

APPLICATION SPECIFICATION

1. SCOPE

1.1. Content

This specification covers the requirements for application of the AMP* 250 special blade receptacle terminal. These requirements are applicable to automatic machine crimping tools. For specific wire and insulation ranges relative to the products covered in this specification see Figure 4.

1.2. Reference Specification

For applicable performance requirements see AMP Specification 108-1055.

2. NOMENCLATURE

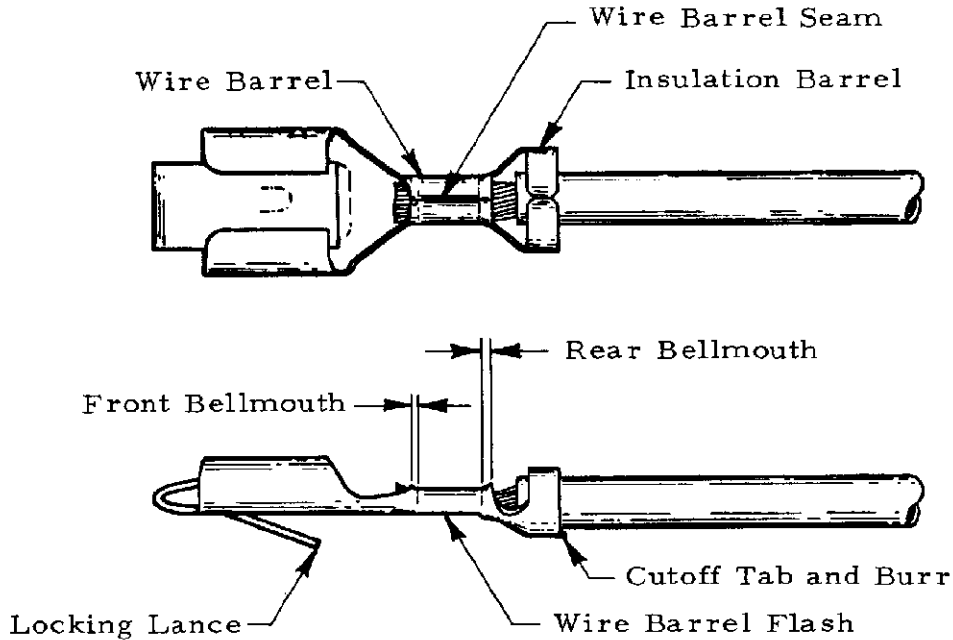


Figure 1

3. CRIMP AND DIMENSIONAL REQUIREMENTS

3.1. Wire Preparation

A. Strip Length

Insulation shall be stripped as indicated in Figure 4.

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				SHEET 1 OF 4		NAME TERMINAL, RECEPTACLE, BLADE, 250 SPECIAL, APPLICATION OF			
DIST 01	LTR	REVISION RECORD	APP	DATE					

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. Carrier Cutoff Tab and Burr

A. Cutoff Tab

Cutoff tab shall not exceed .015.

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. 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 .015 - .025.

(2) Front bellmouth length shall not exceed .020.

E. Conductor Location

(1) End of the wire shall be flush with the front end of the wire barrel or extend .030 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 Figure 4.

B. Workmanship

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

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3.5. Locking Lance

Locking lance shall not be deformed.

3.6. 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 2.

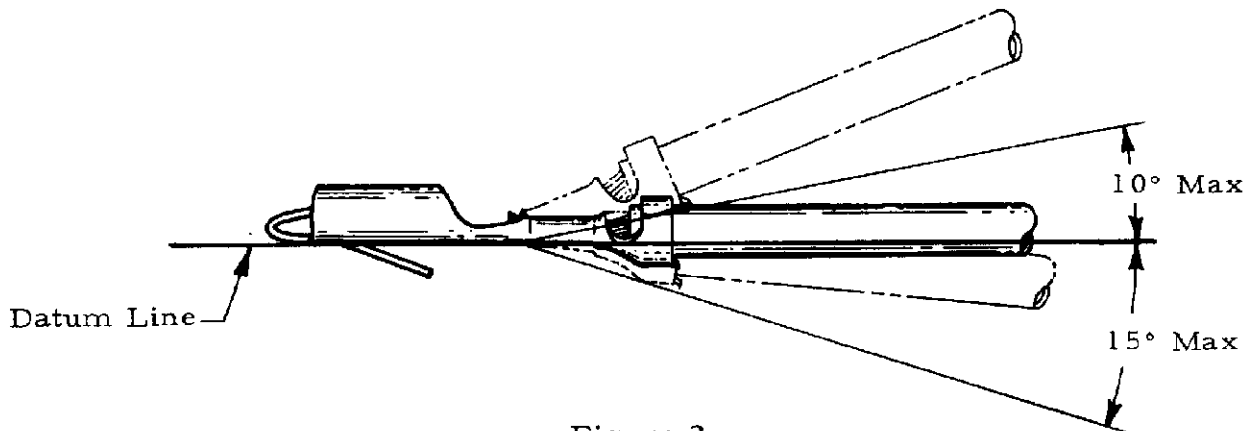


Figure 2

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

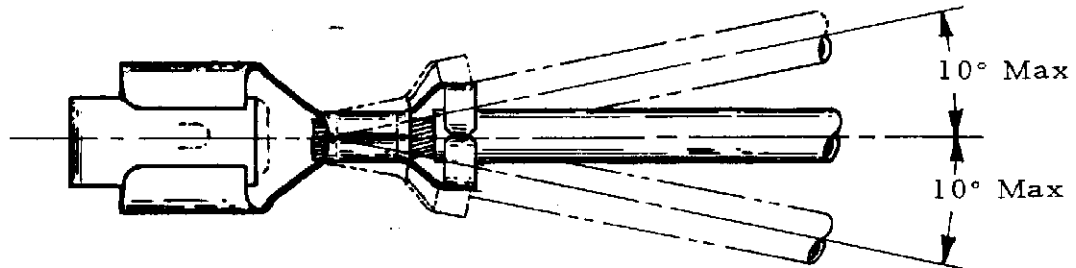


Figure 3

B. Twist or Roll

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

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Part No	Wire		Insulation Diameter, maximum	Strip Length	Wire Barrel Crimp			Insulation Barrel Crimp	
	Qty	Size			Width	Height ± .002	Type	Width	Type
640417 641257	1	18	.154	.187 - .219	.110	.063	F	.220	F
		16							
		14							
640418 (a)	1	18	.154	.187 - .219	.110	.063	F	.220	F
		16							
		14							
640841	1	20	.145	.187 - .219	.090	.060	F	.180	F
		18							
		16							
640842 (a)	1	20	.145	.187 - .219	.090	.060	F	.180	F
		18							
		16							

(a) Without nibs.

Figure 4

Automatic Machine Wire Crimp Dimensions