APPLICATION SPECIFICATION

1. SCOPE

This specification covers the requirements for application of AMP* relay receptacle 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 4 and 5.

2. NOMENCLATURE

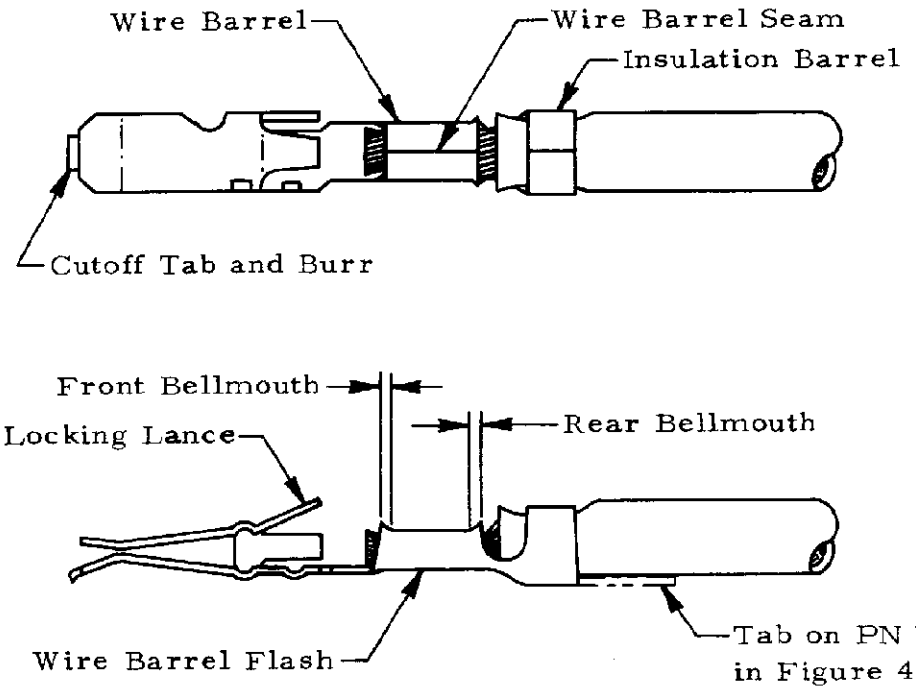

Figure 1

3. CRIMP AND DIMENSIONAL REQUIREMENTS

3.1. Wire Preparation

A. Strip Length

Insulation shall be stripped as indicated in Figures 4 and 5.

B. Workmanship

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

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LTR	REVISION RECORD	APP	DATE

DIST 1

DR D. Davis 9-12-77
CHK M. Schaller 9/12/77
APR R. C. Mason 9-12-77

AMP INCORPORATED Harrisburg, Pa.

LOC B | A | NO 114-1018 | REV 0

SHEET 1 OF 4

NAME CONTACT, RECEPTACLE, RELAY, APPLICATION OF

3.2. Carrier Cutoff Tab and Burr

A. Cutoff Tab

Cutoff tab shall not exceed .010.

B. Burr

Burr on cutoff shall not exceed .003.

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. Wire Barrel Flash

Wire barrel flash shall not exceed .005.

C. 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.

D. Bellmouth

(1) Rear bellmouth length shall be .020-.030.

(2) Front bellmouth length shall be .020 maximum.

E. Conductor Location

(1) End of the wire shall be flush with the front end of the wire barrel or extend .050 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.

3.6. Alignment

A. Straightness

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

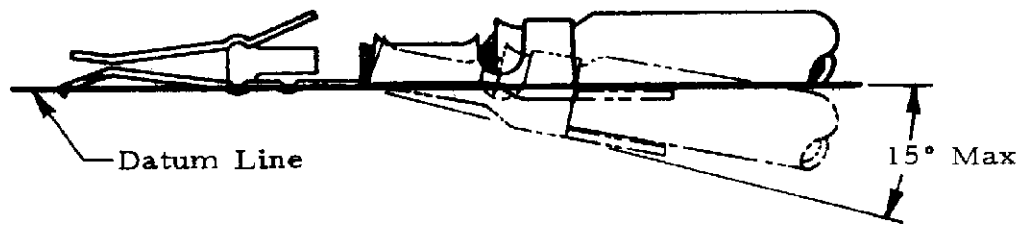

Figure 2

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

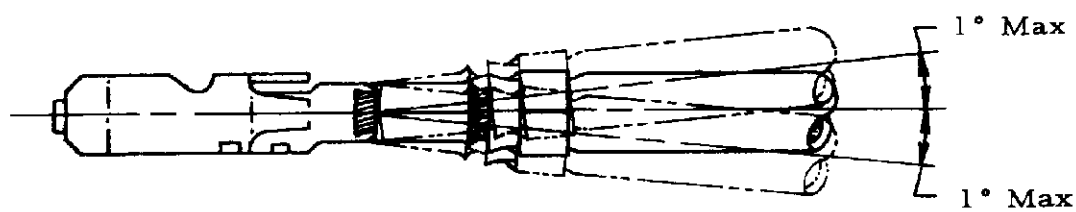

Figure 3

B. Twist or Roll

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

Part No	Wire		Insulation Diameter	Strip Length	Wire Barrel Crimp			Insulation Barrel Crimp	
	Qty	Size			Width	Height ±.002	Type Crimper	Width	Type Crimper
350057 350207 (a)	1	20	.075-.132	.187	.090	.051	F	.120	O
	1	18				.056			
	1	16				.063			
	1	14				.074			
	2	20	.080 max			.059			
350059 350208 (a)	1	24	.050-.088	.155	.070	.041	F	.090	O
	1	22				.044			
	1	20				.047			
	1	18				.052			

(a) With tab

Figure 4

Automatic Machine Wire Crimp Dimensions

Part No	Wire		Insulation Diameter	Strip Length	Wire Barrel Crimp			Insulation Barrel Crimp		Hand Tool Part No
	Qty	Size			Width	Height	Type Crimper	Width	Type Crimper	
350067 350348 (a)	1	20	.075-.132	.187	.090	.047	F	.120	O	90270-1
	1	18								
	1	16				.059				
	1	14								
350068 350349 (a)	1	24	.088-.050	.155	.070	.039	F	.110	O	90271-1
	1	22								
	1	20				.046				
	1	18								

(a) With tab

Figure 5

Hand Tool Wire Crimp Dimensions