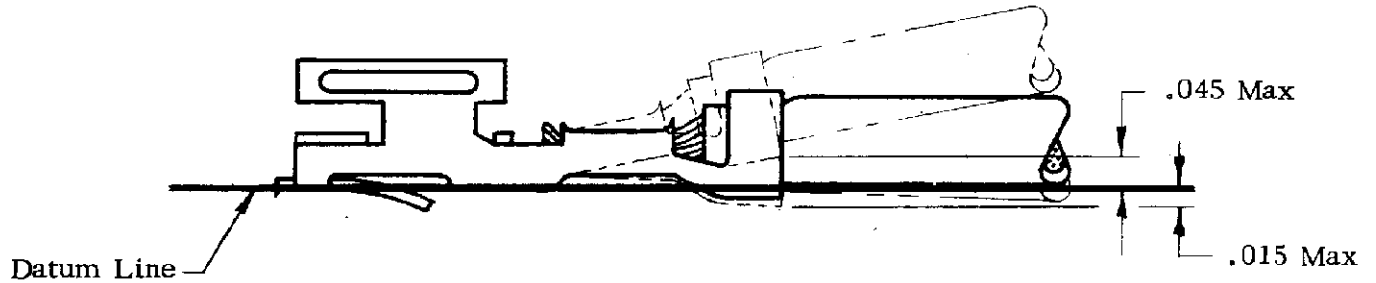


Figure 2

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

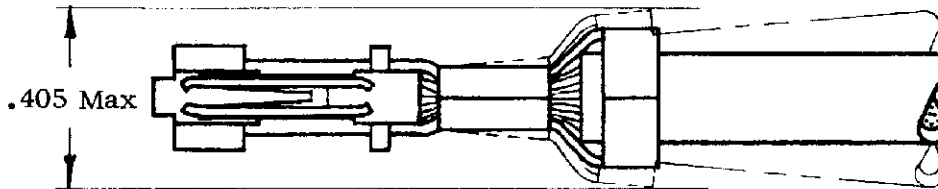



Figure 3

B. Twist or Roll

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

SHEET <u>3</u> OF <u>4</u>	 AMP INCORPORATED <i>Harrisburg, Pa.</i>		
	<small>LOC</small> B	<small>NO</small> A	<small>NO</small> 114-1004
<small>NAME</small> CONTACT, HIGH CURRENT CONNECTOR, APPLICATION OF			

Part No	Wires		Insulation Diameter	Strip Length ±.031	Wire Barrel Crimp			Insulation Barrel Crimp		
	No	Size			Width	Height ±.002	Crimper	Type	Width	Crimper
350650	1	8	$\frac{.360}{.200}$.375	.180	.148	F	Curved	F	Curved
	1	10								
	1	12								
350651	1	12	$\frac{.260}{.150}$.375	.140	.103	F	Curved	F	Curved
	1	14								
	1	16								

Figure 4

Automatic Machine Wire Crimp Dimensions



AMP INCORPORATED
Harrisburg, Pa.

SHEET
4 OF 4

LOC B NO 114 - 1004 REV 0

NAME
CONTACT, HIGH CURRENT CONNECTOR,
APPLICATION OF