

**Micro-MaTch Miniature Connector System.**

**1. SCOPE.**

This specification covers the requirements for the application of AMP Micro-MaTch Male-on-Wire connectors (p/n 215083-series) and Paddle Board connectors (p/n 215570-series) to the appropriate ribbon cable.

**2. REQUIREMENTS.**

**2.1 Ribbon Cable Specifications.**

The AMP Micro-MaTch Miniature Connector System is designed for the application of ribbon cable with the following dimensions and properties:

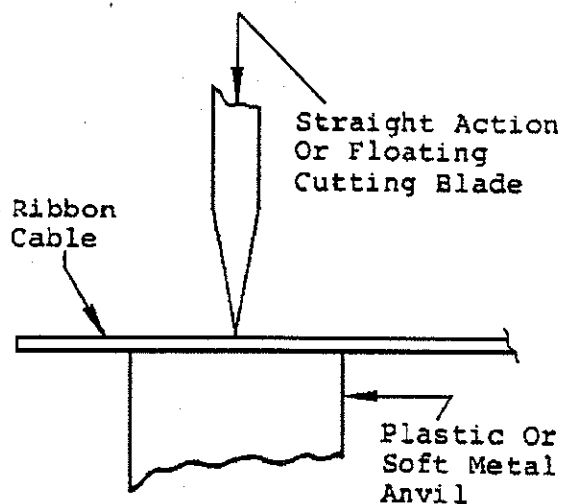
- cable style : AWG 28, UL style 2651
- conductor spacing : 1,27 mm (.050")
- conductor diameter : solid 0,30 mm
- : stranded 7 x 0,12 - 0,13 mm
- insulation material : semi-rigid PVC
- insulation diameter : 0,9 mm ± 0,1 mm

In principle ribbon cable must be approved by AMP prior to application.  
Please consult AMP for further information.

**2.2 Ribbon Cable Preparation.**

The fully automated "Micro-MaTor" also takes care of the cable preparation.

For all other application tools the ribbon cable must be cut to length using proper cutting tooling, preferably constructed as indicated in figure 1, to prevent spacing deformation and burrs.



**Figure 1**

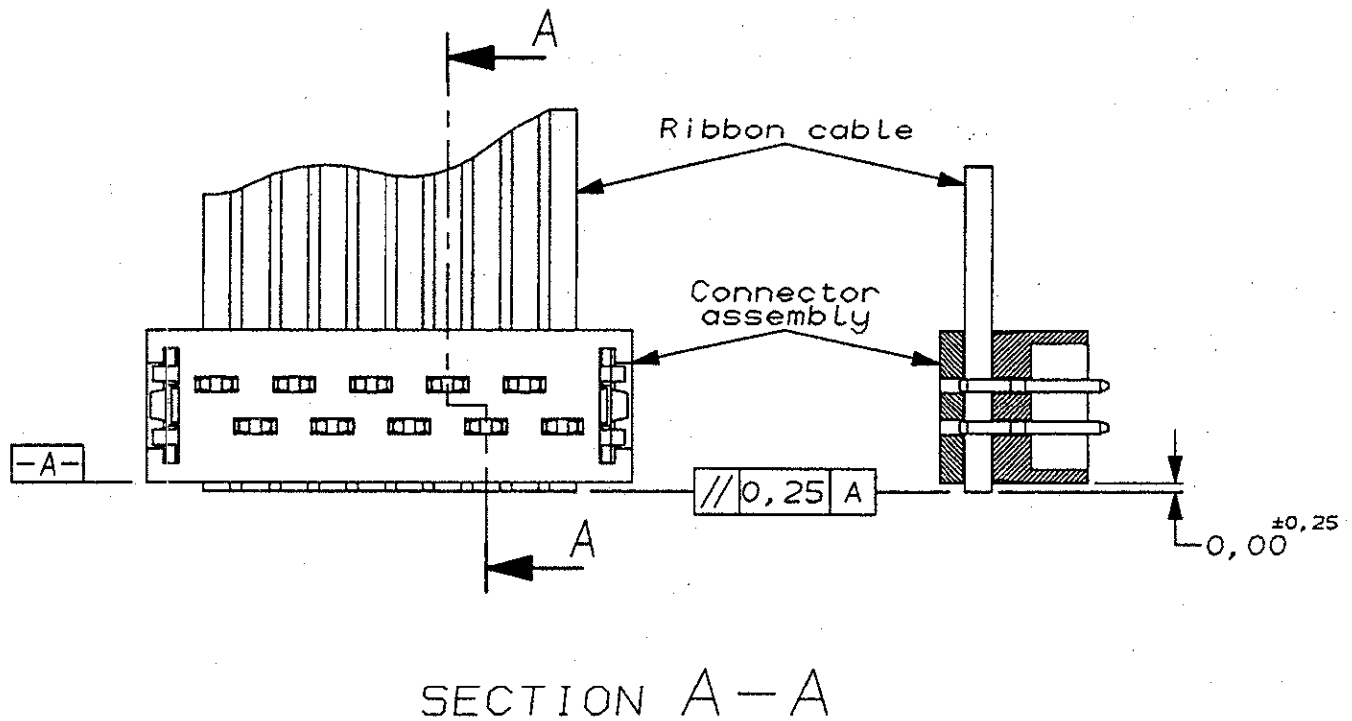
DR. H. SPELDE	DATE 26 NOV. 2001	APVD	DATE 26/11/2001
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**2.3 Inspection Criteria.**

The "Micro-MaTor" automatically checks each applied connector on continuity and shorts. With the other application tools an inspection device is not available, hence, if required, continuity and shorts must be checked separately

For visual examination of the connector/cable combination the following criteria do apply:

- Ribbon cable location.  
For a connector applied to the end of a ribbon cable, the end face of the cable may lay in the connector with a maximum of 0,25 mm (See figure 2).
- The cover shall be securely applied to the connector housing: both end latches of the cover shall be snapped properly over the corresponding locking protrusions on the housing.
- The height of the connector/cable assembly is not a proper criterium to judge the quality of the termination. Due to the miniature dimensions of the connector, the tolerances and the properties of the cable insulation may affect this height.  
To ensure the quality of the termination, the AMP application tooling is designed to have a closing height between upper and lower tooling part of 4,95 – 5,10 millimeters



**Figure 2**