

NO 114-1011

3.2. Carrier Cutoff Tab

A. Cutoff Tab

- (1) Front cutoff tab shall not exceed .008 and shall be wiped upward toward the centerline on pin contacts.
- (2) Rear cutoff tab shall not exceed .015.

3.3. Wire Barrel Crimp

A. Crimp Dimensions and Type

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

B. Tensile Strength

Crimp tensile strength shall be as shown in Figure 4.

C. Wire Barrel Seam

The wire barrel seam shall be closed adequately to confine all strands of the wire. There shall be no loose wire strands or wire strands embedded in the outside of the wire barrel.

D. Bellmouth

- (1) Rear bellmouth length shall be .005-.030.
- (2) Front bellmouth length shall be .010 maximum.

E. Conductor Location

- (1) End of the wire shall be flush with the front end of the wire barrel or extend .047 maximum 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 Figures 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.

		AMP INCORPORATED Harrisburg, Pa.		SHEET	
				2 OF 4	
LOC	A	NO	114-1011	REV	A
NAME					
CONTACT, PIN AND SOCKET, MATE-N-LOK, DUAL LANCE, APPLICATION OF					

3.6. Embossments

Embossments on pin contacts shall pass through a .117 maximum diameter circle and a .145 maximum diameter circle for socket contacts.

3.7. Alignment

A. Axial Concentricity

- (1) Crimped insulation barrel of single conductor crimped contacts shall fall into an area defined by a .160 diameter circle whose center is the centerline of the contact as shown in Figure 2.

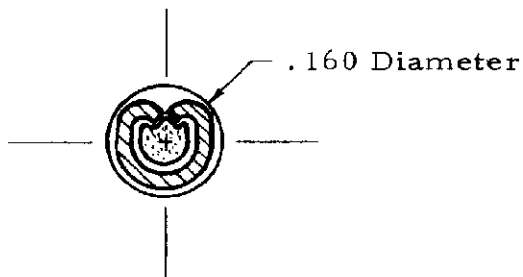


Figure 2

- (2) Crimped insulation barrel of 2 conductor crimped contacts shall fall into an area defined by a .210 by .155 rectangle whose vertical center is the centerline of the contact and whose horizontal center is .030 above the centerline of the contact as shown in Figure 3.

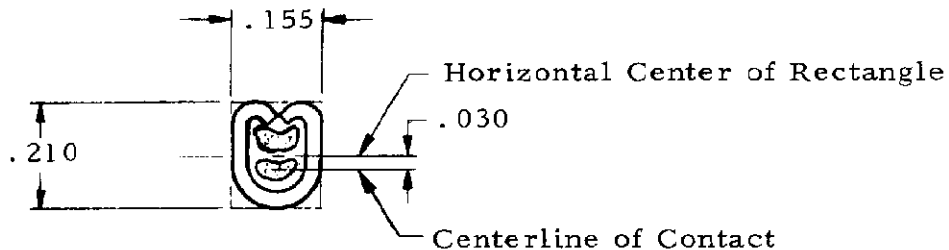



Figure 3

B. Twist or Roll

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

SHEET 3 OF 4	 AMP INCORPORATED Harrisburg, Pa.		
	LOC B	A	NO 114-1011
NAME CONTACT, PIN AND SOCKET, MATE-N-LOK, DUAL LANCE, APPLICATION OF			

Part Numbers		Wires		Insulation Diameter, maximum	Strip Length	Wire Barrel Crimp				Insulation Barrel Crimp	
Pin	Socket	No	Size			Width	Height ±.002	Type Crimper	Tensile Strength, lb min	Width	Type Crimper
350218	350217	1	20	.130	$\frac{.187}{.156}$.090	F	.25	.130	F	F
		1	18					.30			
		1	16					.30			
		1	14					.35			
350513	350512	2	18	(2) .115 stacked	$\frac{.187}{.156}$.090	F	—	.130	F	F
		1	18					.14			
350561	350560	1	24	.100	$\frac{.187}{.156}$.070	F	.20	.100	F	F
		1	22					.25			
		1	20					.30			
		1	18								

Figure 4 Automatic Machine Wire Crimp Dimensions

Part Numbers		Wires		Insulation Diameter, maximum	Strip Length	Wire Barrel Crimp				Insulation Barrel Crimp		Hand Tool Part No
Pin	Socket	No	Size			Width	Height ±.002	Type Crimper	Width	Type Crimper	Type Crimper	
350547	350546	1	20	.130	$\frac{.187}{.156}$.090	F	.050	.130	F	F	90296-1
		1	18					.050				
		1	16					.063				
		1	14					.063				
350549	350548	2	18	(2) .115 stacked	$\frac{.187}{.156}$.090	F	.073	.130	F	F	90297-1
		1	18					.066				
350690	350691	1	24	.100	$\frac{.187}{.156}$.090	F	.040	.100	F	F	90300-1
		1	22					.040				
		1	20					.046				
		1	18					.046				

Figure 5 Hand Tool Wire Crimp Dimensions



SHEET 4 OF 4

LOC B NO 114-1011 REV A

NAME CONTACT, PIN AND SOCKET, MATE-N-LOK, DUAL LANCE, APPLICATION OF